



ATD-5464 Bubble (I.S.O.) Flaring Tool Kit

This tool is designed for metric soft steel brake lines where an "ISO" or bubble style flare is required.

Contents:

Flaring Bar
Forged Steel Yoke
Gauge/Wrench
Flaring adapters for 4.75mm (3/16"), 6mm, 8mm & 10mm tubing



Instructions:

1. Carefully make a square cut on the tubing end to be flared, deburr the inside of the tubing and then chamfer the outside of the tubing.
2. Insert tubing in correct hole of the flaring bar. Place the adapter wrench on the surface of the flaring bar with the notch in the wrench over the tubing end. Position the tubing so the end of the tubing is flush with the top of the notch. (See figure 1)
3. Tighten wing nuts securely, starting with the wing nut closest to the tubing. Select the adapter that fits the tubing, screw the adapter into the forcing screw, and tighten the adapter with the wrench. (See figure 2)
4. Place the yolk assembly over the flaring bar. Line up the center of the adapter with the center of the tubing. Tighten the forcing screw until the adapter rests on the flaring bar. (See figure 3)
5. Loosen the forcing screw and remove the yolk assembly. The bubble flare is complete.

