

# 7 PIECE PIPE FLARING TOOL KIT

## 51762 - BPF/KITB OPERATING INSTRUCTIONS

**IMPORTANT:** In all circumstances, the tube must be cut squarely, which can best be achieved using a tubing cutter and all burrs must be removed.

### Instructions for Flaring:

Insert the tubing into the corresponding size on the clamping bar (see fig.3) and allow it to protrude slightly above the top on the countersunk side.

Tighten the wing nut nearest to the tube and then tighten the other one. (The wing nuts are a special shape and use the rod of the yoke as a lever when tightening).

**Note:** It is important that the wing nuts are securely tightened so that the tube will not slip.

The flaring part of the tool is the Slip-On type which means it can be slipped directly over the clamping bar (see fig.2). The flaring tool should be held in place by the thumb and forefinger as shown in fig.3 or clamped securely in a vice.

Flaring now results from the same operation as a conventional flaring tool. Turn "T" Handle (B) Fig.1. (this controls the flaring cone on the yoke screw) clockwise and continue turning until adequate flaring is accomplished.

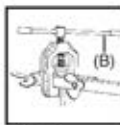


FIG. 1

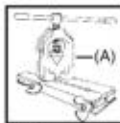


FIG. 2

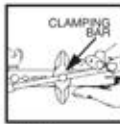


FIG. 3

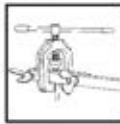


FIG. 4

### INSTRUCTIONS FOR DOUBLE FLAP FLARING:

Insert the tubing into the corresponding size on the clamping bar (see fig.3) and allow the tubing to protrude above the top of the clamp.

**NOTE:** Learn to use this tool correctly. Do several flares using scrap pipe in order to perfect your technique.

**NOTE:** the flaring dies are consumable and not covered by the guarantee. Spare dies are available from your Draper stockist.

Size Stock No.

3/16"	50810
1/4"	50812
5/16"	51880
3/8"	50813
1/2"	50814



SINGLE FLARE



DOUBLE FLARE

Tighten the wing nut nearest to the tube and then tighten the other one. (The wing nuts have a special shape top and use the rod of the yoke as a lever in tightening.)

**NOTE:** It is important that the wing nuts are securely tightened so that the tube will not slip during swaging.

Select the correct size swaging die. Insert the shaft of the die into the end of the tube. (Place a drop of clean brake fluid to act as a lubricant onto the underside of this die).

Slip the flaring tool over the bar and turn the "T" handle in a clockwise direction so that it hooks onto the bar.

Screw the die into the pipe until it reaches the point where the chamfer on the upper shoulder of the die is touching the tube.

Remove the die from the tube and reposition the yoke over the tube. Now turn the "T" handle clockwise until the spreader reaches the point required.

Hold the yoke so it will not twist off the bar. Now, unscrew the spreader from the tube.