



Russell 37 Degree Flaring Tool
Catalog #654430
OPERATING INSTRUCTIONS

Please study these instructions carefully before use of this flaring tool. If you have any questions, please call our **Technical Hotline at: 1-800-416-8628**, 7:00 am - 5:00 pm, Pacific Standard Time, Monday through Friday.

OPERATING INSTRUCTIONS

IMPORTANT NOTE: DO NOT LET THE FLARING DIE CONE MAKE DIRECT CONTACT WITH THE TUBE CLAMPING DIES AT ANY TIME! THIS WILL PERMANENTLY DAMAGE THE FLARING DIE. ALWAYS APPLY A HEAVY OIL TO LUBRICATE THE FLARING DIE WHEN USING THIS TOOL.

1. Tubing that is to be flared must be prepared correctly to achieve the desired result. Prepare the tubing by ensuring that the cut end of the tube is filed flat and square to the tube sides. The inside and outside diameter have to be deburred and cleaned. **Install the tube sleeve and coupling nut (or any other necessary components) prior to flaring.**
2. Retract the flaring die from the tool by turning the handle attached to the flaring die counterclockwise. **Clean and lubricate the flaring die with heavy oil.**
3. Open the tube clamping jaws by turning the handle of the jaw locking mechanism counterclockwise and swinging the handle open.
4. Turn the clamping jaw dials to the proper diameter for both of the two jaws. The sizes are marked on the face of the jaw dials.
5. Position the tube stop to properly distance the tube end. The tube stop is attached to the locking handle and can be rotated into place by the locking handle.
6. Insert the tubing into the clamping jaws until the tubing makes contact with the tube stop.
7. Close the jaw mechanism and tighten the jaws together to secure the tube. Make sure that the tubing has not shifted out of position. Tighten only enough to ensure that the tubing will not be pushed out of the clamping jaws during flaring. **Be careful not to overtighten or the tubing will be damaged.**
8. Begin the flaring process by tightening down the flaring die handle until the flare is made on the end of the tubing. **Do not overtighten the flaring die onto the tube.**
9. Retract the flaring die fully and open the jaws to remove the flared tubing from the tool.

