

# INSTRUCTIONS FOR 537-F AND 637-F 37° ROL-AIR™ FLARING TOOLS

- Flares and burnishes soft steel, copper, aluminum and fully annealed stainless steel tubing.
- Roller action reduces effort required.
- Maintains original wall thickness.
- Heat treated dies clamp tubing without marking it.

537-F flares 3/4", 7/8", 1" and 1-1/4" O.D. tubing.  
637-F flares 1-1/4", 1-1/2" and 2" O.D. tubing.

Before beginning, be sure that tubing is cut off squarely and all cut-off burrs are removed.

1. Clamp yoke in vise by means of vise grip on side as shown in Fig. 1.
2. Loosen clamping stem on die holder by turning hexagon head counter-clockwise and swing clamp to right angle position with sliding segments in die holder. This will permit their separation.



Fig. 1

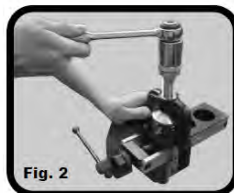


Fig. 2



Fig. 3

Flares rolled out above die bar.

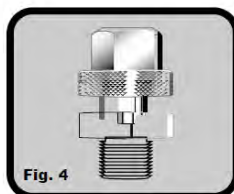


Fig. 4

Feed release and burnishing mechanism.

3. Insert tubing between segments of die block that corresponds to size of tubing to be flared. Tubing should be placed so that it is approximately 3/8" above top of die block. NOTE: 537-F is supplied with a height gauge on side of yoke.

4. Bring clamping stem into position against end segment and tighten firmly with a wrench. When clamping tubing, it is recommended that end of die holder be slipped into yoke to provide support while tightening. (See Fig. 1)

5. Slide die holder in yoke so that flaring cone centers over tubing. Turn feed screw clockwise until flaring cone contacts tubing. Then turn feed screw down 4 to 7 revolutions, depending on size of tubing. (Fig. 2) This completes an accurate 37° flare. (Fig. 3) The three rollers in the cone reduce the amount of torque required. Never turn down to point where cone compresses tubing against edge of hole as damage to flare will result.

6. After flaring, lift driving head as far as it will go, at the same time turning counter-clockwise with wrench until pin rests on top of feed screw cam. (Fig. 4) The tool will then burnish the flare for one complete revolution, at which point the pin will drop into original position allowing feed screw to be backed off sufficiently to remove bar.

**\* IMPORTANT: Lubricate feed screw and cone surface frequently.**

## Replacement Parts for 537-F

S7923401	Die Holder Assembly Complete
S61956	Knob Assembly
S61952	Rollers
S61959	Screw
S61950	Stem
S61948	Yoke Assembly
S67947	Drive Nut Retaining Spring
S61953	Flaring Cone Roller Retaining Cap
S61951	Sleeve

## Replacement Parts for 637-F

S7926801	Die Holder Assembly Complete
S64227	Rollers
S64219	Yoke Assembly Complete
S64221	Stem

**⚠ WARNING - Always wear approved eye protection.**



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