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KENNEDY®
QUALITY INDUSTRIAL TOOLING

COMPACT FLARING TOOL KIT
WITH PIPE CUTTER AND DEBURRER
MODEL CFTK 625 KEN-588-9620K

FLARING INSTRUCTIONS

Fig.1

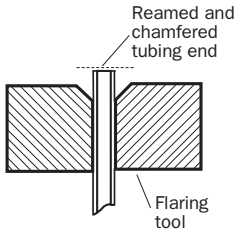


Fig.2

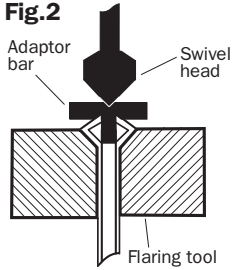
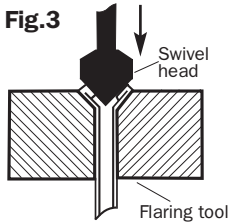


Fig.3



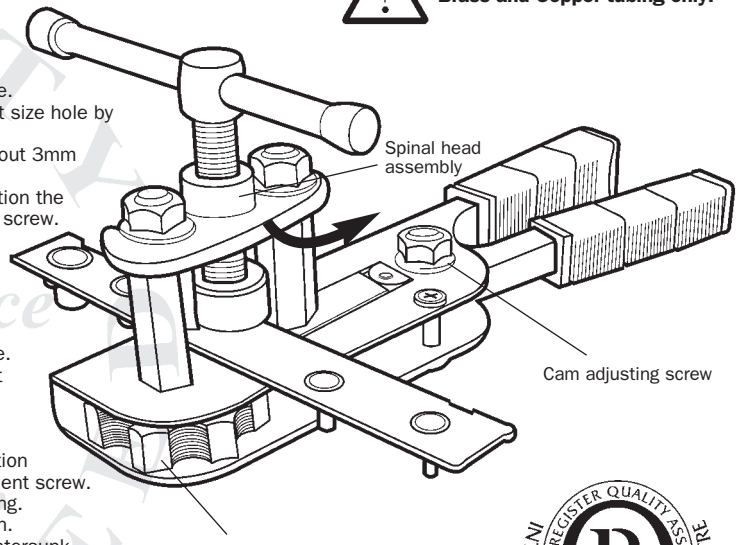
TUBING PREPARATION:
- Cut the tubing off square with the pipe cutter.
- Deburr the tubing.
- Chamfer the outer edge of the tubing.

SINGLE FLARING:
- Unscrew the swivel head assembly and rotate it anti-clockwise.
- Pull the handles of the flaring tool open and select the correct size hole by rotating the two hole gauge wheels.
- Feed the prepared tubing through the hole so that there is about 3mm (⅛") extending above it. (See fig. 1)
- Close the handles to hold the tubing tight. If during the operation the tube slips, realign the tubing and tighten the cam adjustment screw.
- Using the T-handle, turn to apply pressure down onto the tubing.
- Unscrew the swivel head and remove the tubing.
- This completes the single flare.

DOUBLE FLARING:
- Unscrew the swivel head assembly and rotate it anti-clockwise.
- Pull the handles of the flaring tool open and select the correct size hole by rotating the two hole gauge wheels.
- Feed the prepared tubing through the hole so that there is about 3mm (⅛") extending above it. (See fig.1)
- Close the handles to hold the tubing tight. If during the operation the tube slips, realign the tubing and tighten the cam adjustment screw.
- Insert the stem of the correct adaptor into the end of the tubing.
- Rotate the swivel head assembly back into the closed position.
- Using the T-handle, turn to apply pressure down onto the countersunk marking on the adaptor bar.
- Tighten until the adaptor bar rests flat against the flaring tool. (See fig. 2)
- The tubing end should now be formed into a bell shape.
- Release the swivel head assembly and remove the adaptor bar.
- Replace the swivel head assembly and re-tighten it so that the bell shape of the tubing is folded in on itself. (See fig. 3)
- This completes the double flare.

MAINTENANCE:
- Oil moving parts regularly.

For use on Aluminium, Brass and Copper tubing only.



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Specifications may change without prior notice.

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