

37° FLARING TOOLS

37° FLARING TOOL

For 3/16", 1/4", 5/16", 3/8", 1/2" and 5/8" O.D. tubing.

437-FB For use with soft copper, aluminum and brass tubing. Hardened steel, chrome finished cone makes exceptionally smooth, high-strength flares with a radius at base of flare – instead of the sharp angle formed by ordinary tools. Slip-on yoke permits use in tight quarters, allows flaring where there is little space between nut and tube end. Feed screw design provides smooth, easier operation. Positive gripping and self-gauging of tube for exact flare size. Sliding die blocks lock in place by clamp action. Satin chrome and black finish. Wt. 1.75 lbs.

Outside Tube Diameter (in.)	3/16	1/4	5/16	3/8	1/2	5/8
Wall Thickness (in.)	.032	.032	.032	.032	.035	.035



SELF GAUGING - Just insert tube flush with top of die for accurate flare size.



FORMS STRONGER FLARES - Stronger flares assured by smooth, even radius formed at base of every flare by engineered chamfer.



437-FB

37° ROL-AIR™ FLARING TOOL

For 3/16", 1/4", 5/16", 3/8", 1/2" and 5/8" O.D. tubing.

507-FB For use with soft copper, aluminum and brass tubing. Faceted, hardened steel chrome finished cone rolls out perfect 37° flares above die block - then automatically burnishes flare face. Original wall thickness is maintained at base of flare. Slip-on yoke permits use in tight quarters where there is little space between nut and tube end. Larger handle, with better leverage, and precision threads on feed screw make flaring effortless. Heat treated dies firmly grip tubing. Satin chrome and black finish. Wt. 1.75 lbs.

Outside Tube Diameter (in.)	3/16	1/4	5/16	3/8	1/2	5/8
Wall Thickness (in.)	.032	.032	.032	.032	.035	.049



Flares rolled out above die bar by super-smooth faceted cone. Makes stronger flares.



507-FB

37° ROL-AIR™ FLARING TOOLS

For 3/16", 1/4", 5/16", 3/8", 1/2" and 5/8" O.D. Steel and Stainless Steel tubing.

400-F Forms 37° flares to government specifications in steel, stainless steel (including MIL-T-6845), titanium and other metal tubing. Positive stop gauge assures correct size of flare. Special burnishing action polishes flare face. Three rollers in flaring cone roll out 37° flare above die block. Roller action cuts effort required; maintains original wall thickness - eliminates stress concentration. Extension on yoke for clamping in vise. Satin chrome and black finish. Includes tool case. Wt. 2.5 lbs.

401-FA Reaming yoke for 1/4" to 5/8" O.D. tubing. Recommended for use with steel and stainless steel tubing for proper flaring. Wt. 0.7 lbs.

402-FA Flaring and reaming kit. Contains No. 400-F Flaring Tool and No. 401-FA Reaming Yoke for 1/4" to 5/8" O.D. tubing. Includes tool case. Wt. 3.2 lbs.

Conforms to Federal Specification GGG-F-451a. Type 1, Class 1, Style A.

Outside Tube Diameter (in.)	3/16	1/4	5/16	3/8	1/2	5/8
Wall Thickness (in.)	.035	.049	.049	.065	.065	.065



Feed release and burnishing mechanism. Flare control gauge.

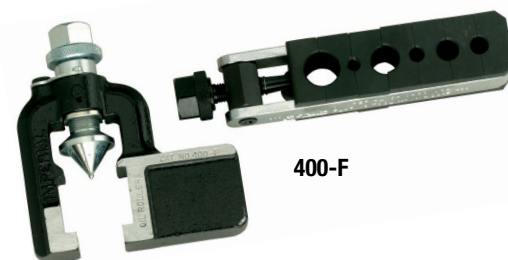


3 rollers in flaring cone. Flare formed above die block.



Feed screw controls depth of reaming.

401-FA



400-F



402-FA

TUBING TOOL SELECTOR

TUBING TOOL SELECTOR				TUBE MATERIAL													
TOOL	PART NO.	PAGE NO.	SIZE RANGE TUBE O.D. (in.)	COPPER							ANNEALED ALUMINUM (SOFT)	ANNEALED BRASS (SOFT)	SAE 1020 STEEL (SOFT)	BRAZED- BUNDY WELD GM STEEL	STAINLESS STEEL ANNEALED (SOFT)	STAINLESS STEEL (1/8 HARD)	TITANIUM
				ANNEALED GENERAL PURPOSE	TYPE K			TYPE L									
				SOFT	BENDING TEMPER (HARD)	HARD	SOFT	BENDING TEMPER (HARD)	HARD	TYPE M							
Tube Cutters	TC-1000	2	1/8 - 1-1/8	•	•	•	•	•	•	•	•	•	•	•	(1)	(1)	(1)
	TC-1050	3	1/8 - 5/8	•	•	•	•	•	•	•	•	•	•	•			
	TC-2050	3	3/16 - 7/8	•	•	•	•	•	•	•	•	•	•	•	(1)	(1)	(1)
	174-F	3	3/8 - 1-1/8	•	•	•	•	•	•	•	•	•	•	•			
Metal Tubing	206-FB	4	3/8 - 2-5/8	•	•	•	•	•	•	•	•	•	•	•			
	227-FA	2	1/8 - 3/4	•	•	•	•	•	•	•	•	•	•	•	(1)	(1)	(1)
	312-FC	2	1/4 - 1-5/8	•	•	•	•	•	•	•	•	•	•	•			
	406-FA	4	2 - 4-1/8	•	•	•	•	•	•	•	•	•	•	•			
Thermoplastic Rubber Hose	307-FP	4	1/16 - 1/2 (4)														
	327-FP	4	1/8 - 13/16 (4)														
Bending Tools	101-F	5	1/4 - 5/8	•	•	•	•	•	•	•	•	•	•				
	102-F	5	1/4 - 7/8	•	•	•	•	•	•	•	•	•	•				
	112-F	5	1/4 - 3/8	•	•	•	•	•	•	•	•	•	•				
	162-F	5	3/16 - 1/4	•	•	•	•	•	•	•	•	•	•				
	163-F	5	1/4 - 5/8	•	•	•	•	•	•	•	•	•	•				
	201-F	5	1/4 - 7/8	•	•	•	•	•	•	•	•	•	•				
	270-F	10	3/4 - 1-1/8	•	•	•	•	•	•	•	•	•	•				
	364-FH	8	1/8 - 3/16	•	•	•	•	•	•	•	•	•	•				
	364-FHA	8	1/4 - 3/4 (3)	•	•	•	•	•	•	•	•	•	•				
	364-FHAM	8	6 - 12 mm	•	•	•	•	•	•	•	•	•	•				
	364-FHB	8	1/4 - 1/2	•	•	•	•	•	•	•	•	•	•				
	364-FHBM	8	6 - 12 mm	•	•	•	•	•	•	•	•	•	•				
	367-FH	7	1/8, 3/16, 1/4	•	•	•	•	•	•	•	•	•	•				
	368-FH	7	3/16, 1/4, 5/16, 3/8	•	•	•	•	•	•	•	•	•	•				
	370-FH	7	3/16, 1/4, 3/8, 1/2	•	•	•	•	•	•	•	•	•	•				
	470-FH	6	3/16, 1/4, 5/16, 3/8	•	•	•	•	•	•	•	•	•	•				
	564-FH	9	3/8, 1/2	•	•	•	•	•	•	•	•	•	•				
	600-F	10	1/4 - 3/4	•	•	•	•	•	•	•	•	•	•				
664-FH	9	1/4, 3/8, 1/2	•	•	•	•	•	•	•	•	•	•					
664-FH (Metric)	9	6 - 12 mm	•	•	•	•	•	•	•	•	•	•					
37° Flaring Tool	400-F	13	3/16 - 5/8	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•
	437-FB	13	3/16 - 5/8	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•
	447-F	14	1/8 - 1/2	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•
	507-FB	13	3/16 - 5/8	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•
	555-FS	15	3/16 - 5/8	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•
	537-F	14	3/4 - 1-1/4	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•
2000-FS	20	1/8 - 3/4	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•	
45° Flaring Tool	195-FC	11	3/16 - 5/8	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•
	203-FA	11	5/8 - 1-1/8	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•
	275-FS	16	1/8 - 3/4	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•
	300-FB	11	3/16 - 5/8	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•
	375-FS	11	1/8 - 3/4	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•
	500-FC	11	3/16 - 5/8	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•
45° Double Flaring Tools	525-F	12	3/16 - 5/8 4.75 - 16 mm	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•
	555-FS	15	3/16 - 5/8	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•
	2000-FS	20	1/8 - 3/4	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•
Reaming and Deburring Tools	93-FB	12	3/16 - 1/2	•	•	•	•	•	•		•	•	•	•	•	•	•
	2000-FS	20	3/16 - 3/4	•	•	•	•	•	•		•	•	•	•	•	•	•
	208-F	23	3/16 - 1-1/2	•	•	•	•	•	•		•	•	•	•	•	•	•
Tube Constrictor	209-F	23	1/4 - 1-1/2	•	•	•	•	•	•		•	•	•	•	•	•	•
	210-F	23		•	•	•	•	•	•		•	•	•	•	•	•	•
Swaging Tools	TC-1020	2	1/8 - 1-1/8	•	•	•	•	•	•		•	•	•	•	•	•	•
	93-S	18	3/16 - 7/8	•	•	•	•	•	•		•	•	•	•	•	•	•
	94-SSP	18	1/2, 5/8, 7/8	•	•	•	•	•	•		•	•	•	•	•	•	•
	95-S	18	3/16 - 5/8	•	•	•	•	•	•		•	•	•	•	•	•	•
	193-S	18	1/4 - 5/8	•	•	•	•	•	•		•	•	•	•	•	•	•
	195-SA	18	1/4 - 5/8	•	•	•	•	•	•		•	•	•	•	•	•	•
	275-FS	16	3/16 - 3/4	•	•	•	•	•	•		•	•	•	•	•	•	•
	555-FS	15	3/16 - 5/8	•	•	•	•	•	•		•	•	•	•	•	•	•
2000-FS	20	3/16 - 3/4	•	•	•	•	•	•		•	•	•	•	•	•	•	
Metric Bubble Flaring Tool	293-F	15	4.75 - 10 mm	•	•	•	•	•	•		•	•	•	•	•	•	•

(1) Heavy duty cutting wheel No. S75046 is recommended for continuous service with steel, stainless steel, monel, titanium and hard temper copper tubing.
 (2) Type M tubing should be torch annealed before flaring.
 (3) No.364-FHA, 5/8" - 3/4" size should be used only with annealed (softened) non-ferrous tubing.
 (4) Not to be used with metal reinforced hose.