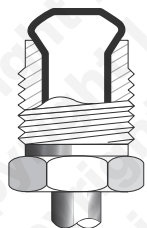


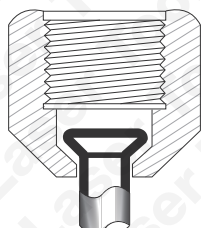
SAE CONVEX (SINGLE) FLARE		
Tube Diameter	Punch	Die Set
4.75mm (3/16")	OP1 4.75/5	4.75 SAE END
5.0mm	OP1 4.75/5	5.0 SAE END
6.0mm	OP1 6.0	6.0 SAE END

SAE CONCAVED (DOUBLE) FLARE		
Tube Diameter	Punch	Die Set
4.75mm (3/16")	OP1 4.75/5	4.75 SAE
5.0mm	OP1 4.75/5	5.0 SAE
6.0mm	OP1 6.0	6.0 SAE

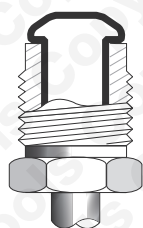
DIN CONVEX FLARE		
Tube Diameter	Punch	Die Set
4.75mm (3/16")	DIN 4.75/5.0	4.75 DIN END
5.0mm	DIN 4.75/5.0	5.0 DIN END
6.0mm	DIN 6	6.0 DIN END



SAE CONVEX FLARE



SAE DOUBLE FLARE



DIN CONVEX FLARE

Consult the chart and the diagrams above and select the die specified to produce the required flare on the diameter of brake pipe specified.



Distributed by The Tool Connection Ltd

Kineton Road, Southam, Warwickshire CV47 0DR
 T +44 (0) 1926 815000 F +44 (0) 1926 815888
 info@toolconnection.co.uk www.toolconnection.co.uk

LASER[®]

4938

Brake Flaring Tool Set | Hydraulic

Flares pipe sizes 4.75mm (3/16") | 5mm | 6mm

This tool utilises a patented design to quickly produce high quality SAE and DIN flares on or off the vehicle. The 4938 can produce flares on Cupro-Nickel and steel pipe as well as coated steel piping.

The 4938 is designed to flare 4.75mm (3/16"), 5mm and 6mm pipes by using the correct size die and punch set supplied.



Contents

- A.** 1 x pair 4.75mm (3/16") Dies
- B.** 1 x pair 5mm Dies
- C.** 1 x pair 6mm Dies
- D.** 1 x "Operation 1" 4.75 (3/16") | 5mm punch (SAE)
- E.** 1 x "Operation 1" 6mm punch (SAE)
- F.** 1 x "Operation 2" 4.75 (3/16") | 5mm punch (SAE)
- G.** 1 x DIN 4.75/5mm punch
- H.** 1 x DIN 6mm punch
- I.** 1 x Yoke unit with handle
- J.** 1 x Hydraulic Ram
- K.** 1 x Mechanical Force Screw

Instructions for Preparation of Use

1. The end of the pipe to be flared must be cut square and the outside edge free from burrs.
2. The outside edge of the pipe should be chamfered by 45°
3. Internal bore of the pipe should be de-burred
4. If the pipe is plastic covered or coated in any way only remove the first 3mm maximum of covering.

N.B. *Do not use a file or abrasive materials to do this as the resultant damage will significantly weaken the flare*

5. After flaring remove all debris from inside the pipe.

N.B. *To ensure a good flare is made every time ensure dies and punches are clean, dry and free from oil contamination on assembly.*

Instructions for Preparation of Use



1. Identify and assemble the correct dies for the flare and pipe size required. Assemble the dies and pipe as shown with the pipe end flush with top of the dies block.

Note: The dies are marked on their inner faces with SAE at one end and DIN at the other, ensure the dies are assembled with the ends matching. Remember the end of the pipe should be square and free from burrs.



2. Select the required punch and fit into quick fit adaptor on the ram. Fit the "S" shaped "Quick Adaptor" onto the ram and screw it half way up the rams thread as shown.



3. Insert the punch/ram combination into the yoke and turn the "S Quick Adaptor" so it locates on to the yoke and screw the ram body fully in to the "S Quick Adaptor" ensuring the punch end aligns with and enters the end of the pipe.



4. Turn the Hydraulic T handle in a clockwise direction until the rubber seal makes light contact with the seal cover as shown. Do not overtighten the O-ring.



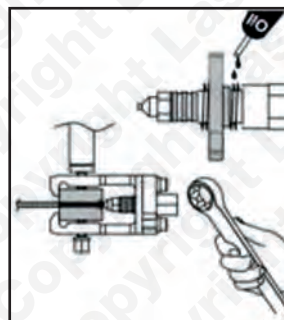
5. Wind the T bar fully back (anticlockwise) and separate the ram from the yoke using the "S Quick Adaptor".



6. If an Operation 2 is required, remove the existing OP1 punch by pulling back on the Ram end sleeve. Now fit OP2 punch and re-assemble the tool.



7. Wind the T bar clockwise again to form the reverse cone flare.



8. Where space is limited the 4938 kit is provided with a mechanical force screw (K) that can be used with an appropriate ratchet wrench. (Keep the force screw thread lubricated with oil).

SAE

Single Flare	=		=	OP1
Double Flare	=		=	OP2
DIN	=			