

OPERATING INSTRUCTIONS

37° FLARING & DOUBLE FLARING OPERATING INSTRUCTIONS



WARNING! Wear safety goggles when using this tool!

PRE-OPERATION SET-UP

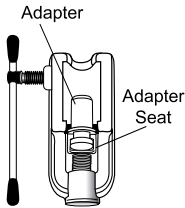
- Open the relief valve to fully recess the piston, then close tightly.
- Rotate the yoke fully counter-clockwise to bottom out the adapter seat.

DOUBLE FLARING INSTRUCTIONS

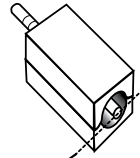


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- 1) Rotate the yoke fully counter-clockwise. Place the adapter onto the adapter seat on the end of the piston.

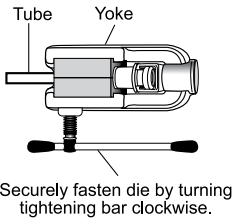


- 2) Insert the tube between the dies so it is even with the edge as shown.

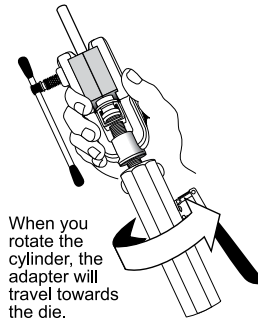


Tube should be even with die as shown.

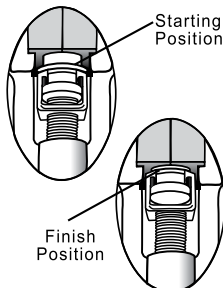
- 3) Insert dies and tubing into the yoke using the stabilizing lever. Make sure die and tube are level prior to tightening. (**important to securely fasten before moving on to step #4**)



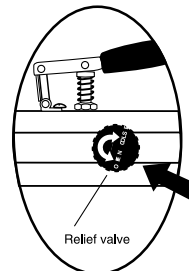
- 4) Grasp the yoke and rotate the hydraulic cylinder clockwise until it stops. (The adapter should engage the die.)



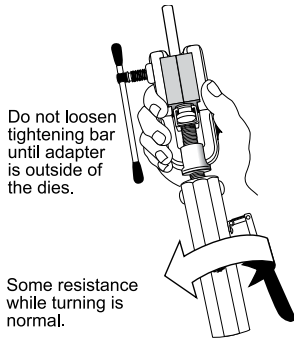
- 5) Begin squeezing the lever and continue until the edge of the adapter meets the die or pumping action shows substantial resistance.



- 6) Release the pressure by opening the relief valve.

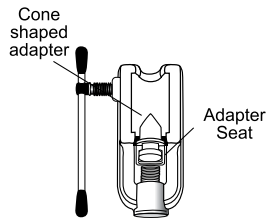


7) Grasp the yoke and rotate the tool counter-clockwise to remove the adapter from the die.



8) Remove the male adapter and insert the cone shaped adapter onto the adapter seat. Follow steps 4 - 7.

*** Follow Steps 1 - 7 with CONE ONLY for SINGLE FLARE**



9) Loosen the tightening bar and remove the tube. It should look something like the sketch below.



TROUBLESHOOTING

The piston does not seem to advance when the level is pushed.

- Close the relief valve.
- The hydraulic fluid is too cold. Close the relief valve and pump the lever several times to warm the oil.

The push connect flare does not seem to be formed correctly.

- After the tubing is positioned in the tool the yoke must be rotated into the die before one begins to squeeze the lever.
- The tightening bar must be very tight.

The tubing is stuck inside the adapter.

- After flaring, you must rotate the yoke counter-clockwise to pull the adapter out of the tubing. This must be done prior to releasing the tightening bar and attempting to remove the tubing.

37° DOUBLE FLARING ADAPTER DIE SETS

Part #	Description	Part #	Description
71202	Hydra-Flare Pump Assembly	72480-PB	Plastic Box for 72480
71098-01	37° Cone		
71098-03	3/16" Double Flare Adapter	71098-13	3/16" Double Flare Die Set
71097-04	1/4" Double Flare Adapter	71098-14	1/4" Double Flare Die Set
71097-05	5/16" Double Flare Adapter	71098-15	5/16" Double Flare Die Set
71097-06	3/8" Double Flare Adapter	71098-16	3/8" Double Flare Die Set
71097-08	1/2" Double Flare Adapter	71098-18	1/2" Double Flare Die Set