



Mastercool[®] Inc.
"World Class Quality"

Part# 71400

GM Fuel Line Tube Flaring Tool Set

User Guide and Parts List



Pre-operation set-up

- Open the relief valve to fully recess the piston, then close tightly.
- Rotate the yoke fully counter clock-wise to bottom out the adapter seat.
- **READY TO GO!**

Warning! Wear safety goggles when using this tool.

NEWS...

OTHER AVAILABLE ADAPTERS & DIE SETS

Push Connect Adapters and Die Sets:

| Part# | Description |
|-------|----------------------------|
| 71205 | 5/16" Push Connect adapter |
| 71215 | 5/16" Push Connect die set |
| 71206 | 3/8" Push Connect adapter |
| 71216 | 3/8" Push Connect die set |
| 71204 | 1/4" Push Connect adapter |
| 71214 | 1/4" Push Connect die set |

45° Double Flaring Adapters and Die Sets:

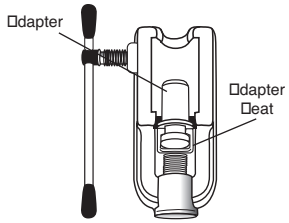
| Part# | Description |
|----------|----------------------------|
| 71097-01 | 45° Flaring Cone |
| 71097-03 | 3/16" Double Flare adapter |
| 71097-13 | 3/16" Double Flare die set |
| 71097-04 | 1/4" Double Flare adapter |
| 71097-14 | 1/4" Double Flare die set |
| 71097-05 | 5/16" Double Flare adapter |
| 71097-15 | 5/16" Double Flare die set |
| 71097-06 | 3/8" Double Flare adapter |
| 71097-16 | 3/8" Double Flare die set |
| 71097-08 | 1/2" Double Flare adapter |
| 71097-18 | 1/2" Double Flare die set |



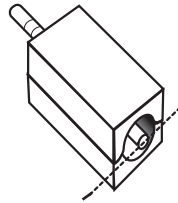
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GM FUEL LINE FLARING INSTRUCTIONS

Rotate the yoke fully counter-clockwise. Place the adapter onto the adapter seat on the end of the piston.

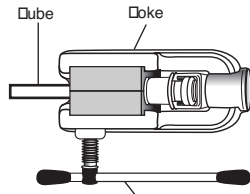


Insert the tube between the dies so it is even with the edge as shown.



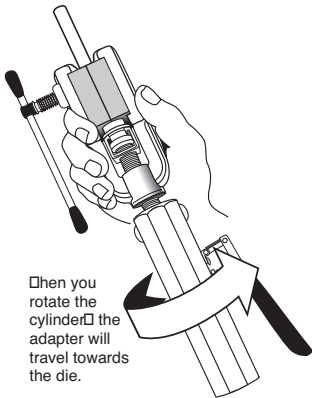
Tube should be even with die as shown.

Insert and tighten the dies and tubing into the yoke. (Important to securely fasten before moving on to step #4.)



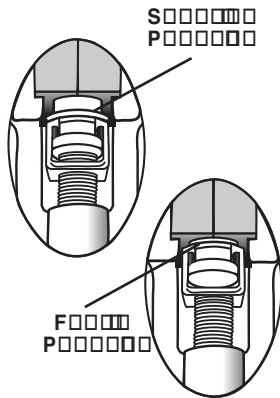
Securely fasten die by turning tightening bar clockwise.

Grasp the yoke and rotate the hydraulic cylinder clockwise until it stops. The adapter should be 1/2 of the way into the die.



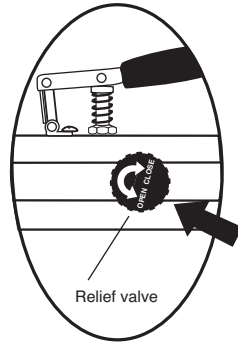
When you rotate the cylinder the adapter will travel towards the die.

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

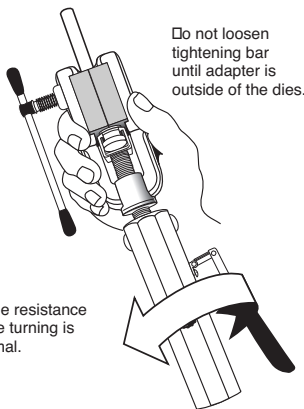


Push

Release the pressure by opening the relief valve.



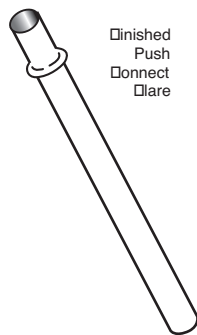
Grasp the yoke and rotate the tool counter-clockwise to remove the adapter from the die.



Do not loosen tightening bar until adapter is outside of the dies.

Some resistance while turning is normal.

Loosen the tightening bar and remove the tube. It should look something like the sketch below.



Finished Push Connect Flare

TOOLKIT SUPPLIES

TOOLKIT SUPPLIES LIST

Close the relief valve.

If hydraulic fluid is too cold, close the relief valve and pump the lever several times to warm the oil.

TOOLKIT SUPPLIES LIST

After the tubing is positioned in the tool the yoke must be rotated into the die before one begins to squeeze the lever. Tightening bar must be very tight.

TOOLKIT SUPPLIES LIST

After flaring you must rotate the yoke counter-clockwise to pull the adapter out of the tubing. This must be done prior to releasing the tightening bar and attempting to remove the tubing.

TECHNICAL ASSISTANCE PROGRAM

GM FUEL LINE ADAPTER FLARING TOOLKIT SUPPLIES LIST

GM FUEL LINE ADAPTER FLARING TOOLKIT SUPPLIES

| Part Number | Description |
|-------------|----------------------|
| 100000 | GM Fuel Line Adapter |
| 100000 | GM Fuel Line Die Set |
| 100000 | GM Fuel Line Adapter |
| 100000 | GM Fuel Line Die Set |
| Part Number | Description |
| 100000 | Hydra-flare assembly |