

INSTRUCTIONS FOR USING IMPERIAL® Nos. 537-F AND 637-F 37° ROL-AIR FLARING TOOLS

Patent Nos. 2,505,665; 2,505,666; 5,534,510; 2,707,511. Pat. Can. 1951, 1956. Other Patents Pending.

Imperial Nos. 537-F and 637-F Rol-Air Flaring Tools make precision 37° flares quickly and easily on soft steel, copper, aluminum, and fully annealed stainless steel tubing. Flares conform to standards set by the Joint Industry Conference on Hydraulic Standards.. (J.I.C.).

Before flaring, be sure that tubing is cut off squarely (this can be done easily with an Imperial Tube Cutter or using an Imperial Sawing Vise) and remove the cutoff burr.

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.
3. Insert tubing between segments of die block that correspond to size of tubing to be flared. Tubing should be placed so that it is approximately 3/8" above top of block. NOTE: No. 537-F is supplied with 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. This completes an accurate 37° flare. (Fig. 2.) 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. 3.) 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.

Fig. 1



Fig. 2



Extra Parts

No. 61960 Die Holder Assembly for 537-F
No. 61948 Yoke Assembly for 537-F

Fig. 3

Feed Release
and Burnishing
Mechanism

