

Double Tube Flaring Tool Kit

66534 Flaring Tool Kit

INSTRUCTIONS AND PRECAUTIONS

Visit our website at:
<http://www.harborfreight.com>

⚠WARNING

Read this material before
using this product.
Failure to do so can result
in serious injury.
SAVE THIS MANUAL.

When unpacking, make sure
that the product is intact and
undamaged.

If any parts are missing or broken,
please call 1-800-444-3353
as soon as possible.

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Tools. Diagrams within this document may
not be drawn proportionally. Due to continuing
improvements, actual product may differ slightly
from the product described herein. Tools required
for assembly and service may not be included.

**For technical questions or replacement
parts, please call 1-800-444-3353.**



Important Safety Information

1. Assemble and use only according to these instructions. Improper assembly or use can create hazards.
2. Wear ANSI-approved safety goggles and heavy-duty work gloves during assembly and use.
3. Keep assembly and use area clean and well lit.
4. Keep bystanders out of the area during assembly or use.
5. Do not assemble or use when tired or when under the influence of drugs or medication.
6. This product is not a toy. Do not allow children to play with or near this item.
7. Use for intended purpose(s) only.
8. Inspect before use; do not use if parts are damaged.
9. Maintain product labels and nameplates. These carry important safety information. If unreadable or missing, contact Harbor Freight Tools for a replacement.

Operating Instructions



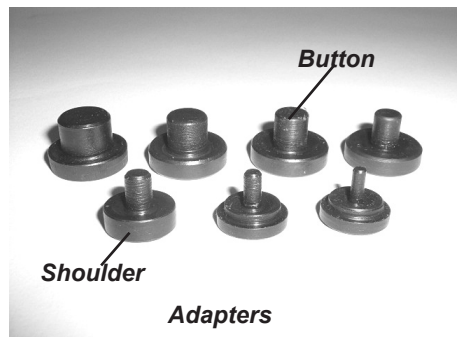
Read the **ENTIRE IMPORTANT SAFETY INFORMATION** section at the beginning of this document including all text under subheadings therein before set up or use of this product.

1. This tool is used to create a double flared end on Copper, Aluminum, Soft Steel and Brass tubing.
2. You may flare tubing from 3/16" to 5/8" in diameter.

3. Prepare the tube by making a clean cut straight across the tube. Deburr inner and outer edges.
4. Back off the Compression Cone and the pivoting wing nut and then slide Yoke (1) over Screen Bar Assembly (2).



5. Place the flare connector nut (not included) over the tube before flaring.
6. Insert the prepared tubing into the proper-size hole in the Screen Bar. Allow the end of the tube to protrude.
7. The end of the tube must protrude above the top of the bar as much as the height of the shoulder of the Adapter. On the two smallest Adapters, the tube protrusion is equal to the large adapter shoulder.
8. After setting the tubing height, tighten the Screen Bar Assembly on the tube by tightening the two Wing Nuts.



Note: Use Button Adapters to create double flared ends for stronger support.

9. Lightly oil the appropriate sized Adapter and insert it into the end of the tube, button end down.



10. Position the Yoke on the Screen Bar over the Adapter.
11. Turn the Handle of the Yoke driving the Adapter into the end of the tube. The tube will flare. Continue flaring until the shoulder of the Adapter touches the Screen Bar.
12. Back off the Yoke enough to remove the Adapter. The first flare has now been made.
13. Screw the Yoke down again on the end of the tube until the tubing folds back on itself, forming a 45 degree double flare.
14. Clean and lightly lubricate the tool, and store it out of reach of children.

Maintenance and Servicing

1. **Before each use**, inspect general condition of tool. Check for misalignment or binding of moving parts, cracked or broken parts, and any other condition that may affect its safe operation. **Do not use damaged equipment.**
2. **After use**, clean external surfaces. Then dry and lubricate all moving parts. Do not use solvents.
3. **When storing**, keep Flaring Tool and its accessories in its Carrying Case and store in a clean, dry, safe location.
4. **CAUTION!** All maintenance, service, and repairs not mentioned in this manual must only be performed by a qualified service technician.

Record Serial Number Here:

Note: If product has no serial number, record month and year of purchase instead.

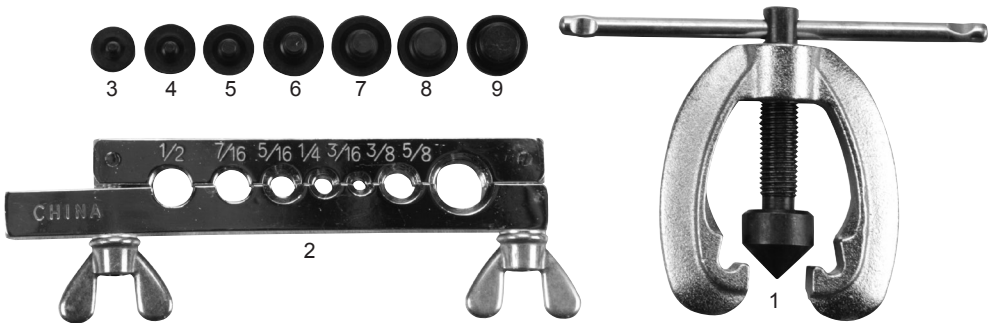
PLEASE READ THE FOLLOWING CAREFULLY

NEITHER THE MANUFACTURER OR DISTRIBUTOR MAKES ANY REPRESENTATION OR WARRANTY OF ANY KIND TO THE BUYER THAT HE OR SHE IS QUALIFIED TO MAKE ANY REPAIRS TO THE PRODUCT, OR THAT HE OR SHE IS QUALIFIED TO REPLACE ANY PARTS OF THE PRODUCT. IN FACT, THE MANUFACTURER AND/OR DISTRIBUTOR EXPRESSLY STATES THAT ALL REPAIRS AND PARTS REPLACEMENTS SHOULD BE UNDERTAKEN BY CERTIFIED AND LICENSED TECHNICIANS, AND NOT BY THE BUYER. THE BUYER ASSUMES ALL RISK AND LIABILITY ARISING OUT OF HIS OR HER REPAIRS TO THE ORIGINAL PRODUCT OR REPLACEMENT PARTS THERETO, OR ARISING OUT OF HIS OR HER INSTALLATION OF REPLACEMENT PARTS THERETO.

Parts List and Diagram

Part	Description	Qty
1	Yoke	1
2	Screen Bar Assembly	1
3	3/16" Adapter	1
4	1/4" Adapter	1
5	5/16" Adapter	1

Part	Description	Qty
6	3/8" Adapter	1
7	7/16" Adapter	1
8	1/2" Adapter	1
9	5/8" Adapter	1
10	Carrying Case (not shown)	1



LIMITED 90 DAY WARRANTY

Harbor Freight Tools Co. makes every effort to assure that its products meet high quality and durability standards, and warrants to the original purchaser that this product is free from defects in materials and workmanship for the period of 90 days from the date of purchase. This warranty does not apply to damage due directly or indirectly, to misuse, abuse, negligence or accidents, repairs or alterations outside our facilities, criminal activity, improper installation, normal wear and tear, or to lack of maintenance. We shall in no event be liable for death, injuries to persons or property, or for incidental, contingent, special or consequential damages arising from the use of our product. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation of exclusion may not apply to you. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

To take advantage of this warranty, the product or part must be returned to us with transportation charges prepaid. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection verifies the defect, we will either repair or replace the product at our election or we may elect to refund the purchase price if we cannot readily and quickly provide you with a replacement. We will return repaired products at our expense, but if we determine there is no defect, or that the defect resulted from causes not within the scope of our warranty, then you must bear the cost of returning the product.

This warranty gives you specific legal rights and you may also have other rights which vary from state to state.

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