

INSTRUCTIONS FOR HI-DUTY™ FLARING TOOLS

Imperial's flaring tools make precision flares which conform to SAE standards. They flare soft copper, aluminum or brass tubing.

1. Before flaring, be sure that tubing is cut off squarely, and remove the cut-off burrs.
2. Slip the flare nut onto the tubing.
3. IT'S IMPORTANT TO OIL THREADS before each use. Also oil the cone - especially when flaring aluminum. Use a 50/50, kerosene/oil mixture for aluminum.
4. Loosen clamping screw used for locking the sliding segments in the die holder. This will permit their separation. (See Fig. 1.)
5. THESE TOOLS ARE SELF-GAUGING. The proper size flare is produced when tubing is clamped flush with the top of the die block. (See Fig. 2.) Insert tubing between the segments of the die block that correspond to the size of the tubing to be flared.
6. Advance the clamp screw against the end segment and tighten firmly. (See Fig. 3.)
7. Move the yoke down over the top of the die holder and twist it clockwise to lock it into position. Note that the yoke can be positioned directly over the top of the tube. (See Fig. 4.)
8. Turn the feed screw clockwise, until contact with tubing is made. Then turn the feed screw down until slight resistance is felt. This indicates an accurate flare has been completed. **IMPORTANT:** To maintain maximum strength in the flare, do not force spreader cone beyond this point.

NOTE: Only flare soft copper, aluminum and brass tubing with these tools. They are not to be used with steel or stainless steel tubing.

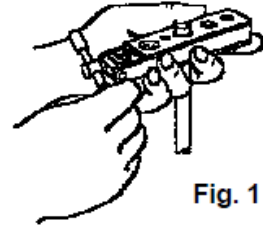


Fig. 1

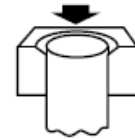


Fig. 2

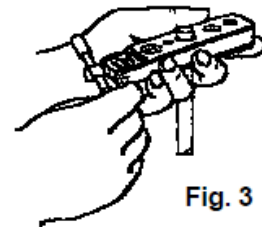


Fig. 3

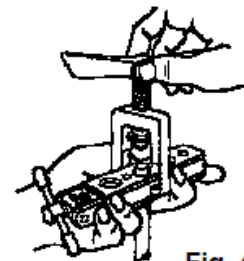


Fig. 4



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