

INSTRUCTIONS FOR DOUBLE FLARING

Prepare end of tubing carefully by making sure tubing is cut off square. Deburr inside with Reamer Blade. Chamfer the outside with either a file or grinding wheel. This preparation is essential to obtain correct forming. Insert tubing through correct size hole. Extend tubing beyond surface of Flaring Bar to proper distance as determined by placing corresponding size adapter flat surface down alongside tubing, so end of tubing is flush with step on adapter as shown on Figure 1.

Tighten Wing Nuts by $1/4$ " turns with Yoke Handle after hand tightening to ensure proper grip, starting with the Wing Nut nearest the tubing. Be sure Flaring Bar holds tubing tight enough so that it will not slip down. Insert stem on adapter into end of tubing. Place Yoke Assembly over Flaring Bar and adapter, so that Swivel enters depression in end of adapter. With Sliding T handle, turn and force Swivel down until adapter rests flat against Flaring Bar as shown in Figure 2. The end of tubing is now formed into a bell shape, which completes the forming operation.

Back off Swivel and remove adapter from tubing. Now turn Swivel down against bell shape of tubing so that metal folds in on itself as shown in Figure 3. This operation is the same as a conventional single flare.

