

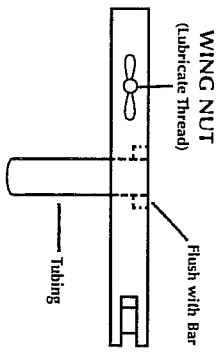
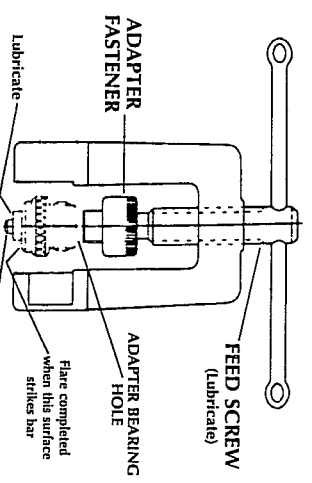
# INSTRUCTIONS FOR IMPERIAL® NO.293F METRIC FLARING TOOL FOR AUTOMOTIVE BRAKE SYSTEMS (REF. SAE 1258 ISO 4038-1977)

1. Place tubing in the proper opening, then position the top of tubing even with top surface of flaring bar, tighten wing nuts to prevent slippage.
2. Select a flaring adapter corresponding in size to the tube diameter being flared and attach it to the adapter fastener located on the yoke feed screw, turning clockwise.
3. Engage the slip on yoke on the flaring bar, twisting the yoke clockwise approximately a quarter turn for full engagement.
4. Position yoke so the pilot of the flaring adapter is centrally located over the tube opening. Advance yoke screw clockwise until the pilot or adapter enters the tube and a resistance is felt. Check again for alignment making adjustments if needed.
5. Advance yoke clamp screw clockwise until the adapter strikes the flaring bar surface. The bubble flare is completed. The flare diameter can be made smaller or larger by varying the tube position in the flaring bar.

**IMPORTANT:** This tool is designed for use with soft double wall steel tubing having a wall thickness no greater than .028". Use with a heavier wall tubing will cause tube slippage and will result in damaging the components.

**NOTE:** Tubing must be cut squarely and deburred for satisfactory results.

**LUBRICATION:** Always lubricate the yoke feed screw threads, the adapter face and the bearing hole in back of the adapter before use. Occasionally oiling the flaring bar wing nut threads will reduce the force needed to tighten bar.



**YOKE ASSEMBLY**  
08771001

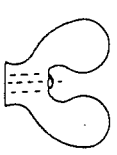
**BAR ASSEMBLY**  
08770901

**REPLACEMENT ADAPTER**



08771801 08771301 08771601 08771701  
4.75MM 10MM 8MM 6MM

**WING NUT**



08694401



6300 W. Howard Street, Niles, IL 60714  
Phone: (847) 581-3300 or (888) IMP-TOOL  
Fax: (847) 583-9033