

# DOUBLE FLARE TOOL

This tool is designed to double flare thin wall steel tubing, aluminum and .040 wall soft copper

1. End of tubing must be cut square. (Use Performance Tool part number W700C or W702C.)
2. Deburr inside of tubing, and chamfer outside.
3. Place tubing in correct hole with proper length exposed on beveled side of flaring bar as shown in Figure 1.
4. Tighten flaring bar firmly starting with nut closest to tubing. Make certain tubing will not slip.
5. Fit adaptor stem into tubing (Fig. 2). This may be difficult if not properly deburred.
6. Place anvil over adaptor and turn down until adaptor contacts flaring bar. (Fig. 3).
7. Remove adaptor. End of tubing should be bell shaped (Fig. 4).
8. Place anvil over bar and turn anvil down until tubing folds in on itself (Fig. 5).
9. Remove tool and tubing should look like Figure 6.

