

# Flaremaster2 - Stainless Steel Pipe Upgrade Kit 02727500

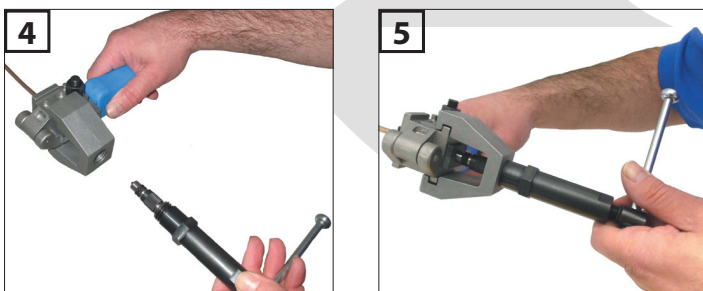
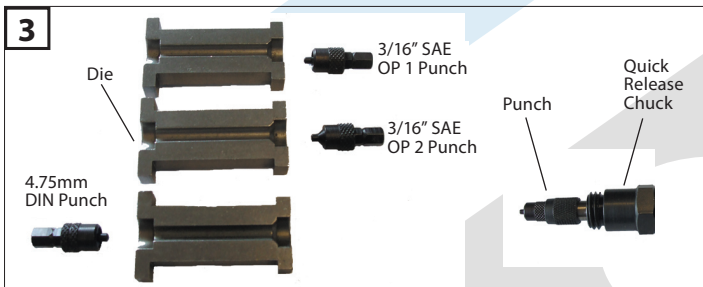
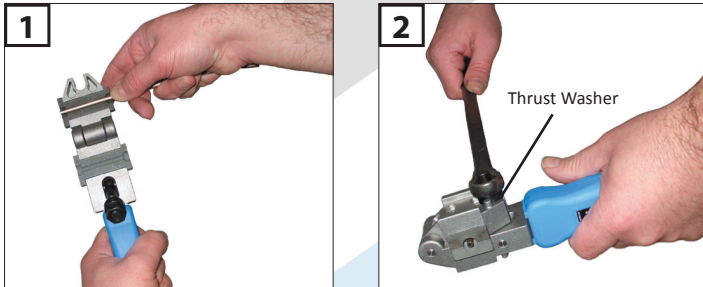
## Pipe Preparation

Ensure pipe is cut accurately and fully deburred both internally and externally prior to flaring. Failure to do so will result in off-centre flares.

Careful pipe preparation is very important to ensure accurate flares. The end must be cut squarely and the pipe fully de-burred internally and externally.

Always grip the pipe on a straight section which has not been clamped previously. If the flare is not satisfactory first time always cut off sufficient pipe to ensure a new portion of pipe is gripped in the tool.

Correct pressure holding the dies ensure accurate flares and ongoing servcability of the tool.



## Stainless Steel Pipe

Stainless steel pipe is much more difficult to work with and achieve good results. Extreme care must be taken in the preparation and clamping of the pipe. Prior to making the flare it helps to apply a small amount of flaring compound to the tip of the punch.

Products such as MOLYSLIP (Metal Cutting Compound) or similar assists in flaring stainless tubing. This allows the material to form correctly. Take care to avoid blockage in the pipe through excess flaring compound.

Thrust washers are provided to be used under the clamping nut to ensure the stainless steel pipe is gripped firmly. This ensures the tool is level avoiding slippage when flaring.

## Instructions for Use

1. Select the correct die-form and insert the pipe until the pipe end is flush with the face on the die. Swing the hinged portion of the die holder over to clamp the pipe.
2. Fully tighten the clamp nut ensuring the thrust washer is in place under the nut and between the casting.
3. Select the correct punch (ie. 4.75mm DIN or 3/16" OP 1 SAE) and fit into the quick release chuck on the end of the power ram. Please note 3/16" OP 1 punch has a plain knurled body and 4.75mm DIN punch has a grooved knurled body.
4. Place the bridge piece onto the main body and insert the ram. Once in position, wind the T-Bar pressure screw fully home until the rubber O-Ring under the head of the screw starts to compress.
5. For completion of an SAE Double Lap Flare (Concave Form) remove the ram from the bridge and replace the OP 1 SAE punch with the OP 2 SAE punch. Insert the ram into the bridge and tighten to complete the flare.

NOTE: The second OP flare form is only available on SAE.

To produce DIN form flares the tool is reversed and operated from the other side with the correct punch inserted in the ram.

## Spare Parts

- 02727070 Hydraulic Ram c/w pressure screw for stainless steel pipe
- 00202570 MOLYSLIP MCC
- 09811870 Thrust Washer

## Chemical Product

- Product Name: MCC
- Product Type: Metal Working Paste
- Product Use: Lubricant for metal removal operation

## Hazards Identification

This product is not classified as hazardous under current UK Health & Safety & Environmental Legislation when used in the application for which it is intended. However, prolonged or extensive skin contact with the product may result in skin disorders. The risk of skin disorders may be increased if the product has become contaminated.