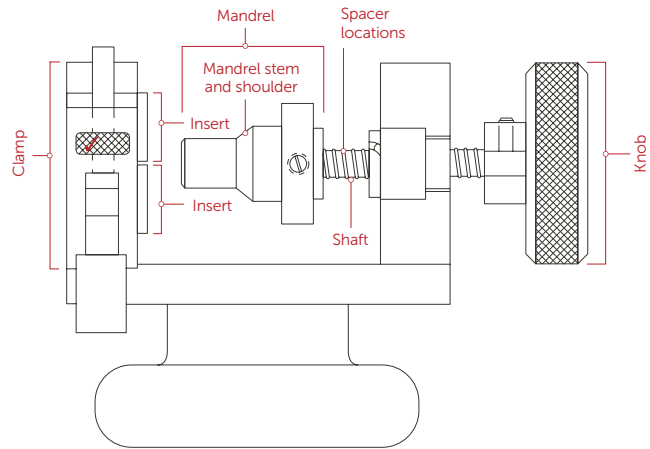


# Room Temperature Tube Flaring Tool

## Operating instructions

The Room Temperature Flaring Tool is a hand held, compact tool that does not require heat or electricity to flare the tubing. Flares are made by placing the tubing into the clamping mechanism and turning the knob. The knob moves a shaft with an attached flaring mandrel into the tube making the flare. The Room Temperature Flaring Tool weighs three pounds and is 152.0 mm x 63.5 mm (6.0" x 2.5").

**NOTE: The Room Temperature Flaring Tool is not recommended for FEP tubing. Use hot flaring tools, such as the Automatic Bench Top Flaring Tool (213-95) or the Handheld Heating Tool (213-79).**



## OPERATING INSTRUCTIONS

1. Open the clamp.
2. Select the appropriately sized inserts for the tubing OD. Slide each insert into the clamp slots.
3. Push the PTFE mandrel onto the shaft. The mandrel will automatically snap into place. Tighten plastic screws on mandrel.

**NOTE: When flaring 1/4" OD tubing, place spacer onto the shaft behind the PTFE mandrel. This prevents the tubing from moving out of position while being flared. The 1/4" OD tubing is the only size that requires a spacer.**

4. Turn the knob counterclockwise until fully retracted.
5. Insert tubing through the clamp and onto the mandrel until the tubing has reached the sloped surface on the PTFE mandrel.
6. Swing the clamp mechanism over the tube and fasten.
7. Slowly turn the knob clockwise until the end of the tube contacts the shoulder of the mandrel.
8. Fully insert the flare mandrel into the tool and hold the knob for 30 seconds. Be sure that the PTFE mandrel does not back out of the tube.

9. Remove the PTFE mandrel from the tube end by rotating the knob counterclockwise.
10. Immediately place the tube on the fitting connection and apply torque per the factory specifications.

## BENCH MOUNT ASSEMBLY

1. Remove the two screws from the bottom handle grip.
2. Attach the bench mount bracket with the two screws that were removed from the bottom handle grip.
3. Slide the bench mount clamp onto the bracket and tighten the retainer screw.
4. Place the Room Temperature Flaring Tool, with the bench mount bracket, onto the work station.
5. Tighten the black knob until it is securely fastened to the work station.

## RETIGHTENING CONNECTIONS

Room temperature flared connections should be retightened using the following procedures:

### Ambient Temperature Applications

Retighten fitting connection after exposing the system to operating conditions for a minimum of one hour.

### Media Temperatures above Ambient Temperature Applications

Expose the system to operating conditions.  
Return the system to room temperature and 0 psig.  
Retighten fitting connections and return the system to operating conditions.

## TROUBLESHOOTING

Problem	Solution
Tube is slipping through the clamp.	Tighten the adjustment nut on the clamp. If tubing continues to slip, clean tubing OD and the ID clamp inserts with isopropyl alcohol.
Flared tube will not slide on a properly sized Flaretek® fitting.	The PTFE mandrel was removed from the tube end too quickly. Repeat operating instruction steps 4–10 making sure the PTFE mandrel remains inside the flared tube for the recommended amount of time.

### FOR MORE INFORMATION

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Corporate Headquarters  
129 Concord Road  
Billerica, MA 01821  
USA

Customer Service  
Tel +1 952 556 4181  
Fax +1 952 556 8022  
Toll Free 800 394 4083

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