

Installation and Assembly Procedures

Assembly Procedures

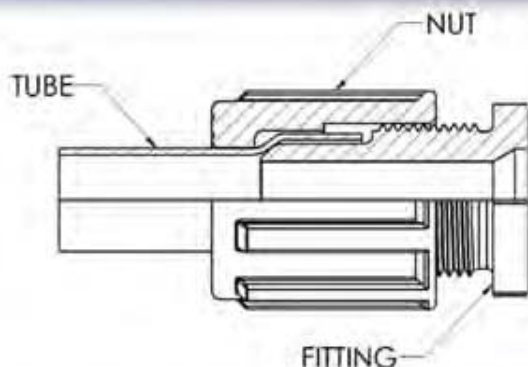
1. Cut the tube evenly with a tube cutter and insert through the non-threaded side of the nut.
2. Insert FlareLINK™ tool into the tube all the way to the shoulder of the tool.
3. Apply light pressure to the tube while holding it to the tool.
4. Expand tool 10 to 20%.
5. Relax pressure and rotate the tube, then reapply pressure.
6. Repeat steps 4 and 5 progressively increasing the pressure until the tool is completely expanded.
7. Insert the tube onto the FlareLINK™ fitting and tighten nut onto the fitting.



Using the manual flaring method is the fastest, easiest installation system available today, taking just 10 to 20 seconds to install a tube-to-fitting connection using a simple hand tool. No heating or preparation is necessary. This simple method alone can save up to 70 percent of the installation cost.



Recommended Nut Torque Setting			
Tubing Size	Wall Size	Minimum Torque (in-lb)	Maximum Torque (in-lb)
1/4	.030	6	10
1/4	.047	6	11
3/8	.030	7	10
3/8	.062	9	18
1/2	.062	12	23
3/4	.062	20	30
1	.062	30	48
1-1/4	.075	60	80



Tube O.D.	Part No.
1/4	FT-4
3/8	FT-6
1/2	FT-8
3/4	FT-12
1	FT-16

Manual Tube Flaring Tools
U.S. Patent 5,382,151