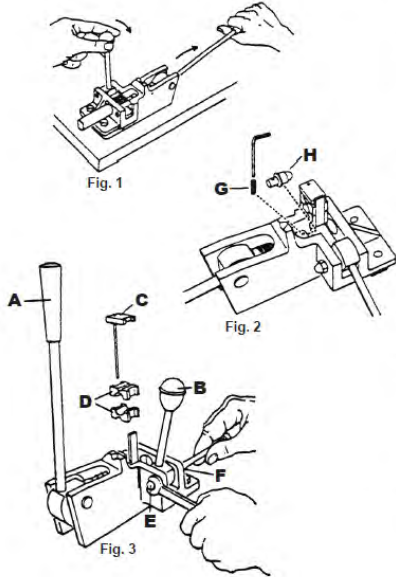


## INSTRUCTIONS FOR IMPERIAL® 555-FS PRODUCTION FLARING AND SWAGING TOOL

This tool can be bolted to bench by means of bolt holes in base or clamped in vise

Before flaring, be sure that tubing is cut off squarely (an Imperial tube cutter is recommended for this purpose) and be sure to remove all burrs or the turned down edge of tubing resulting from cutting the tubing.



### FLARING INSTRUCTIONS

1. Swing flaring handle (A) into vertical position and release die holder cam lever (B). Swing out die holder assembly and remove die pressure plate (C). Insert set of dies (D) corresponding to tubing size to be flared with chamfer ends facing cone (Fig. 1). Replace die pressure plate and return die holder to flaring position.
2. Insert tubing into dies flush with face of dies. Swing die holder cam lever into locked position.
3. Move flaring handle to right until cone completes flaring operation and abrupt resistance is felt (Fig. 2). (Excessive force is not required in fabricating flares.) Recess in die and self-centering, hard chrome finished cone automatically form a flare with the correct S.A.E. dimensions every time.
4. Bring flaring handle and die holder cam lever back to original positions. Tubing can now be easily removed with a slight front to back motion.

NOTE: Die cam, flaring handle and cone plunger assembly should be kept well lubricated at all times.

Die cam is adjusted at factory to maintain correct tension on die blocks. If adjustment is necessary, due to wear, loosen nut (E) on cam fulcrum pin, turn screw (F) clockwise until proper tension is restored and retighten nut (Fig. 1).

### SWAGING

This tool can be adapted for swaging by substituting a swaging adapter for the flaring cone. Remove flaring cone set screw (G) and flaring cone (Fig. 3). Insert swaging adapter (H) corresponding to tubing size to be swaged, replace set screw and tighten. Order swaging adapters or additional flaring cones from your supplier.

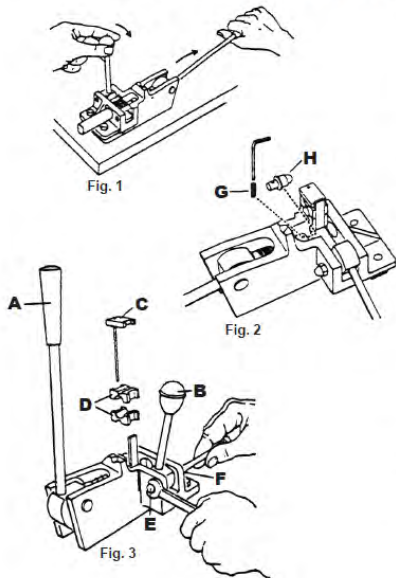
#### Flaring Cones

- No. S70348 - 45° Flaring Cone
- No. S70349 - 37° Flaring Cone

## INSTRUCTIONS FOR IMPERIAL® 555-FS PRODUCTION FLARING AND SWAGING TOOL

This tool can be bolted to bench by means of bolt holes in base or clamped in vise

Before flaring, be sure that tubing is cut off squarely (an Imperial tube cutter is recommended for this purpose) and be sure to remove all burrs or the turned down edge of tubing resulting from cutting the tubing.



### FLARING INSTRUCTIONS

1. Swing flaring handle (A) into vertical position and release die holder cam lever (B). Swing out die holder assembly and remove die pressure plate (C). Insert set of dies (D) corresponding to tubing size to be flared with chamfer ends facing cone (Fig. 1). Replace die pressure plate and return die holder to flaring position.
2. Insert tubing into dies flush with face of dies. Swing die holder cam lever into locked position.
3. Move flaring handle to right until cone completes flaring operation and abrupt resistance is felt (Fig. 2). (Excessive force is not required in fabricating flares.) Recess in die and self-centering, hard chrome finished cone automatically form a flare with the correct S.A.E. dimensions every time.
4. Bring flaring handle and die holder cam lever back to original positions. Tubing can now be easily removed with a slight front to back motion.

NOTE: Die cam, flaring handle and cone plunger assembly should be kept well lubricated at all times.

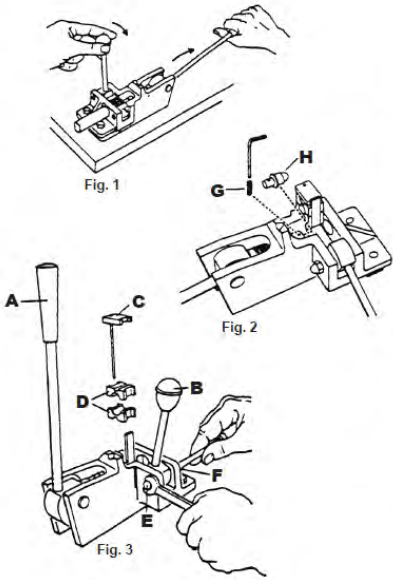
Die cam is adjusted at factory to maintain correct tension on die blocks. If adjustment is necessary, due to wear, loosen nut (E) on cam fulcrum pin, turn screw (F) clockwise until proper tension is restored and retighten nut (Fig. 1).

### SWAGING

This tool can be adapted for swaging by substituting a swaging adapter for the flaring cone. Remove flaring cone set screw (G) and flaring cone (Fig. 3). Insert swaging adapter (H) corresponding to tubing size to be swaged, replace set screw and tighten. Order swaging adapters or additional flaring cones from your supplier.

#### Flaring Cones

- No. S70348 - 45° Flaring Cone
- No. S70349 - 37° Flaring Cone



### SWAGING INSTRUCTIONS

1. Swing swaging handle (A) into vertical position and release die holder cam lever (B). Swing out die holder assembly and remove die pressure plate (C). Insert set of dies (D) corresponding to tubing size to be swaged with chamfer ends facing swaging adapter (Fig.1). Replace die pressure plate and return die holder cam lever to swaging position.
2. Remove swaging adapter set screw (G). Insert swaging adapter (H) corresponding to tubing size to be swaged. Replace set screw and tighten.
3. Insert tubing into dies and position end of tube to be in contact with swaging adapter. Swing die clamped into locked position.
4. Move swaging handle to right until adapter completes swaging operation and abrupt resistance is felt (Fig. 2). (Excessive force is not required in fabricating swages.) Recess in die and self-centering hard chrome finished adapter automatically forms a swage.
5. Bring swaging handle and die holder cam lever back to original positions. Tubing can now be easily removed with a slight front to back motion.

NOTE: Die cam, swaging cam and swaging plunger assembly should be kept well lubricated at all times.

Die cam is adjusted at factory to maintain correct tension on die blocks. If adjustment is necessary, due to wear, loosen nut (E) on cam fulcrum pin, turn screw (F) clockwise until proper tension is restored and retighten nut (Fig. 1).

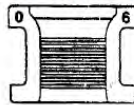
#### FLARING

This tool can be adapted for flaring by substituting a flaring cone for the swaging adapter. Follow instructions in No. 2 above and insert flaring cone in the same manner. Order flaring cones or additional swaging adapters from your supplier.

#### SWAGING ADAPTERS

No. 560-S-03 (3/16" O.D.)	No. 560-S-05 (5/16" O.D.)	No. 560-S-08 (1/2" O.D.)
No. 560-S-04 (1/4" O.D.)	No. 560-S-06 (3/8" O.D.)	No. 560-S-10 (5/8" O.D.)

Jaw sizes located on inner half of jaw are in sixteenths of an inch.

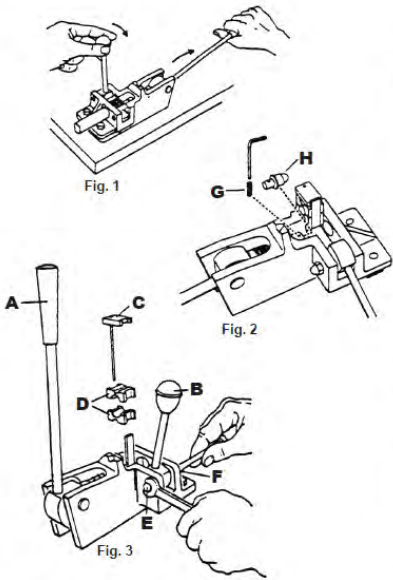


Example  
 03 = 3/16"  
 04 = 1/4"  
 05 = 5/16"  
 06 = 3/8"  
 08 = 1/2"  
 10 = 5/8"

**Imperial**  
 Dependable Under Pressure  
 30333 Emerald Valley Parkway • Glenwillow, Ohio 44139 USA  
 www.imperial-tools.com • info@stridetool.com © 2012 Stride Tool Inc.

Printed in U.S.A.

P0001006\_C



### SWAGING INSTRUCTIONS

1. Swing swaging handle (A) into vertical position and release die holder cam lever (B). Swing out die holder assembly and remove die pressure plate (C). Insert set of dies (D) corresponding to tubing size to be swaged with chamfer ends facing swaging adapter (Fig.1). Replace die pressure plate and return die holder cam lever to swaging position.
2. Remove swaging adapter set screw (G). Insert swaging adapter (H) corresponding to tubing size to be swaged. Replace set screw and tighten.
3. Insert tubing into dies and position end of tube to be in contact with swaging adapter. Swing die clamped into locked position.
4. Move swaging handle to right until adapter completes swaging operation and abrupt resistance is felt (Fig. 2). (Excessive force is not required in fabricating swages.) Recess in die and self-centering hard chrome finished adapter automatically forms a swage.
5. Bring swaging handle and die holder cam lever back to original positions. Tubing can now be easily removed with a slight front to back motion.

NOTE: Die cam, swaging cam and swaging plunger assembly should be kept well lubricated at all times.

Die cam is adjusted at factory to maintain correct tension on die blocks. If adjustment is necessary, due to wear, loosen nut (E) on cam fulcrum pin, turn screw (F) clockwise until proper tension is restored and retighten nut (Fig. 1).

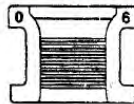
#### FLARING

This tool can be adapted for flaring by substituting a flaring cone for the swaging adapter. Follow instructions in No. 2 above and insert flaring cone in the same manner. Order flaring cones or additional swaging adapters from your supplier.

#### SWAGING ADAPTERS

No. 560-S-03 (3/16" O.D.)	No. 560-S-05 (5/16" O.D.)	No. 560-S-08 (1/2" O.D.)
No. 560-S-04 (1/4" O.D.)	No. 560-S-06 (3/8" O.D.)	No. 560-S-10 (5/8" O.D.)

Jaw sizes located on inner half of jaw are in sixteenths of an inch.



Example  
 03 = 3/16"  
 04 = 1/4"  
 05 = 5/16"  
 06 = 3/8"  
 08 = 1/2"  
 10 = 5/8"

**Imperial**  
 Dependable Under Pressure  
 30333 Emerald Valley Parkway • Glenwillow, Ohio 44139 USA  
 www.imperial-tools.com • info@stridetool.com © 2012 Stride Tool Inc.

Printed in U.S.A.

P0001006\_C