



HYDRAULIC FLARING TOOL

PART NUMBER

71475M

New Heavy Duty Version




















Included

- **Brake Lines Bubble and Standard**
3/16" - 1/4" - 5/16" - 3/8" - 6mm - 8mm - 10mm
- **Fuel Lines 1/4" - 5/16" - 3/8" - 1/2"**
GM - Diesel - Chrysler Trans
(Male end for quick connect)
- **GM Transmission Lines 3/8" & 1/2"**
Special Trans & Oil Cooler Line Flare
- **GM O-Ring Flare for Fuel Lines**
5/16" - 3/8"



Makes these flares

<p>3/16 invert flare</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 1: 3/16"</p> <p>STEP 1 Adapter(Black) 3/16" OP1</p> <p>FINISH OP2</p>	<p>1/4 invert flare</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 1: 1/4"</p> <p>STEP 1 Adapter(Black) 1/4" OP1</p> <p>FINISH OP2</p>	<p>5/16 invert flare</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 1: 5/16"</p> <p>STEP 1 Adapter(Black) 5/16" OP1</p> <p>FINISH OP2</p>	<p>3/8 invert flare</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 1: 3/8"</p> <p>STEP 1 Adapter(Black) 3/8" OP1</p> <p>FINISH OP2</p>	<p>1/2 invert flare</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 1: 1/2"</p> <p>STEP 1 Adapter(Black) 1/2" OP1</p> <p>FINISH OP2</p>
<p>4.75mm ISO bubble flare</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 2: 4.75mm ISO</p> <p>Adapter(Black) 4.75mm ISO</p>	<p>6mm ISO bubble flare</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 2: 6.00mm ISO</p> <p>Adapter(Black) 6.00mm ISO</p>	<p>8mm ISO bubble flare</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 2: 8.00mm ISO</p> <p>Adapter(Black) 8.00mm ISO</p>	<p>10mm ISO bubble flare</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 2: 10.00mm ISO</p> <p>Adapter(Black) 10.00mm ISO</p>	<p>1/2 quick connect</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 2: 1/2" connect</p> <p>Adapter(Black) 1/2" connect</p>
<p>5/16 GM fuel line</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 3: 5/16" GM</p> <p>Adapter(Black) 5/16" GM</p>	<p>3/8 GM fuel line</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 3: 3/8" GM</p> <p>Adapter(Black) 3/8" GM</p>	<p>1/4 quick connect</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 3: 1/4" connect</p> <p>Adapter(Black) 1/4" connect</p>	<p>5/16 quick connect</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 3: 5/16" connect</p> <p>Adapter(Black) 5/16" connect</p>	<p>3/8 quick connect</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 3: 3/8" connect</p> <p>Adapter(Black) 3/8" connect</p>
<p>3/8 GM trans connect</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 4: 3/8" GM-TC</p> <p>Adapter(Black) 3/8" GM-TC</p>	<p>1/2 GM trans connect</p>  <p>TOOLING NEEDED Tube Holder(Grey) Row 4: 1/2" GM-TC</p> <p>Adapter(Black) 1/2" GM-TC</p>			

SEE REVERSE SIDE FOR OPERATING INSTRUCTIONS



FMSI AUTOMOTIVE HARDWARE

1070 HERITAGE ROAD, BURLINGTON, ONTARIO, CANADA L7L4X9

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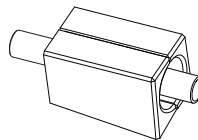
Universal Hydraulic Flaring Tool Operating Instructions

Pre-operation Set-Up

- Open the relief valve to release the pressure, then close tightly.
- Rotate the yoke fully counter-clockwise to bottom out the adapter seat.
- Deburr the tube.

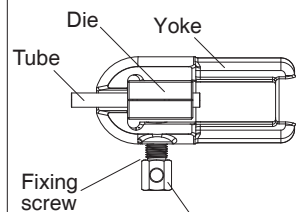
WARNING! Wear safety goggles when using this tool.

- 1) Choose the correct die set and insert the tube between the dies.



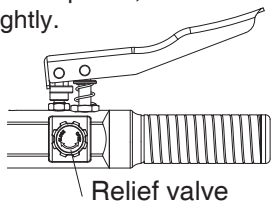
Die refers to Tube holder die

- 2) Insert and tighten the dies and tubing into the yoke.



Securely fasten die by hand tightening fixing screw (clockwise)

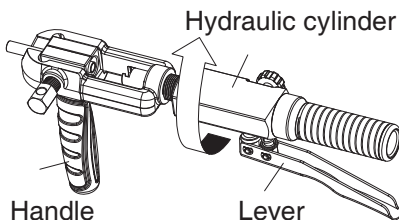
- 3) Open the relief valve to fully recess piston, then close tightly.



Relief valve

*** DO NOT OVER TIGHTEN THE RELIEF VALVE. HAND TIGHTEN ONLY**

- 4) Grasp the handle and rotate the hydraulic cylinder clockwise until it stops.

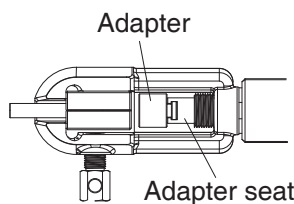


Hydraulic cylinder

Handle

Lever

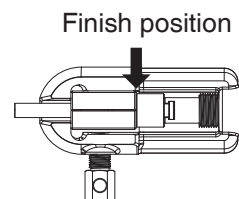
- 5) Place the OP0 adapter onto the adapter seat on the end of the piston.



Adapter

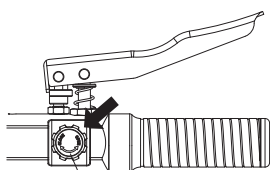
Adapter seat

- 6) Begin squeezing the lever and continue until the edge of the adapter meets the die.



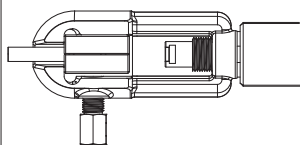
Finish position

- 7) Open the relief valve to fully recess piston, then close tightly. And remove the OP0 adapter.



Relief valve

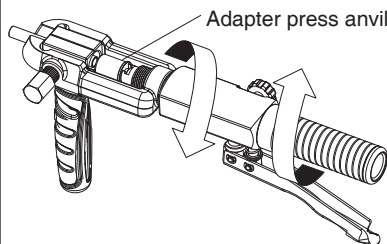
- 8) Securely fasten die by tightening fixing screw with 17mm socket ratchet assembly



Socket Ratchet Assembly not included

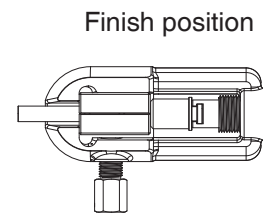
USE 17MM SOCKET RATCHET ASSEMBLY. WHEN TIGHTENING FIXING SCREW, MAKING SURE IT IS TIGHT TO AVOID SLIPPAGE. (BAD FLARES)

- 9) Rotate the tool counter-clockwise leaving enough room to push adapter press anvil in place. Rotate handle clockwise until it stops.



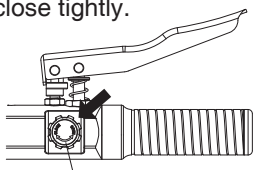
Adapter press anvil

- 10) Squeeze the lever and continue until the edge of the adapter meets the die.



Finish position

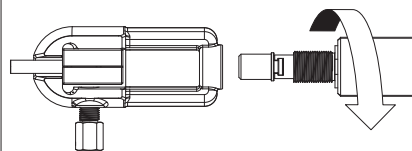
- 11) Open the relief valve to release pressure and then close tightly.



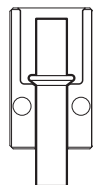
Relief valve

*** DO NOT OVER TIGHTEN THE RELIEF VALVE. HAND TIGHTEN ONLY**

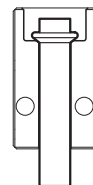
- 12) Grasp the handle and rotate the tool counter-clockwise to remove the adapter from the die.



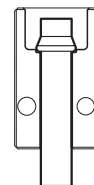
- 13) Loosen the fixing screw and remove the tube. It should look like the sketch below.



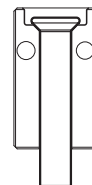
CONNECT



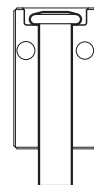
GM



GM-TC



45°&DOUBLE



ISO



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