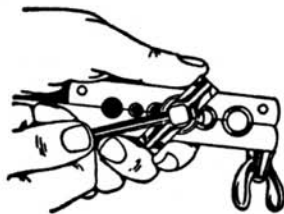


# INSTRUCTIONS FOR USING FLARING AND SWAGING TOOL



## FLARING

1. Make sure the flaring cone is securely attached to the yoke screw.
2. Insert an evenly cut piece of tubing into the corresponding sized die. Insert tubing so that it is slightly above the top of the die.
3. Tighten the wing nut closest to the tube first, then tighten the other one. Nuts must be securely tightened so there is no chance of the tube slipping.
4. Slide the yoke over the bar and line up flaring cone with tube. Slightly turn the yoke clockwise to lock into place. Secure this locked position with thumb and forefinger and begin to tighten down the yoke screw until desired flare is achieved.

## SWAGING

1. Remove yoke cone and install the proper size spreader on the yoke screw. Note that the small spreader accommodates 3/16", 1/4" and 3/8" O.D. tubing.
2. Insert an evenly cut piece of tubing into the corresponding sized die. Insert tubing approximately 1/8" more than the size (O.D.) of the tube you are swaging. (i.e. on 1/2" O.D. tubing, the tubing should protrude 5/8" past the face of the bar).
3. Tighten the wing nut closest to the tube first, then tighten the other one. Nuts must be securely tightened so there is no chance of the tube slipping.
4. Slide the yoke over the bar and line up the swaging spreader with the tube. Slightly turn the yoke clockwise to lock into place. Secure this locked position with thumb and forefinger.
5. Tighten the yoke screw until the chamfer on the upper shoulder of the spreader is bearing on the tube.



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One Aspen Drive, Randolph, NJ 07869-1103 [www.mastercool.com](http://www.mastercool.com)

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