

270 SERIES DOUBLE LAP FLARING TOOL



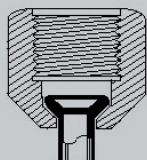
270 Brake Pipe Kit Specifications:

Reference	Flare Pattern	3/16"	1/4"	5/16"	3/8"	1/2"	4.75 (mm)	6 (mm)	8 (mm)	10 (mm)	12 (mm)
02700000	SAE convex single	X	X	X	X		X				
	DIN convex single						X				
	SAE / DIN double	X	X	X	X		X				
02700100	SAE convex single	X					X				
	DIN convex single						X				
	SAE / DIN double	X					X				
02700200	SAE convex single	X					X	X	X	X	
	DIN convex single						X				
	SAE / DIN double	X					X	X	X	X	
02700800	SAE convex single	X	X	X	X	X	X	X	X	X	X
	DIN convex single						X				
	SAE / DIN double	X	X	X	X	X	X	X	X	X	X
02700900	SAE convex single	X	X				X	X			
	DIN convex single						X				
	SAE / DIN double	X	X				X	X			

02700000



270 Series - Individual punch and die selection chart:

Flare Pattern	Tube o.d.	270 Series Individual Selection	
		Punch	Die Set
SAE convex (single) 	3/16"	02705100	02703100
	1/4"	02705200	02703200
	5/16"	02705300	02703300
	3/8"	02705400	02704400
	1/2"	02705500	02703500
	6mm	02705200	02704200
	8mm	02705300	02704300
	10mm	02705400	02704400
	12mm	02705500	02704500
DIN convex (single) 	4.75mm	02706100	02704100
	6mm	02706200	02704700
	8mm	02706300	02704800
	10mm	02706400	02704900
	12mm	02706500	02705000
SAE / DIN (double) 	3/16"	02705100	02703100
		02707100	
	1/4"	02705200	02703200
		02707100	
	5/16"	02705300	02703300
		02707200	
	3/8"	02705400	02703400
		02707200	
	1/2"	02705500	02703500
		02707300	
	4.75mm	02705100	02704100
	6mm	02707100	02704200
		02705200	
	8mm	02705300	02704300
		02707200	
10mm	02705400	02704400	
	02707200		
12mm	02705500	02704500	
	02707300		

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Kit No.	Body Assembly	Dies				
02700000	02701100 (c/w 027014 Turret)	02703100 3/16"	02703200 1/4"	02703300 5/16"	02703400 3/8"	02704100 4.75mm
02700100	02701200 (c/w 027015 Turret)	02703100 3/16"	02704100 4.75mm			
02700200	02701100 (c/w 027014 Turret)	02703100 3/16"	02704100 4.75mm	02704200 6mm	02704300 8mm	02704400 10mm

The Flaring Tool STORAGE CASE has been designed to accept the full range of 270 Series components. To extend the application of this kit, further punches and dies can be selected from the list below. Punches are normally supplied, ready mounted on the four turret assemblies shown. However, individual punches can be purchased to replace any lost or damaged.

Turret Assembly No. 027014		Die Sets	
02705100	OP.1 Punch 3/16"	02703100	Die set 3/16"
02705200	OP.1 Punch 1/4" & 6mm	02703200	Die set 1/4"
02705300	OP.1 Punch 5/16" & 8mm	02703300	Die set 5/16"
02705400	OP.1 Punch 3/8" & 10mm	02703400	Die set 3/8"
02707100	OP.2 Punch 3/16", 1/4", 4.75mm & 6mm	02703500	Die set 1/2"
02707200	OP.2 Punch 5/16", 3/8", 8mm & 10mm	02704100	Die set 4.75mm DIN
		02704200	Die set 6mm
		02704300	Die set 8mm
		02704400	Die set 10mm
		02704500	Die set 12mm
		02704700	Die set 6mm DIN
		02704800	Die set 8mm DIN
		02704900	Die set 10mm DIN
		02705000	Die set 12mm DIN
Turret Assembly No. 027015		Other Components	
02705100	OP.1 Punch 3/16"	02702500	Die Clamp Screw c/w "T" bar
02706100	OP.1 Punch 4.75mm DIN	02702700	Handle
02707100	OP.2 Punch 3/16", 1/4", 4.75mm & 6mm		
Turret Assembly No. 027016			
02705500	OP.1 Punch 1/2" & 12mm		
02707300	OP.2 Punch 1/2" & 12mm		
Turret Assembly No. 027018			
02706100	OP.1 Punch 4.75mm DIN		
02706200	OP.1 Punch 6mm DIN		
02706300	OP.1 Punch 8mm DIN		
02706400	OP.1 Punch 10mm DIN		
02706500	OP.1 Punch 12mm DIN		

IMPORTANT

Tube Preparation

All types of tubing to be flared must be correctly prepared as follows:

- the end of the tube must be cut square
- the outside edge carefully chamfered
- the inside edge de-burred

Plastic Coated Tubing

Scrape away plastic coating for 2-3mm from end of tube with a sharp instrument such as a knife before proceeding as above. Do not use a file or emery cloth. Remove any whiskers of plastic with a nylon brush. Do not use a wire brush. Always blow out the tube after flaring or bending.

The PUNCH TURRET is retained by a spring loaded ball. This provides a positive location for punch selection when a turret is rotated. To remove turret, turn to a position mid-way between any two adjacent punches and pull firmly upwards.

Reverse the procedure to refit making certain that the turret is pressed fully down to the base of the support pillar.

