

# INSTRUCTIONS FOR ROL-AIR™ FLARING TOOLS

Imperial's Rol-Air™ flaring tools quickly and easily both flare and burnish soft copper, brass or aluminum 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. For normal size flares, tubing should be placed so that it is approximately 5/16" above the die block. Use the bottom of the yoke leg as a height gauge. (See Fig. 2.)
  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 6 to 7 half turns, depending on size of tubing. This completes the flare. NEVER TURN THE FLARE DOWN TO THE POINT WHERE THE CONE COMPRESSES THE TUBING AGAINST THE COUNTER SINK, AS DAMAGE TO THE FLARE WILL RESULT.
  9. After flaring, simply back off the flaring cone.
- NOTE:** Only flare soft copper, aluminum and brass tubing with these tools. They are not to be used with steel or stainless steel tubing.

**Patent Nos.:** 2,505,665, 2,505,666, 2,534,510, 2,893,463  
**Pat. in Canada** 1951 and 1956

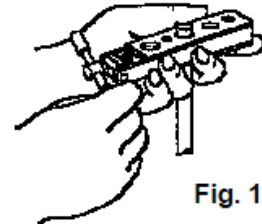


Fig. 1

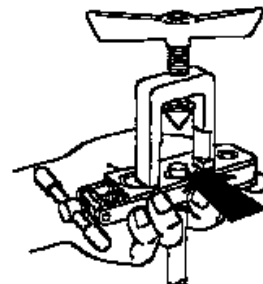


Fig. 2

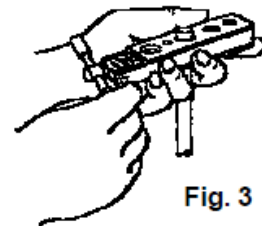


Fig. 3

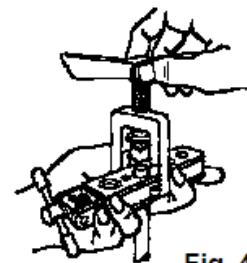


Fig. 4



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507-FB, 500-FB

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