



PROFESSIONAL BRAKE LINE FLARING TOOL

OPERATOR'S MANUAL

Get to Know Your Double Flaring Tool

The ARES Professional Brake Line Flaring Tool features 4 dies for tubing between 3/16" and 3/8" and a convenient storage case so you'll have everything you need for flaring jobs in one place. With a T-handle screw clamp that keeps the selected die and tubing securely in place when used in conjunction with a vise, this tool is designed to create 45-degree double, bubble, and single flares quickly and easily. Whether working on steel, stainless steel, copper, or aluminum brake line, transmission cooler line, or fuel line tubing, this set has you covered.

Set Includes:

- Professional flaring tool
- 3/16" die
- 1/4" die
- 5/16" die
- 3/8" die
- Convenient storage case

Adapters also cover sizes 4.8mm - 9.525mm.



NEED HELP?

(800) 340-1442

www.arestool.com

customerservice@arestool.com

Don't forget to register your product!

Preparing Tube for Flaring:

Read these instructions carefully before using this Professional Brake Line Flaring Tool.

1. Use a suitable tubing cutter to square cut the tube end.
2. Chamfer the outside and ream the inside of the tube, making sure to remove burrs and clear metal chips from the inside of the tubing. Clean the outside of tubing.
3. Lightly lubricate the end of the cut tubing with Anti-Seize Compound.
4. Place the appropriate fittings over ends of the tubing, with the flare end facing outward.

ARES**PROFESSIONAL BRAKE LINE FLARING TOOL**

Create
**45°, DOUBLE,
BUBBLE, & SINGLE
FLARES**

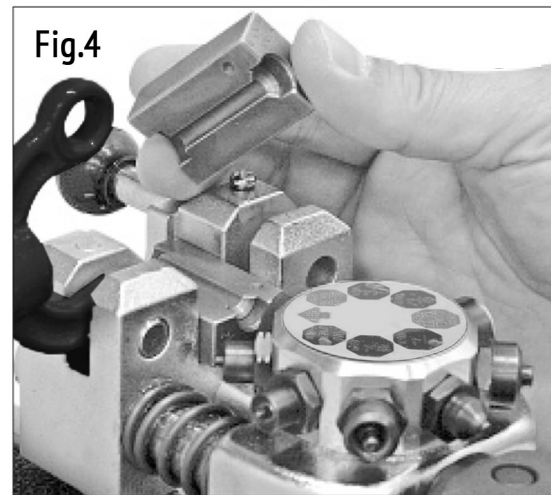
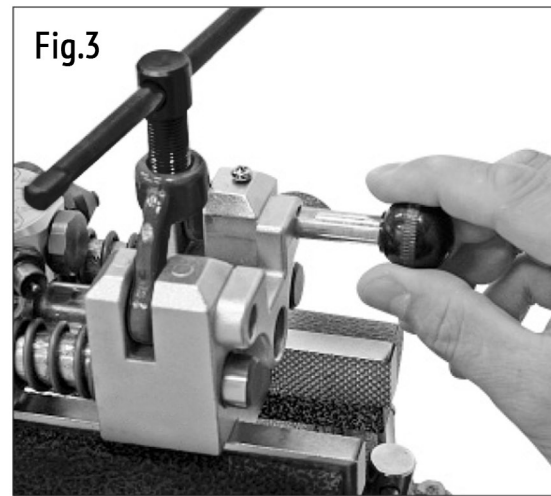
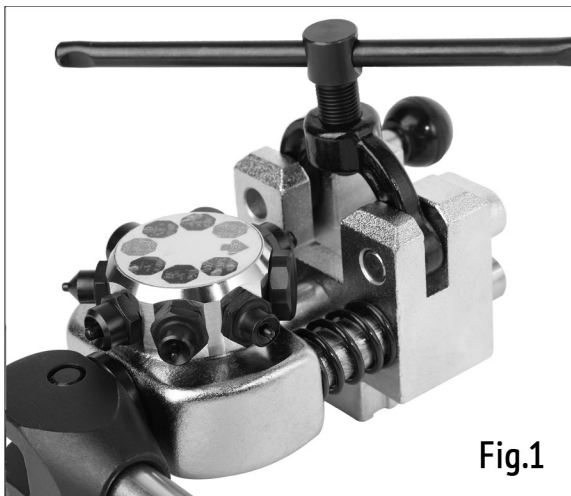
For
**STEEL, STAINLESS
STEEL, COPPER, OR
ALUMINUM**
Tubing



Before Flaring:

Read these instructions carefully before using this Professional Brake Line Flaring Tool.

1. Place the 1 1/2" x 1 1/2" square offset base of the tool (opposite the clamp) into a secure vise (Fig. 1).
2. Place the Rotating Die Head onto the 1 1/4" round boss (adjacent to the lever base). Be sure to seat the head fully and snap over the ball detent on the side (Fig. 2).
3. Place the 11" handle into the hole in the lever base. Be sure to seat the handle fully and snap the groove into the ball detent on the side of the hole.
4. Pull the Clamp Pin (with the black knob) out, releasing the clamp (Fig. 3). Rotate the clamp upward.
5. Choose the Die size that you need, and insert the die halves into the rectangular recess in the tool base with the beveled counterbore end (on which the size is stamped) positioned toward the Rotating Die Head and the back end firmly against the



Creating a Flare:

Read these instructions carefully before using this Professional Brake Line Flaring Tool.

1. Place the tube between the die halves with the tube end flush with the flared end of the Die. The Flat Faced OP.O die is a gauge used to line the end of the tube up flush with the die halves. Rotate the Die Head so that the Flat Faced OP.O die is facing the end of the tube. Move the lever inward toward the body using the OP.O die as a stop gauge (Fig. 5). Note: The tube end must be flush with the end of the die set to create a complete double flare (Fig. 6).
2. Rotate the clamp back into place. Then push the Clamp Pin through the holes and back into the tool until the black knob seats against the body of the tool.
3. Tighten the threaded retainer T-handle screw in the clamp securely against the die set (Fig. 7).
4. Spin the rotating Die Head with the appropriate size OP.1 Flaring Die lined up with the end of the tube (Fig. 8).
5. Move the lever against the tool body, exerting sufficient force to create a flare, continuing until it stops (Fig. 9). Note: At this point, a bubble flare has been created. To create a 45-degree double flare, continue with the following steps.
6. Spin the rotating die head so that one of the two appropriately sized OP.2 45 Degree Dies is lined up with the end of the tube
7. Move the lever against the tool body, exerting sufficient force to create the inverted portion of the double flare, continuing until it stops.
8. Loosen the threaded retainer T-handle screw. Then pull the clamp retaining pin and remove the split dies.
9. Remove the finished flared tube from the Die. You now have a finished, pro-quality, 45-degree double flare (Fig. 10). Note: A slight tap may be required to release it.

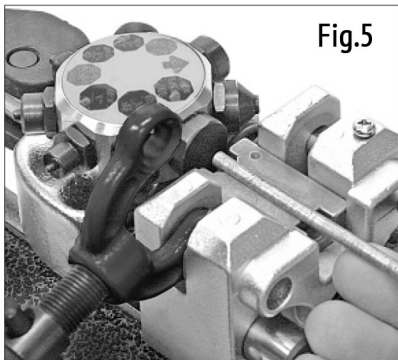


Fig.5



Fig.7

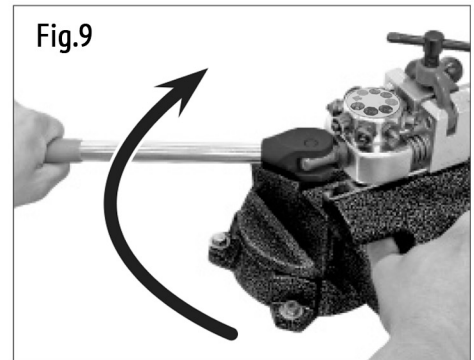


Fig.9

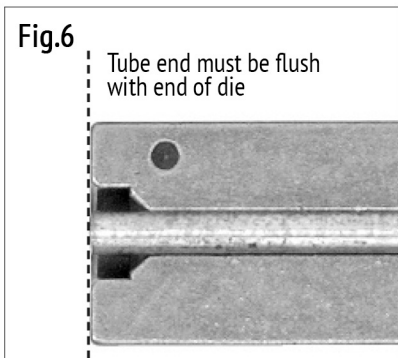


Fig.6

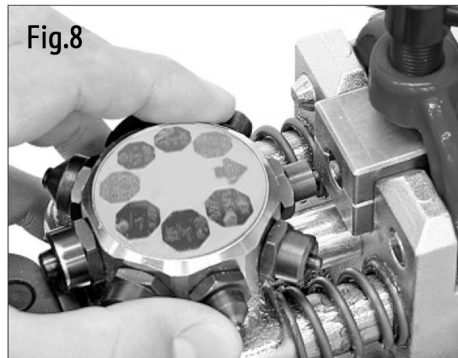


Fig.8

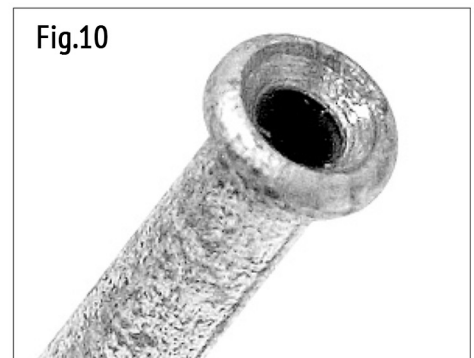


Fig.10

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Safety and Maintenance:

1. Always wear eye protection when operating this Professional Brake Line Flaring Tool, as oils, grease and metal particles may be ejected during operation.
2. Make sure that this Flaring tool is clamped securely in a vise, and keep your hands and fingers away from the tool faces in use.
3. Wear gloves while operating this tool to avoid cuts from sharp metal edges.
4. Wipe with a clean, dry cloth after each use.
5. Store in convenient carrying case to maintain best organization and condition of the tools.

You are backed by the ARES Tool Performance Assurance!

ARES TOOL warrants this product to be free from defects in materials and workmanship under normal use and service. A defective product may be returned for a free replacement within 90 days from the date of purchase, provide that product is returned immediately after discovery of defect. This warranty shall be valid only when proof of purchase (receipt) showing the date of purchase accompanies the defective product.

Exclusions:

These warranties exclude blades, bits, punches, dies, bulbs, fuses, batteries, and other consumables which must be replaced under normal use and service. These warranties shall not apply to any product or part which is used for a purpose for which it is not designed, or which has been repaired or altered in any way so as to affect adversely its performance or reliability, nor shall these warranties apply to any product or part which is subject to misuse, neglect, accident, or wear/tear incident to normal use and service.