

Instructions for 80881 & 80882 In-Line Flaring Tools

- 1) Make sure tubing is cut off square and burrs removed.
- 2) Chamfer outside of tubing with either a file or grinding wheel.
- 3) **INSERT TUBING THROUGH TWO SIDES OF CLAMPING BASE USING INCLUDED ADAPTER AS A GUIDE FOR PROPER LENGTH.**
- 4) Alternate tightening the two cap screws of the clamping base to grip the tubing. Too loose a grip will allow the tubing to push through.
- 5) **INSERT STEM OF ADAPTER INTO END OF TUBING.** (See Diagram 1) Place hex yoke over flaring adapter and hand tighten on to clamping base. (Do not use wrench to tighten) (See Diagram 2)
- 6) Thread flaring screw into Hex yoke. Screw until tight and firm which will produce the first flare. This will form a bell shape in tubing. (See Diagram 3)
- 7) Unthread screw until loose.
- 8) Unthread Hex yoke completely and remove adapter. Check for proper bell shape.
- 9) Replace Hex yoke and tighten to base.
- 10) Thread screw into hex yoke again until completely tight. This should complete the double flare.

