**MODEL**
**FTK 625**

**KENNEDY**
**QUALITY INDUSTRIAL TOOLING**

**ORDER CODE**
**KEN-588-9570K**

# FLARING TOOL KIT WITH PIPE CUTTER

**Fig.1**

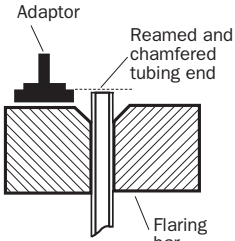



**Fig.2**

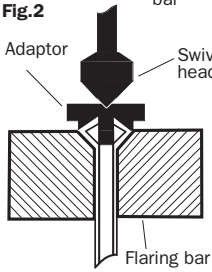
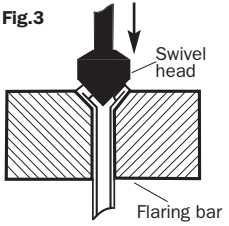



**Fig.3**

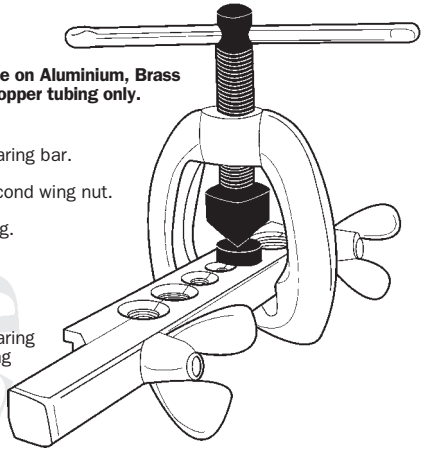



## FLARING INSTRUCTIONS

### TUBING PREPARATION:

- Cut the tubing off square with the pipe cutter.
- Deburr the tubing.
- Chamfer the outer edge of the tubing.

**For use on Aluminium, Brass and Copper tubing only.**



### SINGLE FLARING:

- Unscrew the the wing nuts on the flaring bar.
- Feed the prepared tubing through the correct size hole in the flaring bar. It should protrude about 3mm (⅛") beyond the surface.
- Tighten the wing nut nearest the tubing first followed by the second wing nut.
- Place the yoke assembly over the flaring bar.
- Using the T-handle, turn to apply pressure down on to the tubing.
- Release the swivel head and unscrew the wing nuts.
- This completes the single flare.

### DOUBLE FLARING:

- Unscrew the wing nuts on the flaring bar.
- Feed the prepared tubing through the correct size hole in the flaring bar. The tubing should protrude beyond the surface of the flaring bar. To determine the correct length lay an adaptor on its flat side next to the tubing. The end of the tubing should be level with the first step of the adaptor. This is the amount of tubing required to produce a double flare. (See fig. 1)
- With tubing protruding through the flaring bar, tighten the wing nut nearest the tubing first, followed by the second wing nut. Insert the stem of an adaptor which is suitable for that diameter of tubing.
- Place the yoke assembly over the flaring bar and the adaptor so that the swivel head meets the depression in the face of the adaptor. Use the T-handle of the yoke assembly to feed the swivel head down until the adaptor rests flat on the flaring bar. (See fig. 2) The tubing end should now be formed into a bell shape.
- Release the swivel head, remove the adaptor and re-tighten the swivel head so that the bell shape of tubing is folded in on itself. (See fig. 3)
- Release swivel head and unscrew the wing nuts.
- This completes the double flare.

### MAINTENANCE:

- Oil moving parts regularly.

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Specifications may change without prior notice.

**KENNEDY TOOLS**
**Wigston, Leicester, England, LE18 2FS.**