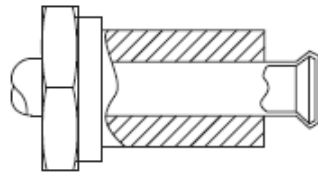
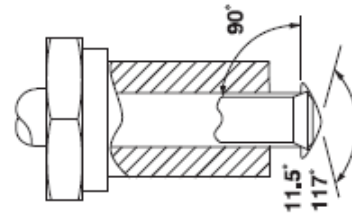


# Brake pipe flaring tool

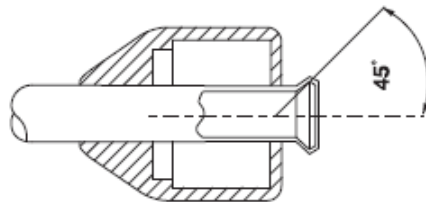
Ensure you are familiar with the various types of flares before using this equipment.



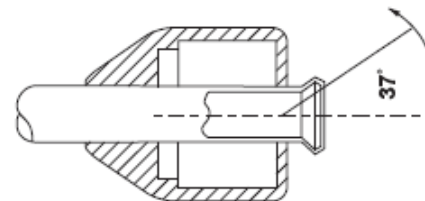
**SAE CONVEX**  
TUBE OP.1 DIE



**113° - 117° DIN CONVEX**  
TUBE OP.1 DIE



**SAE DOUBLE**  
TUBE OP.1 OP.2 DIE

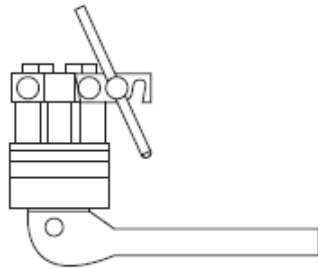


**113° - 117° DIN CONVEX**  
TUBE OP.1 OP.2 DIE

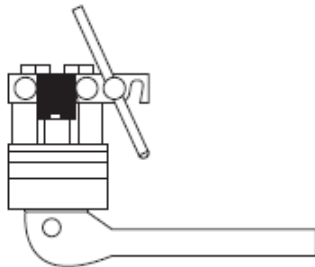
1. The end of the pipe must be cut square.
2. The outside edge of the pipe must be chamfered approx. 0,25 x 45°
3. The bore of the pipe must be de-burred.
4. If the pipe is plastic covered, this must be removed for 3mm from the end of the pipe to be flared. Ensure the pipe is not scored or any metal removed during this operation. Do not use abrasive doth. Blow any debris from the pipe after flaring.

## IMPORTANT

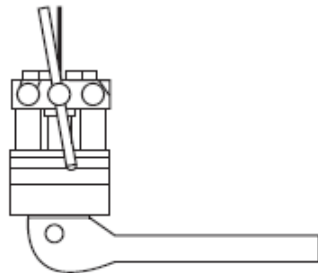
The punches and dies supplied for this tool must only be used with this equipment.



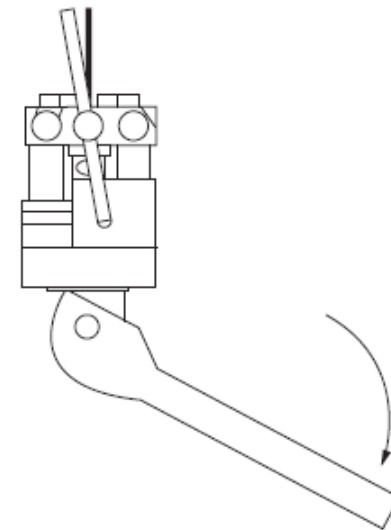
Clamp the tool in a suitable bench mounted vice. Assemble the lever into the cam as shown. Pull out pin to allow clamp bridge to open.



Rotate punch head containing the punches to correct size operation required to produce the required flare. Place the die of correct size into the cavity as shown with the split line horizontal and the counter bore towards the operating lever.



After the pipe has been prepared as instructed above, ensure the tube nut is fitted to the pipe. Pass the pipe through the rear of the die until the prepared end is flush with the front face of the die. Ensure that both halves of the die are contacting the die stops. Swing the locking bridge into position refit pin and tighten the damping screw. Check that the position of the pipe and the die are still correct



Pull the lever to engage the punch into the end of the brake pipe and continue to form the flare until a solid resistance is felt. Return the handle to the original position to withdraw the punch. If the required flare calls for a second operation in Chart 1 slide the correct Op.2 punch in line with the brake pipe. Operate the lever to complete the form of the flare.

Return the lever to the original position to withdraw the punch. Release the clamping screw and swing the clamp open and remove the dies with the pipe. If necessary a gentle tap on a suitable surface will release the dies from the pipe.

Check the quality of the flare to ensure the pipe did not move during the flaring.