

To produce a convex (single) flare (1)

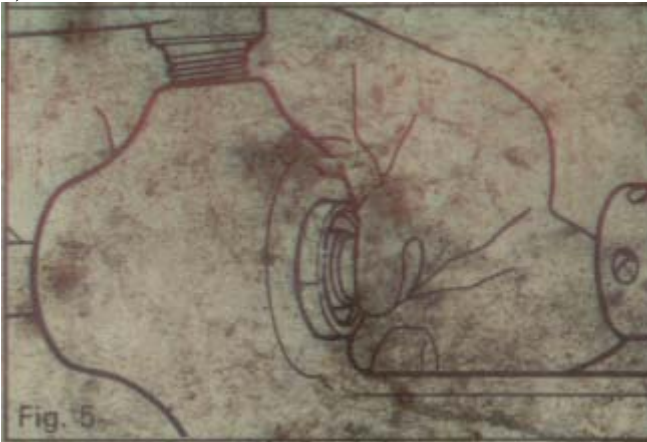
- a) Flaring tool body
- b) Forcing screw
- c) Clamping screw
- d) Punch extractor
- e) Punch holder
- f) Split die
- g) OP 1 & 2 Punches

Lubricate threads of (b) and (c) with light machine oil before use



2) Tighten tool in vice, unscrew forcing screw and clamping screw to enable the die to be placed in the body

3)



Select the required die and place in the body with the split line horizontal and the counter bore facing the forcing screw

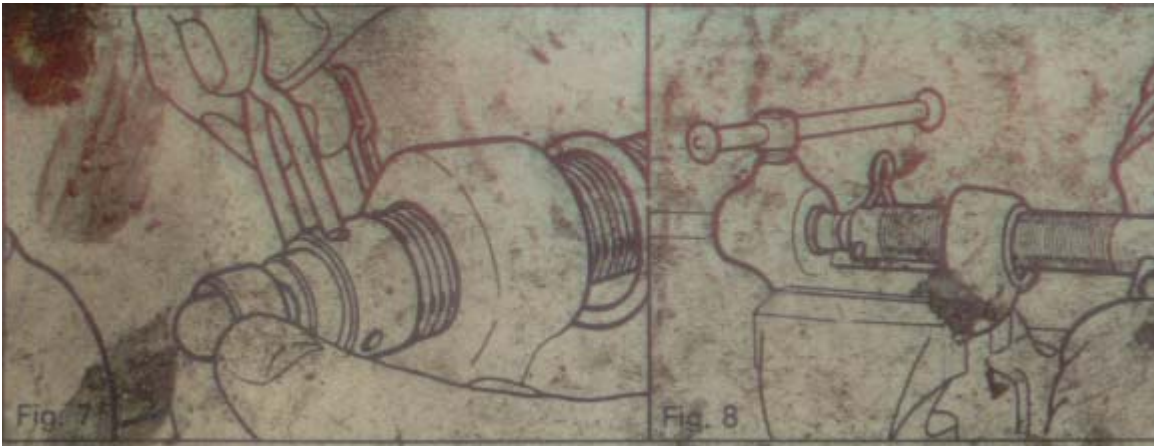


4) Insert the tube into the back of the die and push forwards until the tube protrudes beyond the face of the die

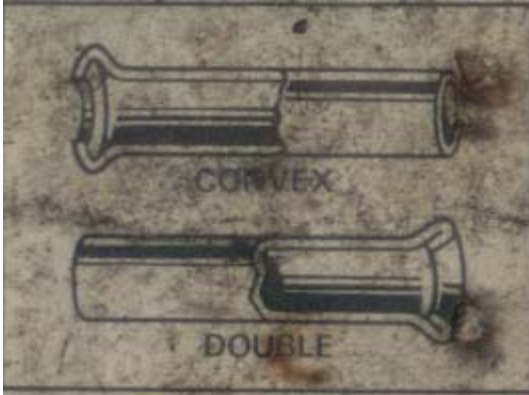
5) Push the tube and the die back until the tube is level with the face of the die and the die is located against the back stop



6) Grip the tube in the die by tightening the clamping screw **AVOID OVER-TIGHTENING**



7) Place the required OP 1 punch into the punch holder and fit the punch extractor.
Apply a little light machine oil to the pilot of the punch



8) Screw the forcing screw forward so that the pilot of the punch enters the tube.
Apply a steady hand pressure until a convex flare joint has been produced.
Unscrew the forcing screw to remove the punch

To Produce a Double Flare

9) After 1-8, place the required OP 2 punch in the punch holder
and fit the punch extractor

10) Screw the forcing screw forward so that the pilot of the punch
enters the flared end of the tube

11) Apply steady hand pressure until a double flare form
has been produced

12) Unscrew the forcing screw to remove the punch
Unscrew the clamping screw to release the die and tube

Punches are dual marked, where applicable, with Imperial / metric sizes. Punches also carry symbols to show whether they are OP 1 (convex / single flares) or OP 2 (double flares)



Important correct preparation of the tube is vital.

The end to be flared must be cut square, cleaned and de-frazed