

No. 458

Capacity: 1/8" through 3/4" (45°)

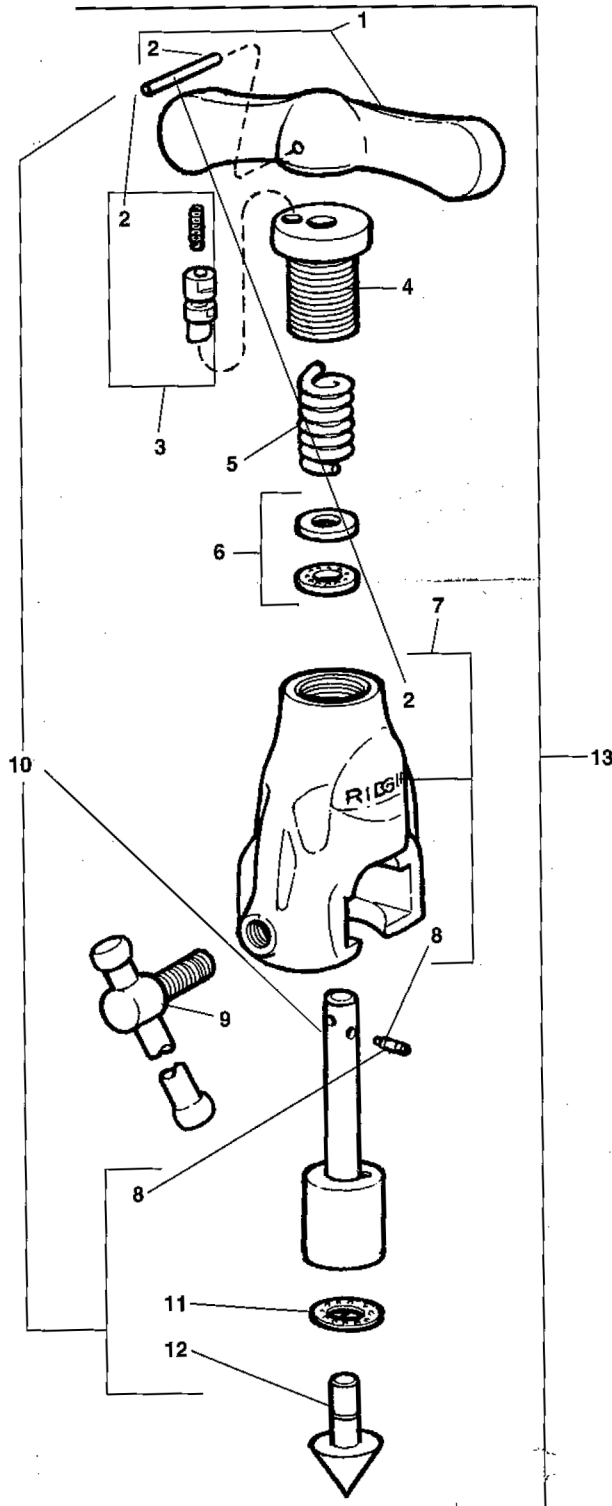
No. 458MM

Capacity: 4 mm through 16 mm (45°)

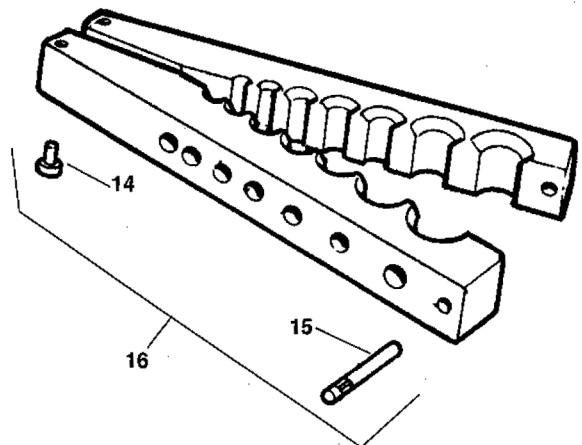
No. 377

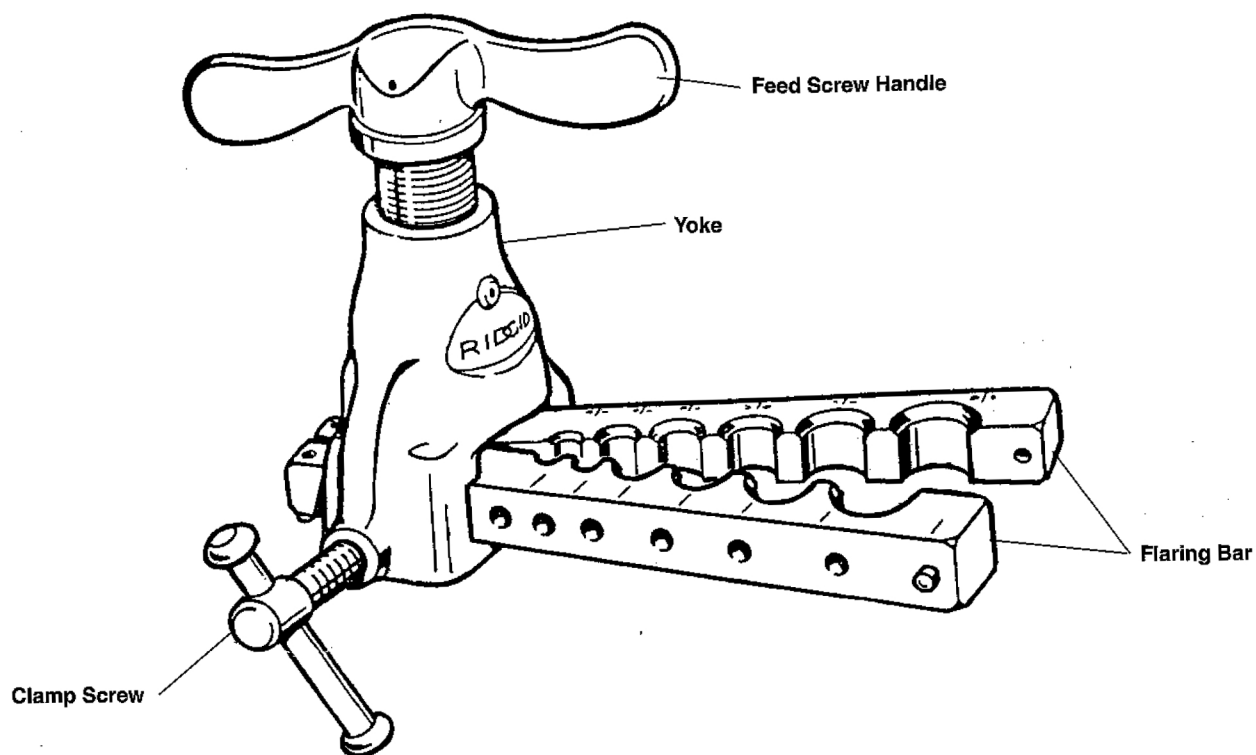
Capacity: 3/16" through 3/4" (37°)

NOTE: Order parts by Catalog Number only.
DO NOT order by Reference Number.



Ref. No.	Catalog No.	Description
1	41495	Handle with Pin
2	41500	Roll Pin
3	41510	Plunger Assembly
4	41525	Feed Screw - 45°
	41490	Feed Screw - 37°
5	41485	Spring
6	41520	Bearing Assembly
7	39722	Yoke Assembly
8	41505	Pin
9	41515	Clamp Screw Assembly
10	41475	Shaft Assembly - 45°
	41480	Shaft Assembly - 37°
11	41470	Thrust Bearing
12	41460	Cone - 45°
	41465	Cone - 37°
13	39742	Yoke and Shaft Assembly - 45°
	42092	Yoke and Shaft Assembly - 37°
14	41450	Stop Pin 2
15	41455	Locating Pin
16	39727	Flaring Bar Assembly - 458
	50267	Flaring Bar Assembly - 458MM
	42102	Flaring Bar Assembly - 377





Operating Instructions

1. Cut and ream tubing.
2. Back off feed screw handle and clamp screw to permit flaring bars to slide freely through yoke. Slide yoke to hinged end of flaring bars.
3. Insert tube into proper size opening and close flaring bars. Push tube up from bottom of tool until it is even with top of flaring bars.

NOTE! OVERSIZE or UNDERSIZE flares can be made by adjusting tube position slightly above or below the top of flaring bars.

4. Slide yoke forward over tube until arrow on yoke meets line on flaring bars. Tighten clamp screw firmly.

5. Turn the feed screw handle clockwise until pressure kick-out releases. A few additional turns before backing off will burnish flare.
6. Back off feed screw handle as far as it will go. Release clamp screw and slide yoke back. Remove tube. If tube tends to stick, tighten clamp screw against tapered end of bars. This action will force bars open.