

Full Range Flaring Kit



YELLOW JACKET® FULL RANGE FLARING KITS feature two bars and a special yoke which slips over the bar and locks with a turn to the right (see figures 1 and 2). This tool flares 9 sizes: 1/8" to 3/4" O.D.

INSTRUCTIONS FOR FLARING

1. Cut off the tube squarely with a YELLOW JACKET tubing cutter. Remove the burr inside the tubing without thinning the tubing wall.
2. Select the flaring bar with a flare size to match your tubing and loosen the wing nuts so the bars separate. Insert the tubing so it protrudes above the chamfered side of the bar. Tighten the wing nuts securely starting with the one further from the tubing, then the closer one.
3. Slip the yoke over the tubing so the flaring cone is centered over the tubing (see figure 1) and then turn the yoke to lock it on the bar (see figure 2).

FIG. 1

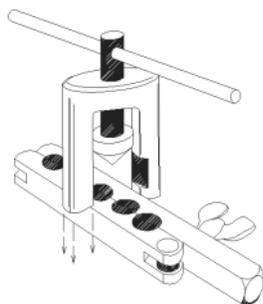
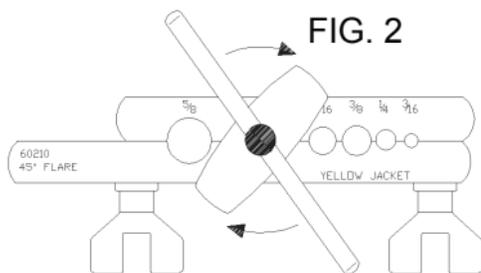


FIG. 2



4. Turn the handle until the flaring cone has come down firmly against the tubing and spread out the flare. If you tighten the handle too much, you will thin out the metal at the base of the flare. Experience can teach you how much pressure is needed.
5. Oil the yoke screw and swivel cone occasionally.

TIPS FOR TUBE CUTTING

1. Take care of your tube cutter. Make sure it is not thrown around or the cutting mechanism may get sprung. Sprung cutters will cut threads on the tubing.
2. Feed the cutter wheel slowly into the tubing for each rotation to minimize deforming the end of the tube you are cutting.
3. Before flaring, use a reamer to remove the burr from inside the tubing.
4. All YELLOW JACKET premium cutters have a spare cutter wheel inside the cutter body near the rollers.