

RUGGED. DURABLE. A LOT LIKE YOU.

Sometimes the job calls for a no-frills type of flaring tool. These bulldogs are rock-solid, compact and not afraid to be knocked around. With a cast steel yoke, hardened flaring bar and steel wing nuts, you can guarantee these guys will get the job done. Just be sure to use hilmor flaring tools on soft tubing materials such as copper, aluminum, brass and steel.

Flaring Instructions:

1. Prep the tube for flaring by cutting to length and deburring the inside and outside of the tube end.
2. Place the flare nut in position on the tube.
3. Attach the flare cone to the yoke.
4. Insert the tube into the block, keeping the tube end slightly above the top of the block so there is enough material to make a flare. Tighten the wing nuts, starting with the one closest to the tube (this will help keep the tube from slipping).
5. Position the yoke over the tube, and block and rotate the yoke to lock into place. Hold in place as flare is being formed.
6. Turn the handle, making complete rotations until flare is formed and the handle cannot be turned anymore.
7. To release the tube once complete, turn the handle counterclockwise, loosen the wing nut, remove the yoke and open the block.
8. Brag.

See back side for swaging instructions .

Be sure to use hilmor swaging tools on soft tubing materials such as copper, aluminum, brass and steel.

Swaging Instructions:

1. Prep the tube for swaging by cutting to length and deburring the inside and outside of the tube end.
2. Attach the correct swage head to the yoke for the size of tube you are using.
3. Place the tube in the block, keeping the tube end about 1.5 times the diameter of the tube above the top of the block so that there is enough material to make a swage (Ex.: 1/4" tube should be 3/8" above the top of the block).
4. Tighten the wing nuts on the block, starting with the one closest to the tube (this will help keep the tube from slipping).
5. Position the yoke over the tube and block, and rotate yoke to lock the yoke into place. Hold in place while swage is made.
6. Turn the handle a few times to form a quality swage.
7. To release the tube once complete, turn the handle counterclockwise, loosen the wing nut, remove the yoke and open the block.
8. Stop, and stare.