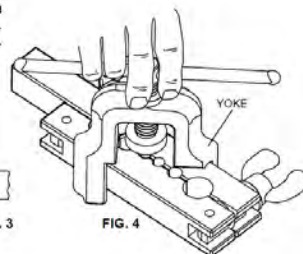
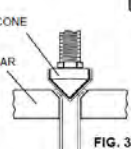
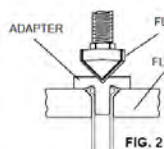
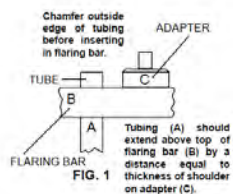


INSTRUCTIONS FOR *IMPERIAL*[®] No. 195-FB 45° DOUBLE-FLARING TOOL KIT

For 1/4", 5/16", 3/8", 1/2", 5/8" and 3/4" O.D. tubing.

- For soft tubing only - copper, aluminum, brass and steel (wall thickness to .035").
- Makes single or double flares.
- Small, lightweight, easy to handle.

1. Before flaring, be sure that the tubing is cut off squarely, and cut-off burrs are completely removed.
2. Slip the flare nut onto the tubing. (Not supplied with kit.)
3. Loosen the wing nuts, which will permit the separation of the two halves of the bar.
4. Insert the tubing into the bar hole of the corresponding size, allowing tubing to protrude by a distance equal to the width of shoulder on adapter of corresponding size. See Fig. 1. On steel tubing that is harder than average, it may be necessary to reduce slightly the distance which tube protrudes. Experience in using the tool will indicate when this is necessary. (A set of 6 adapters, one each for 1/4", 5/16", 3/8", 1/2", 5/8" and 3/4" O.D. tubing, is a part of the tool).
5. Tighten wing nuts. It is a good practice to tighten the wing nut nearest to the tube first and then tighten the other one. The wings on 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 tube slipping.



6. Place yoke over bar of tool. Now place adapter of proper size on the protruding end of tubing, with pilot or stem of adapter inserted into tubing. It is advisable to put a little oil on the lower face and stem of adapter.
7. Move yoke into position so that flaring cone centers directly over the adapter, and screw cone down until cone and adapter engage. At this point make sure that the adapter is centered in the tubing, and then continue screwing cone down until shoulder of adapter rests on flaring bar. This performs a beelling operation on the tubing as shown in Fig. 2.
8. Now back off flaring cone slightly, remove adapter and then screw cone down again tightly, this time directly onto the tubing. This folds the tubing back on itself, as shown in Fig. 3, forming an accurate 45° double-flare. Fig. 4 shows a view of tool in operation.

NOTE: Occasionally oil yoke screw and oil swivel cone through hole in side.

PARTS LIST

S68012	Adapter - 1/4"
S68013	Adapter - 5/16"
S68014	Adapter - 3/8"
S68015	Adapter - 1/2"
S68016	Adapter - 5/8"
S68017	Adapter - 3/4"
S64253	Bar Assembly
S32640	Compressor Cone
S28357	Open End Stud
S28358	Pin
S8740901	Wing Nut (2 Required)
S64250	Yoke Assembly



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WARNING - Always wear approved eye protection.

Made in USA with US and globally sourced components. Products are designed, engineered and quality tested in the USA.

P0000016 Rev B