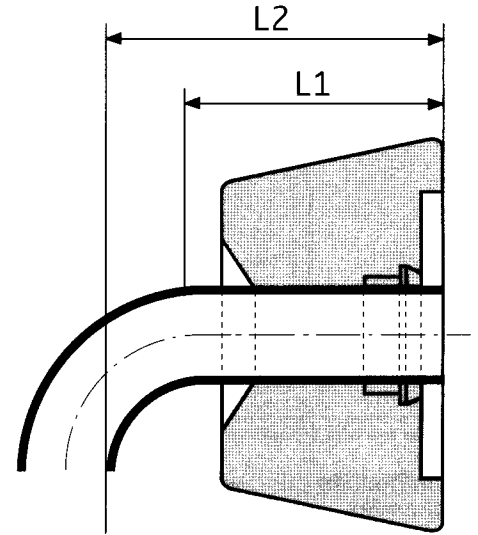


5. Flaring the tube end

5-1 Important: What ever type of equipment is selected (1015, 1020, 1025, 1040) to produce the flare, a minimum straight length before the start of the bend is necessary.

Minimum straight length to start of bend

Tube O.D.		minimum straight length to start to bend (mm) L1			
(mm)	(in.)	1015/1020 Machines	1025 Machine	1040 Machine	
				L1	L2
6	1/4	32	45.4	45.4	55
8	5/16	35	46.2	46.2	55
10	3/8	37	47.7	47.7	55
12	1/2	43	40.2	40.2	55
14			64.8	64.8	55
15		45	64.8	64.8	55
16	5/8	45	45.8	45.8	55
18		50	65.3	65.0	55
20	3/4	50	54.3	54.3	55
22		50	67.0	67.0	55
25	1	58	67.8	67.8	55
28		60	71.1	71.1	55
30		30	71.1	71.1	55
32	1-1/4	60	71.1	71.1	55
35		70	76.4	76.4	55
38	1-1/2	70	76.4	76.4	55
42			77.3	77.3	55



5-2 Selection of the equipment

Manual flaring tool vice block and flaring pin

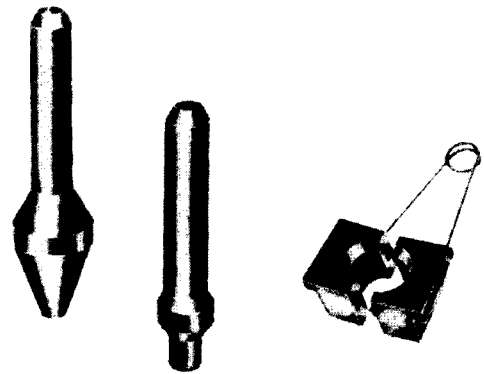
These tools are used in a vice. They are designed for flaring:

- inch O.D. tubing from 1/4" O.D. to 1.1/2" O.D.
- metric tubing from 6 mm O.D. to 38 mm O.D.

From 3/4" size tubing and above it is necessary to use a pre-flaring pin to start the flare.

- clamp tubing flush in block halves
- flare tubing by hammering the flaring pin.

A separate block and pin set is used for each tube size.



Tube O.D. inch	Pre-flaring pin part number	Flaring pin part number	Vice block part number	Tube O.D. mm	Pre-flaring pin part number	Flaring pin part number	Vice block part number
6		P17408	M27406	1/4"		P17408	M04742
8		P17408	M27408	5/16"		P17408	M05742
10		P17408	M27410	3/8"		P17408	M06742
12		P17414	M27412	1/2"		P17414	M08742
14		P17414	M27414				
15		P17414	M27415				
16		P17414	M27416	5/8"		P17414	M10742
18		P17418	M27418				
20	P1E	P17418	M27420	3/4"	P1E	P17418	M12742
25	P1E	P17422	M27425	1"	P1E	P17422	M16742
30	P1E	P17432	M27430		P1E		
32	P1E	P17432	M27432	1.1/4"	P1E	P17432	M20742
38	P1E	P17438	M27438	1.1/2"	P1E	P17438	M27438