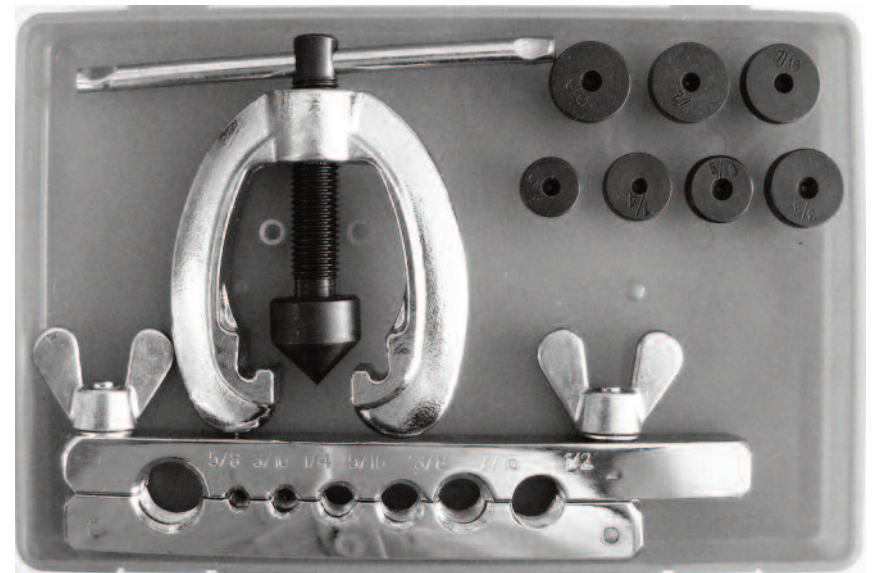


HFX654

Pipe Flaring Set

- 7 flaring sizes
- Suitable for 3/16", 1/4", 5/16", 3/8" and 1/2" O/D pipes
- Suitable for producing single or double-lap flares in copper, aluminum, soft steel, and brass tubing



OPERATING INSTRUCTIONS

- **Warning - Only to be used by a qualified mechanic** •
 - Please ensure that all pipe is cleanly cut with a dedicated pipe cutting tool (Not included) •

TOOL PARTS



FLARING CLAMP BLOCK



FLARING TOOL



COLLETS

USAGE INSTRUCTIONS

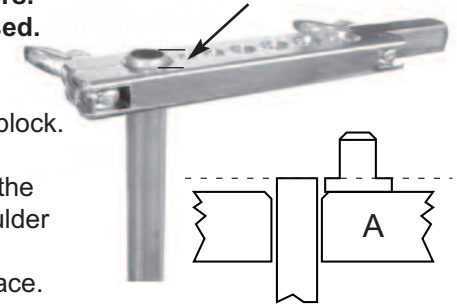
CAUTION:

Do not attempt to flare unevenly cut tube ends. Tubing to be flared must be cut square and be deburred, both inner and outer diameters. A dedicated pipe cutting tool should be used.

FITTING THE PIPE

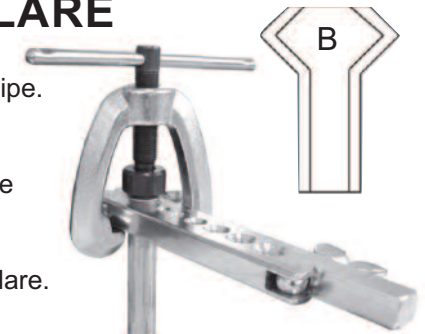
Height = Thickness of collet shoulder (Fig A)

1. Loosen the wing nuts on the flaring clamp block.
2. Insert the pipe into the correct size hole.
3. The top of the pipe should protrude above the top of the flaring block. Use the collet shoulder as a guide. see (Fig. A)
4. Tighten the wing nuts to hold the pipe in place.



SINGLE FLARE

1. Follow the above instructions for fitting the pipe.
2. Place the correct sized collet into the pipe.
3. Place the flaring tool over the flaring clamp block and position the cone into the top of the collet.
4. Gradually wind the cone downwards until stiff resistance is felt to complete the single flare. see (Fig. B).



DOUBLE FLARE

1. Follow the instructions for the single flare above, without removing the pipe from the tool.
2. Remove the collet from the pipe.
3. Wind the flaring tool cone into the pipe and slowly tighten until stiff resistance is felt to complete the double flare, see (Fig. C)

