

# INSTRUCTIONS FOR BAR-TYPE FLARING TOOLS WITH SLIP-ON YOKE

These flaring tools are for soft copper, aluminum and brass tubing.

1. Before flaring, be sure that the tubing is cut off squarely, and remove the cut-off burrs.
2. Slip the flare nut onto the tubing.
3. Loosen the wing nuts which will permit the separation of the two halves of the bar.
4. Insert the tubing into the die of the corresponding size so that it is slightly above the top of the die. Position the bar so that the chamfered side of the dies faces the flaring cone. (See Fig. 1.)
5. Tighten the wing nuts. It is a good practice to tighten the wing nut nearest to the tube first. The wings on the nuts are of a special shape that permits using the rod of the yoke as a lever in tightening. Nuts must be securely tightened so there is no chance of the tube slipping.
6. Place the yoke over the bar of the tool so that the cone is over the tubing. Note that the yoke of this tool is the Imperial slip-on type which can be slipped directly over the bar without twisting or turning. (See Fig. 1.) The inside edges of the yoke are slotted so that once in position, a slight turn clockwise holds it in place. The yoke should be held in position by the thumb and the forefinger. (See Fig. 2.)
7. Turn the feed screw down firmly. The result will be an accurate 45° flare.

NOTE: Oil the feed screw and all moving parts occasionally.

Patent Nos.: 1,724,679, 2,072,359, 2,278,932, 2,553,813, 3,027,931  
Pat. in Canada 1953 and Br. Pat. No. 921695

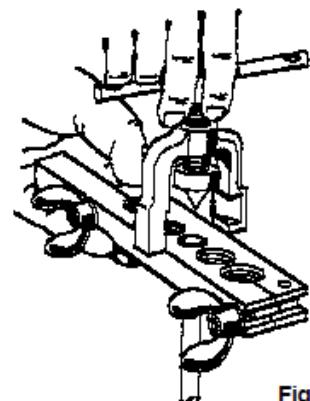


Fig. 1

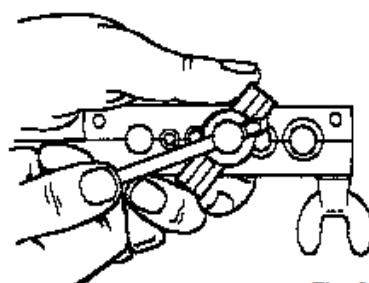


Fig. 2



30333 Emerald Valley Parkway • Glenwillow, Ohio 44139 U.S.A.  
[www.imperial-tools.com](http://www.imperial-tools.com) • [info@stridetool.com](mailto:info@stridetool.com)

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