

## INSTRUCTIONS FOR USING IMPERIAL EASTMAN® No. 275-FSC FLARING AND SWAGING TOOL

PAT. No. 2,553,813

With this tool it is a simple matter either to flare or to swage soft copper, brass or aluminum tubing.

### FOR FLARING

Tool is used for flaring with the flaring cone attached to the yoke screw (see Fig. 2). Operation is the same as the conventional Imperial Flaring Tool. Before flaring, be sure that the tubing is cut off squarely (this can be done easily with an Imperial Tube Cutter) and be sure to remove all burrs or the turned down edge of metal resulting from cutting the tubing. Insert tubing into die of above top of the die. Tighten wing nut nearest to tube first then tighten the other one. The wings on nuts are of a specific 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.

Note that the yoke of this tool is of the new Imperial Slip-on Type which can be slipped directly over the bar (see Fig. 2). The inside edges of the yoke are slotted so that once in position, a slight turn clockwise holds it in place. Yoke should be held in place by the thumb and forefinger as shown in Fig. 3.

Do not use tool on hard tubing of any type. For soft copper, brass and aluminum only.

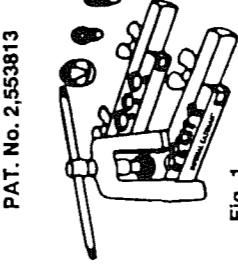


Fig. 1

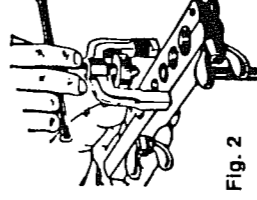


Fig. 2

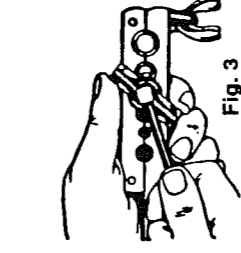


Fig. 3

### FOR SWAGING

1. Place tubing in tool same as in conventional flaring tool except allow tubing to protrude above the face of the tool approximately  $1/8$ " more than the diameter of the tube you are swaging (i.e., on  $1/2$ " O.D. tubing, tubing should protrude  $5/8$ " above face of bar.)
2. Select the proper size swaging spreader and screw it on to the yoke screw. Place a drop of oil on the spreader. NOTE that the small spreader (see A, Fig. 1) takes care of 3 sizes,  $3/16$ ",  $1/4$ " and  $3/8$ " O.D. tubing. There is a separate spreader for every other size.
3. Slip the yoke over the bar and turn in a clockwise direction so that it hooks on the bar.
4. Screw the spreader into the tube until it gets to the point where the chamfer on the upper shoulder on the spreader is bearing on the tube.
5. Hold the yoke so it will not twist off the bar and unscrew the spreader from the tube. The result will be a clean, accurate swage. IMPORTANT-Lubricate the feed screw, adapter bearing and outside of swaging adapter regularly to prolong tool life, reduce operation effort and assure reliable results.

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Imperial