

3. OPERATING INSTRUCTIONS

- ❑ **WARNING!** Before using the flaring kit, ensure that you have read and understood the Safety Instructions in Section 1. Ensure you are familiar with the various types of flares before using this equipment.

3.1. Preparation of the Brake Pipe.

- 3.1.1. The end of the pipe must be cut square
- 3.1.2. The outside edge of the pipe must be chamfered approx 0.25mm X 45°
- 3.1.3. The bore of the pipe must be de-burred.
- 3.1.4. 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 the operation. **DO NOT** use abrasive cloth. Blow any debris from the pipe after flaring.

- 3.2. Clamp the tool in a suitable bench mounted vice. Assemble the lever onto the cam as shown (Fig.1). Loosen the clamping screw to allow the clamp to swing open.

- 3.3. The pipe end to be flared must be cut clean and square and be de-burred. Use a pipe or tube cutter (available from your Sealey dealer).

- 3.4. Consult Chart 1 and select the punch holder containing the punches and the die specified to produce the required flare. Place the die into the cavity as shown with the split line horizontal and the counterbore towards the operating lever (Fig.2).

- 3.5. 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 plate into position and tighten the clamping screw. Check that the position of the pipe and die are still correct (Fig.3).

- 3.6. Fit the specified punch and holder into the mating groove in the sliding portion of the tool with the required punch of the first operation facing and in line with the pipe (Fig.4).

- 3.7. 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 (Fig.5). 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.

IMPORTANT

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

NOTE: It is our policy to continually improve products and as such we reserve the right to alter data, specifications and component parts without prior notice.
IMPORTANT: No liability is accepted for incorrect use of this equipment.

WARRANTY: Guarantee is 12 months from purchase date, proof of which will be required for any claim.

INFORMATION: For a copy of our latest catalogue and promotions call us on 01284 757525 and leave your full name and address, including postcode.

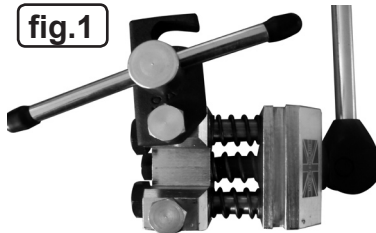


fig.1

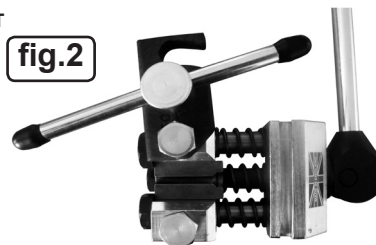


fig.2

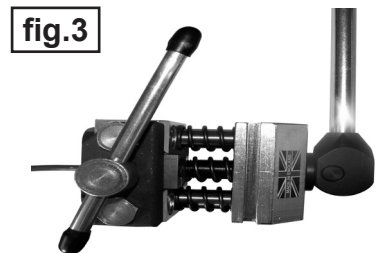


fig.3

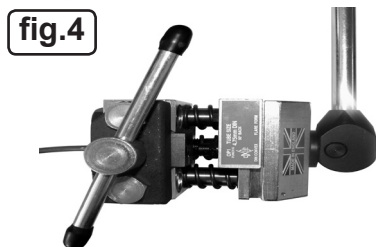


fig.4



fig.5

Thank you for purchasing a Sealey Product. Manufactured to a high standard this product will, if used according to these instructions and properly maintained, give you years of trouble free performance.



IMPORTANT: PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFE OPERATIONAL REQUIREMENTS, WARNINGS AND CAUTIONS. USE THIS PRODUCT CORRECTLY AND WITH CARE, FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE AND/OR PERSONAL INJURY AND WILL INVALIDATE THE WARRANTY. PLEASE KEEP THESE INSTRUCTIONS SAFE FOR FUTURE USE.

1. SAFETY INSTRUCTIONS

- p **WARNING!** Ensure Health & Safety, local authority and general workshop practice requirements are adhered to when using this equipment. Familiarise yourself with the application and limitations, as well as the potential hazards of the kit.
- ✓ This kit is suitable for flaring copper, brass, steel or thin walled aluminium pipe.
- ✓ Maintain the kit in good condition.
- 3 Replace or repair damaged parts. Use genuine parts only. Unauthorised parts may be dangerous and will invalidate the warranty.
- 3 Locate the flaring tools in a suitable work area, keep the area clean and tidy and ensure there is adequate lighting.
- p **WARNING!** Always wear approved eye or face protection when using the flaring tools.
- ✓ Keep children and unauthorised persons away from the working area.
- x **DO NOT** use the kit for any purpose other than for which it is designed.
- x **DO NOT** use the kit if any parts are damaged or missing as this may cause failure and/or personal injury.
- x **DO NOT** allow untrained persons to use the kit.
- x **DO NOT** attempt to flare piping when you are tired, under the influence of alcohol, drugs or intoxicating medication.
- ✓ When not in use clean kit components, replace in case and store in a safe, dry, childproof area.
Remember! The safe operation of a vehicle, or other equipment, may well depend on the quality of the flare produced. Discard any flare which is mis-formed.
- p **WARNING! The warnings, cautions and instructions discussed in this manual cannot cover all possible conditions and situations that may occur. It must be understood that common sense and caution are factors which cannot be built into this product, but must be applied by the operator.**



2. INTRODUCTION & SPECIFICATIONS

Produces accurate automotive double flares on most common sizes of brake pipe. Cam action body fits into bench vice. Supplied with 3/16"SAE and 4.75mm SAE and DIN dies for most popular flares. Other sizes available on request. Suitable for steel pipes and supplied in carry case with full instructions and die listing.


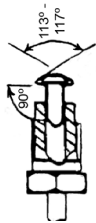

Part	Description
Dies:	4.75mm, 3/16".
Clamp Blocks:	4.75mm, 3/16".
Other flare forms available:	Contact your Sealey dealer.



Chart 1 for:
BRAKE PIPE FLARING KIT
3/16"SAE + 4.75mm DIN

AUTO SERVICE LINE

Model: **PFT/02.V3**

					
SAE CONVEX		113° - 117° DIN CONVEX		SAE DOUBLE	
TUBE ØDIA	OP.1 PUNCH	DIE SET	TUBE ØDIA	OP.1 PUNCH	DIE SET
3/16 in	1	4.75-3/16	4.75mm	6	4.75D
1/4 in	2	1/4	6mm	6mm	6mm D
5/16 in	3	5/16	8mm	8mm	8mm D
3/8 in	4	3/8	10mm	10mm	10mm D
1/2 in	5	1/2	12mm	12mm	12mm D
6mm	2	6mm			4.75mm
8mm	3	8mm			6mm
10mm	4	10mm			8mm
12mm	5	12mm			10mm
					12mm
					4.75-3/16
					1/4
					5/16
					3/8
					1/2
					7
					B
					8
					D
					9
					6mm
					8mm
					10mm
					12mm