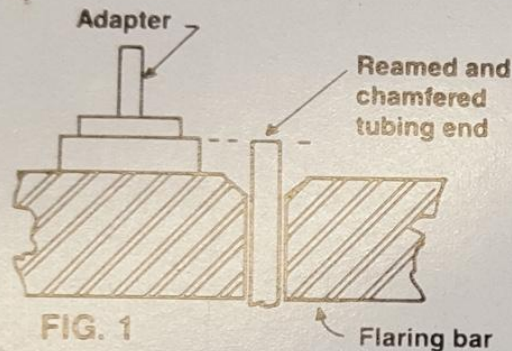


DOUBLE FLARING TOOL KIT

For use with 3/16", 1/4", 5/16", 3/8", 1/2" steel
aluminum and copper tubing



PREPARE TUBING:

1. Cut tubing off square with tubing cutter.
2. Deburr tubing with reamer or reamer blade of tubing cutter.
3. Chamfer the outer edge of the tubing with file or grinding wheel. (SEE FIGURE 1.) These steps are extremely important for correct flare forming.

DOUBLE FLARING

1. Slip prepared tubing through correct size hole in flaring bar. Tubing should extend beyond the surface of the flaring bar to the distance determined by the step on the proper size adapter laid flat surface down on the flaring bar. (SEE FIGURE 1.)
2. With tubing extending the correct distance through the flaring bar, tighten the wing nuts firmly. Tighten the wing nut nearest the tubing first, followed by the second wing nut. Insert stem of correct size adapter into tubing.
3. Place yoke assembly over flaring bar and adapter so that swivel head meets depression in the face of the adapter. Use T-handle of yoke assembly to force swivel head down until adapter rests flat on flaring bar. (SEE FIGURE 2.) The tubing end should now be formed into a bell shape.
4. Back off swivel head, remove adapter and retighten swivel head so that bell shape of tubing is folded in on itself. (SEE FIGURE 3.) This completes a double flare.

