

## 45° ROL-AIR™ FLARING TOOLS

### “GRABBER”™ ROL-AIR™ 45° FLARING TOOL

Universal application. Adjustable opening holds all sizes.

Flares and burnishes 3/16" to 5/8" (4.75 mm to 16 mm) O.D. tubing.

**525-F** Unique, self-adjusting, tube holding mechanism permits flaring any size tubing within the range of 3/16" to 5/8" (4.75 mm to 16 mm) O.D. Innovative, single-opening design is more compact and easier to use than conventional multi-opening flaring bars. Faceted, hardened steel, chrome finished cone rolls out and burnishes perfect 45° flare above the tube-holding mechanism reducing need for deburring. Original wall thickness is maintained at base of flare. Slip-on self-centering yoke permits use in tight quarters. Large handle, with better leverage, and precision threads on feed screw make flaring effortless. High quality construction with satin chrome and black finish. Wt. 1.75 lbs.

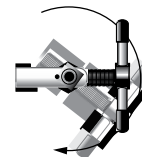


525-F

Outside Tube Diameter (in.)	3/16	1/4	5/16	3/8	1/2	5/8	
Wall Thickness (in.)	.028	.035	.035	.035	.035	.035	
Outside Tube Diameter (mm)	4.75	6	8	10	12	15	16
Wall Thickness (mm)	1.0	1.0	1.0	1.0	1.0	1.0	1.0

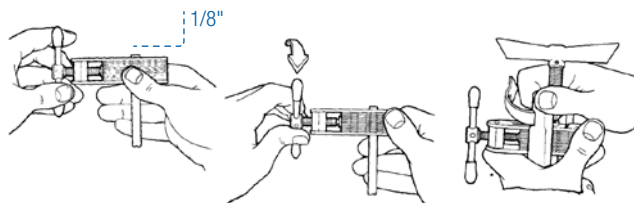


Flares rolled out above die bar by super-smooth faceted cone. Makes stronger flares.



Unique detention mechanism for rapid engagement and release of die blocks.

1. Insert tubing into adjustable opening of tube-holding assembly. Position end of tubing approximately 1/8" above the surface of holder.
2. Tighten clamp screw approximately 1/2 to 3/4 of a turn beyond free travel position to secure tubing.
3. Be certain flaring cone surface is oiled. Slip yoke over tube-holding assembly centering on tubing. Twist yoke clockwise to lock in position. Turn yoke handle clockwise to flare.



## 45° DOUBLE FLARING TOOLS

### 45° DOUBLE FLARING TOOL

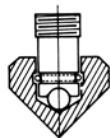
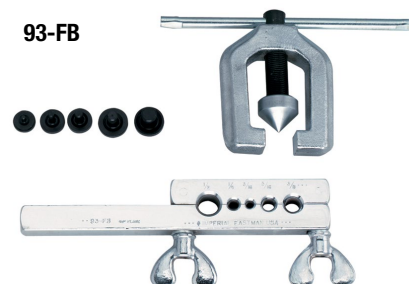
For 3/16", 1/4", 5/16", 3/8" and 1/2" O.D. tubing.

**93-FB** Recommended for Bundy and other annealed soft steel tubing (wall thickness to .035"). Also makes single or double flares in soft copper or aluminum tubing. Small, lightweight, easy to handle. Steel yoke; swivel-type hardened steel, chrome finished flaring cone. Bar provides positive grip of tubing. Includes tool case. Wt. 3.0 lbs.

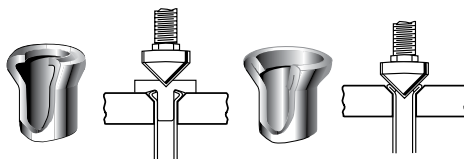
Conforms to Federal Specification GGG-F-451a, Type 1, Class 2, Style A.



93-FB



**SWIVEL-TYPE BALL BEARING CONE -**  
Ball thrust bearing in flaring cone minimizes friction, makes operation easier.



**DOUBLE FLARING ADAPTERS -**  
Screw down flaring cone with proper size adapter in tube. Retract cone, remove adapter, complete flare.

# 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	•	•	•	•	•	•	•	•	•	•	•	•	•	•
	206-FB	4	3/8 - 2-5/8	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Metal Tubing	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	•	•	•	•	•	•	•	•	•	•	•	•	•	•
	307-FP	4	1/16 - 1/2 (4)														
Thermoplastic Rubber Hose	327-FP	4	1/8 - 13/16 (4)														
	101-F	5	1/4 - 5/8	•	•	•	•	•	•	•	•	•	•	•			
Bending Tools	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)	•	•	•	•	•	•	•
	525-F	12	3/16 - 5/8 4.75 - 16 mm	•	•	•	•	•	•	(2)	•	•	•	•	•	•	•
45° Double Flaring Tools	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.