



# 1/4" Brake Line Hammer Punch Flare Tool Kit

PART NUMBERS: 60-58354

## INSTALLATION INSTRUCTIONS

### Tools In the Kit:

- 2 tool handles (used for tightening and setting tube depth)
- 3 Hardened steel flare dies
- 1 Flare depth cap
- 3 Jaw Tube Clamp Die guide
- Padded hard shell carrying case

### Tips:

- Remember to install the fitting you will use before flaring as you will not be able to install after you have made the flare.
- Make sure that the tube you are cutting is flat and cleaned of debris to make sure the new flare is free from defects or scratches.
- Clean your tool dies of grease after each use as this grease can trap metal shavings that will damage your lines or tooling.
- If you need any assistance during installation or if you have questions about this process, call our Tech Help Line at (254) 848-4300.



### Step 1

- Cut and prepare the end of your 1/4" material making sure to clean burrs or debris from the inside of the tube as this will deform the end during the forming process.



### Step 2

- Clamp the 3 Jaw Tube Clamp Die guide in a sturdy vise and loosen the 3 jaw tightening side.



### Step 3

- Insert your 1/4" tube leaving the side you wish to flare out the non vise side of the 3 Jaw Tube Clamp Die guide.

**IMPORTANT:** All appropriate safety equipment (gloves, tools etc.) must be used during the installation of this product(s).

Nitro Dave's LLC accepts NO responsibility for injuries or damages resulting during and/or from the installation of any product(s). All products are intended for off-road use only.

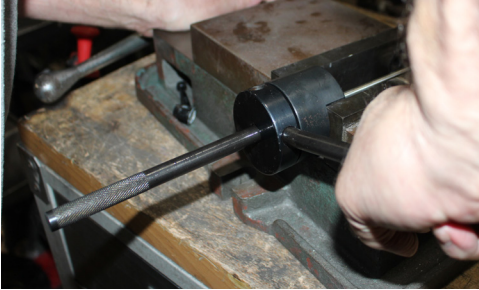
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### Step 5

- Using one of the tightening handles with the recessed tip push the tube back until the handle bottoms out in the jig.



### Step 6

- Leave the one handle in the front to make sure that the tube does not move while tightening (using the other handle). You must tighten this with enough force that the tube does not slip while hammering the die on the end. Tighten as needed.



### Step 7

- Use a sharpie to mark the tube on the back side so you can check whether or not any of the hammering has allowed the tube to slip in the 3 Jaw Tube Clamp Die.



### Step 8

- Once you are sure that the tube is at the correct depth insert flare die #1 and hit with even and increasing strength 2-3 times tightening the clamp between each hammer blow.

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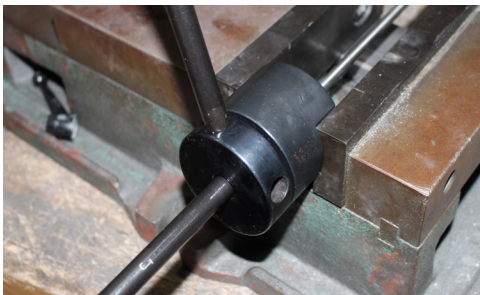
### Step 9

- Loosen the jaws and slide the tube out to ensure that you have the first flare correct. It should be rounded and look like it has been bubbled.



### Step 10

- If it is correct, tighten the clamp mechanism to where the tube can slide but with resistance and pull it back against the clamp mechanism. Tighten and repeat step 8 with flare die #2.



### Step 11

- Check the tube the face of the tube should now be flat in preparation for the flare die #3.



### Step 12

- Repeat previous steps with die #3 and your flare should be complete.

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FLO SUPPLY | 305 SOUTH 28TH STREET | WACO, TX 76710 | P: 254-848-4300 | [WWW.FLOSUPPLY.COM](http://WWW.FLOSUPPLY.COM)