

INSTRUCTIONS FOR USE 395-FAM 45° METRIC BAR-TYPE FLARING TOOL WITH SLIP-ON YOKE

This flaring tool is for soft copper, aluminum and brass tubing.

1. Before flaring, be sure that the tubing is cut off squarely (this can be done using an Imperial Tube Cutter), and remove the cut-off burrs.
2. Slip the flare nut onto the tubing.
3. Loosen the wing nuts which will permit the separation of the two halves of the bar.
4. Insert the tubing into the die of the corresponding size so that it is slightly above the top of the die. Two of the dies in the bar are chamfered on the opposite side from the chamfer in the other dies. This has been done to permit attachment of the yoke without interference by the wing nuts. Position the bar so that the chamfered side of the dies faces the flaring cone. (See Fig. 1.)
5. Tighten the wing nuts. It is a good practice to tighten the wing nut nearest to the tube first. The wings on the nuts are of a special shape that permits using the rod of the yoke as a lever in tightening. Nuts must be securely tightened so there is no chance of the tube slipping.
6. Place the yoke over the bar of the tool so that the cone is over the tubing. Note that the yoke of this tool is the Imperial slip-on type which can be slipped directly over the bar without twisting or turning. (See Fig. 1.) The inside edges of the yoke are slotted so that once in position, a slight turn clockwise holds it in place. The yoke should be held in position by the thumb and the forefinger. (See Fig. 2.)
7. Turn the feed screw down firmly. The result will be an accurate 45° flare.

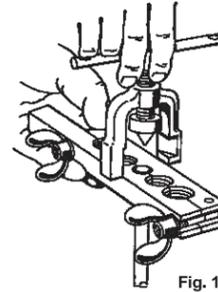


Fig. 1

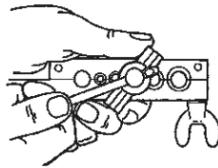


Fig. 2

NOTE: Oil the feed screw and all moving parts occasionally.



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