

# RUGGED. DURABLE. A LOT LIKE YOU.

Sometimes the job calls for a no-frills type of flaring tool. These bulldogs are rock-solid, compact and not afraid to be knocked around. With a cast steel yoke, hardened flaring bar and steel wing nuts, you can guarantee these guys will get the job done. Just be sure to use hilmor flaring tools on soft tubing materials such as copper, aluminum, brass and steel.

## Flaring Instructions:

1. Prep the tube for flaring by cutting to length and deburring the inside and outside of the tube end.
2. Place the flare nut in position on the tube.
3. Insert the tube into the block, keeping the tube end slightly above the top of the block so there is enough material to make a flare. Tighten the wing nuts, starting with the one closest to the tube (this will help keep the tube from slipping).
4. Position the yoke over the tube, and block and rotate the yoke to lock into place. Hold in place as flare is being formed.
5. Turn the handle, making complete rotations until flare is formed and the handle cannot be turned anymore.
6. To release the tube once complete, turn the handle counterclockwise, loosen the wing-nut, remove the yoke and open the block.
7. Brag.