

# Instructions for No. 447F 37° Heavy Duty Flaring Tool

Imperial No. 447-F Heavy Duty Flaring Tool makes precision 37° flares which conform to J.I.C. Standards. Flares soft steel, copper, aluminum or fully annealed stainless steel tubing.

Before flaring, be sure that tubing is cut off squarely (this can be done easily with an Imperial Tube Cutter). Stainless steel and carbon steel tubing should never be cut with a tubing cutter, because of work hardening the end of tube. This causes flares to crack. Imperial 384-FA sawing vise should be used. Remove the cut-off burr.

1. Loosen clamping lever and swing clamp into right angle position to sliding segments in die holder. This will permit their separation. (See Fig. 1)
2. (Fig. 2) Insert tubing between segments of die block that correspond to size of tubing to be flared. Allow tubing to protrude approximately 1/8" above die blocks before clamping.
3. Bring clamp into position against end segment and tighten clamping lever firmly. (Fig. 3)
4. Slide yoke over end of die holder into position over tubing to be flared. Note that yoke slides directly over holder without twisting or turning.
5. Turn the compressor screw down firmly and continue until a slight resistance is felt. This indicates an accurate 37° flare has been completed. (See Fig. 4)

**IMPORTANT:** To maintain maximum strength in the flares, do not force spreader cone beyond this point. Occasionally oil screw and cone surface with MOLYKOTE lubricant or equivalent.

Patent Nos. 2,072,359; 2,505,665; 2,505,666; 2,534,510, PAT. IN CANADA 1951 OTHER PATENTS PENDING  
Made and Printed in U.S.A.

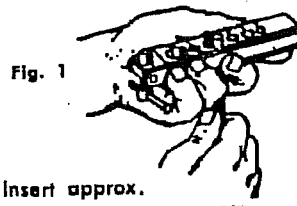


Fig. 1  
Insert approx.  
1/8" above bar.  
Fig. 2

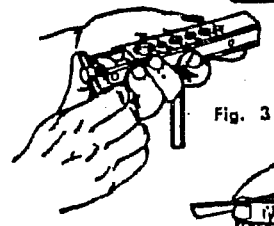


Fig. 3

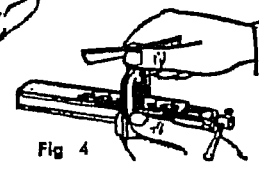


Fig. 4

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