



INSTRUCTIONS FOR USE NO. 275-FSC FLARING AND SWAGING TOOL

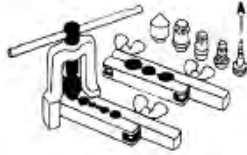


FIGURE 1



FIGURE 2

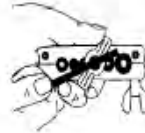


FIGURE 3

WITH THIS TOOL IT IS A SIMPLE MATTER TO FLARE OR SWAGE SOFT COPPER, BRASS OR ALUMINUM TUBING.

FOR FLARING

This tool is used for flaring with the flaring cone attached to the yoke screw (see Fig. 2). Operation is the same as the conventional Imperial Flaring Tool. Before flaring, be sure that the tubing is cut off squarely (this can be done easily with an Imperial Tube Cutter) and be sure to remove all burrs or the turned down edge of metal resulting from cutting the tubing. Insert tubing into die of corresponding size so that it is slightly above top of die. Tighten wing nut nearest to tube first and then tighten the other one. The wings on nuts are of a special shape that permit using the rod of the yoke as a lever in tightening. Nuts must be securely tightened so there is no chance of tube slipping. Note that the yoke of this tool is of a new Imperial Slip-on type which can be slipped directly over the bar (see Fig. 2). The inside edges of the yoke are slotted so that once in position a slight turn clockwise holds it in place. Yoke should be held in place by the thumb and forefingers as show in Fig. 3. Do not use tool on hard tubing of any type. For soft copper, brass & aluminum only.

FOR SWAGING

1. Place tubing in tool same as in conventional flaring tool except allow tubing to protrude above the face of the tool approximately $1/8$ " more than the diameter of the tube you are swaging (i.e., on $1/2$ " O.D. tubing, tubing should protrude $5/8$ " above face of bar).
2. Select the proper size swaging spreader and screw it on to the yoke screw. Place a drop of oil on the spreader. Note that the small spreader (see "A" Fig. 1) takes care of 3 sizes $3/16$ ", $1/4$ " and $3/8$ " O.D. tubing. There is a separate spreader for every other size.
3. Slip the yoke over the bar and turn in a clockwise direction so that it hooks on the bar.
4. Screw the spreader into the tube until it gets to the point where the chamfer on the upper shoulder on the spreader is bearing on the tube.
5. Hold the yoke so it will not twist off the bar and unscrew the spreader from the tube. The result will be a clean, accurate swage.

IMPORTANT - Lubricate the feed screw, adapter bearing and outside of swaging adapter regularly to prolong tool life, reduce operation effort and assure reliable results.



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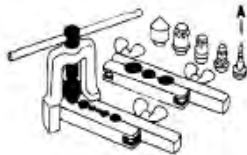


FIGURE 1



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TC-1000 Hi-Duty™ Tube Cutter

(Fig.1) simply place the tubing (A) against the rollers (B). Turn Handle (C) clockwise until the cutting wheel (D) rests rather firmly on the tubing. Turn the cutter completely around the tube and at the end of the revolution, turn wheel handle (C) a little more. Repeat these operations until the tube is cut completely through.

IMPORTANT: For Stainless Steel and Hard Temper Tubing remove standard cutter wheel (D) and replace with cutter wheel 75046 made for this purpose.

When it is desired to cut the flare from end of tubing, place flare in groove (E) of rollers, and operate as above. After cutting, ream end of tubing. (See below).

RETRACTABLE LOCKING REAMER

To move reamer into operating position, place thumb against reamer (Fig. 2) and push toward handle. Swing reamer clockwise until stop is reached, then push forward to locking position (Fig. 3).

SPARE CUTTING WHEEL

A spare cutting wheel is included under reamer blade on this tube cutter. To remove spare wheel, swing reamer blade into open position, loosen screw holding reamer, and wheel can then be removed.

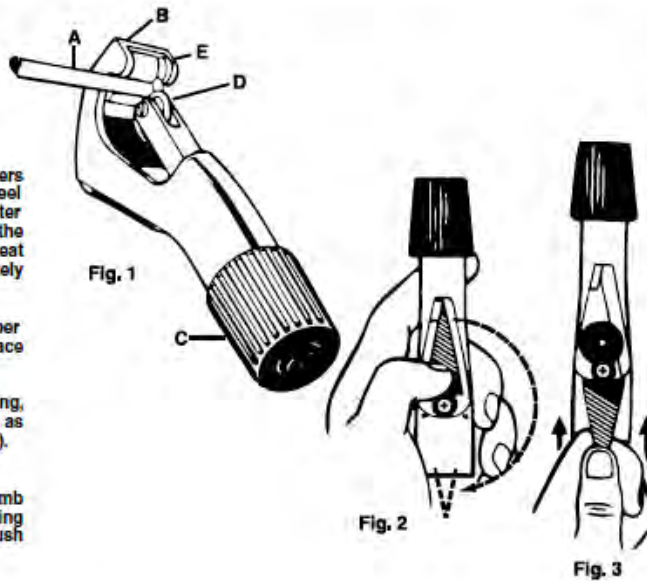


Fig. 1

Fig. 2

Fig. 3



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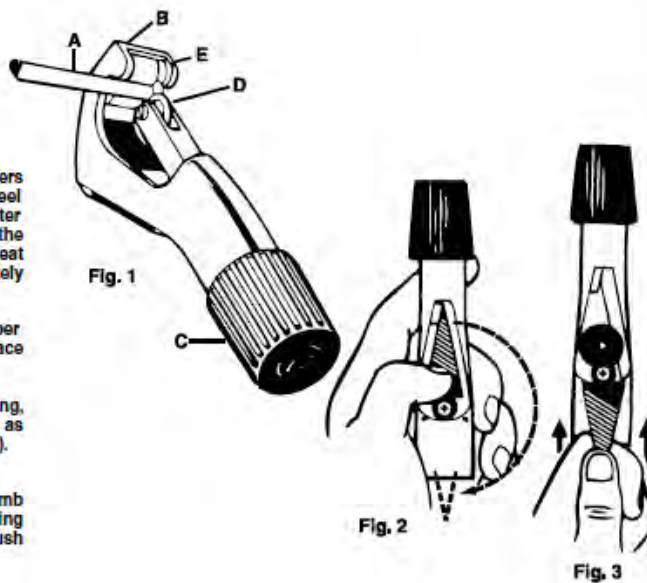


Fig. 1

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Fig. 3



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