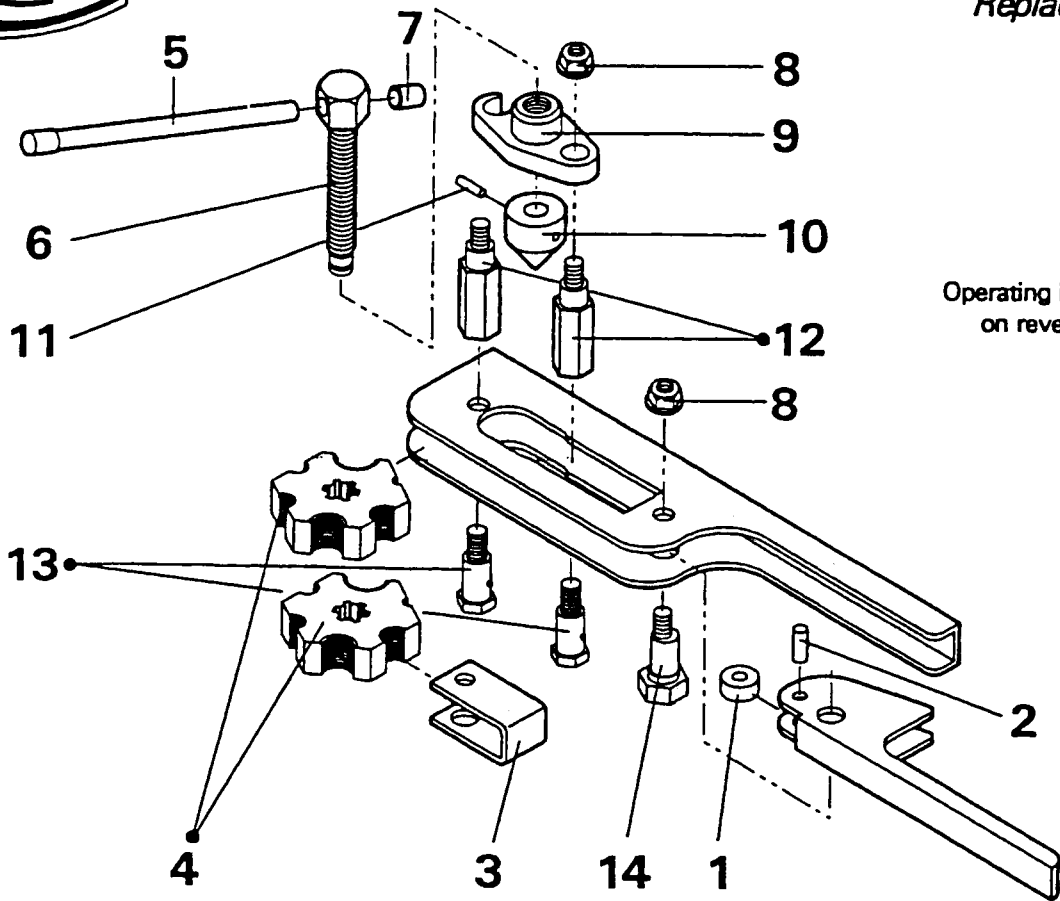




Copper Flaring Tools (Model FT6)

Replacement Parts



Operating instructions
on reverse side

Ref. No.	Description	Item Code	Qty. Used
1	Roller	96430	1
2	Roller Pin	96431	1
3	Clamp Yoke	96432	1
4	Clamp Block	96433	2
5	Handle Assembly	96434	1
6	Screw	96435	1
7	Handle Cap	96436	2
8	5/8" Lock Nut	96437	3
9	Yoke	96438	1
10	45 degree Flare Cone	96439	1
11	Cone Pin	96440	1
12	Post	96441	2
13	Post Screw	96442	2
14	Adjusting Screw	96443	1

Reed Manufacturing Co.
1425 W. 8th St.
Erie, PA 16502 U.S.A.

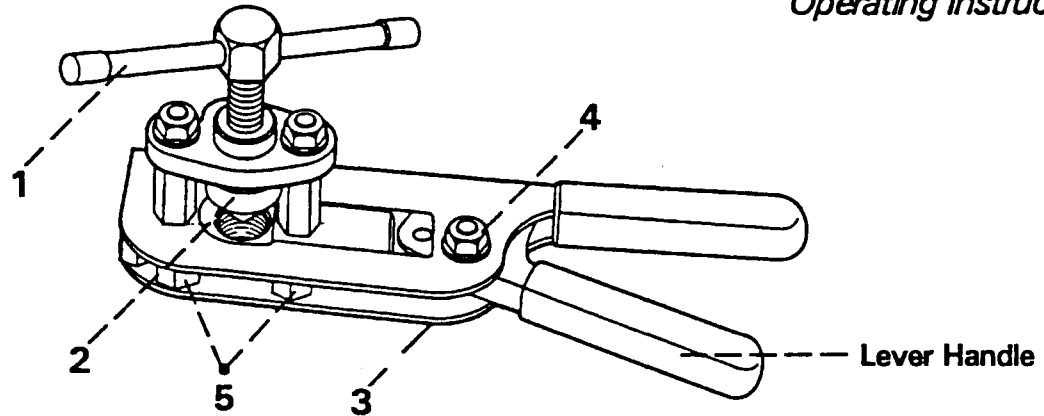
Phone 1-800-666-3691 or 814-452-3691
FAX 814-455-1697

RP-192 698198



Copper Flaring Tools (Model FT6)

Operating Instructions



1. Do not attempt to flare out of round or unevenly cut tube ends. Tubing to be flared must have square cut ends and for best results the tubing ends should be cleanly deburred on the inside and outside diameters.
2. Raise the flaring cone to its highest position. This is accomplished by turning part number 1 counterclockwise.
3. Open the lever handle, then slide the rear hexagon clamp block assembly rearward toward the tool's handle.
4. Rotate the two hexagon shaped clamp blocks part number 5 to the tubing size desired.
5. Insert the tube to be flared, through the bottom of the tool, between the clamp block openings. Position the tube end to be flared slightly above the chamfered surface of the two clamp blocks. Close the lever handle to lock and secure the tubing for the flaring operation.
6. Turn the compression screw handle part number 1 clockwise. This operation forces the flaring cone part number 2 into the tube opening starting the flaring operation.
7. Turn the compression screw clockwise until resistance to further turning is felt. At this point open the lever handle, slide the rear clamp block back and remove the flared tube.
8. Special Note: It is better to slightly under flare a tube thus permitting the tube fitting to complete the final forming and seating of the flare joint. Excessive pressure applied during flare tool operation can cold work the tubing resulting in cracked flares. Never use a "cheater" on handle part number 1. The excessive pressure generated could damage the flaring tool or damage the flared tube.

ADJUSTMENT INSTRUCTIONS:

This tool is factory set to grip .025 / .035 wall copper tubing. It is designed however to accommodate and flare a wide range of wall thickness of various types of metal tubing such as steel, aluminum, annealed brass or stainless steel. Since the compressibility of the different metals, wall thicknesses, etc. varies the gripping pressure of the tool is adjustable.

Should the user encounter tubing that will not permit the lever handle to close over center and lock, the following adjustment must be made.

1. With a 1/2" wrench, loosen lock nut part number 4.
2. With a 5/8" wrench, turn part number 3, the eccentric adjusting screw, clockwise until the desired gripping pressure is obtained.
3. Tighten lock nut part number 4 lightly to secure adjustment.