



INSTRUCTIONS FOR
3/16" And 1/4" SAE Double Flaring Tool
MODEL NO: ST167501

IMPORTANT: PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFE OPERATIONAL REQUIREMENTS, WARNINGS & CAUTIONS. USE THE PRODUCT CORRECTLY AND WITH CARE FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE AND/OR PERSONAL INJURY AND WILL INVALIDATE THE WARRANTY. PLEASE KEEP INSTRUCTIONS SAFE FOR FUTURE USE.

ABOUT PRODUCT



This flaring tool is designed for 3/16" and 1/4" soft metal tubing (copper/aluminum/cupronickel), ideal for brake/hydraulic repairs. Not for stainless/carbon steel.

1	Flaring Tool
2	Removable Handle
3	3/16 inch (4.75mm) Positioning Bolt
4	1/4 inch (6.35mm) Positioning Bolt
5	3/16 inch (4.75mm) OP1 Punch
6	1/4 inch (6.35mm) OP1 Punch
7	S2-4mm Allen wrench
8	Die Lubricant

SAFETY & PRECAUTIONS

- 1.Wear Proper PPE:** Always wear safety glasses to protect your eyes from metal shavings or debris. Use work gloves to prevent cuts from sharp pipe edges.
- 2.Inspect the Tool & Pipe:** Ensure the flaring tool is in good condition, with no cracks or excessive wear. Check the pipe for cracks, corrosion, or deformities before flaring.
- 3.Secure the Pipe Properly:** When using a bench vise, clamp the pipe firmly but avoid over-tightening to prevent crushing. Do not let the pipe extend too far beyond the vise jaws to prevent bending or instability.
- 4.Avoid Excessive Force:** Apply steady pressure when flaring—do not force the tool, as this may damage the pipe or tool. If resistance is too high, stop and check for misalignment or pipe defects.
- 5.Deburr Pipe Ends:** Remove all burrs and sharp edges from the pipe before flaring to prevent tool damage and leaks.
- 6.Work in a Stable Environment:** If working on a vehicle, ensure the vehicle is properly supported (e.g., jack stands). On a workbench, make sure the vise is securely mounted.
- 7.Store Properly After Use:** Clean the tool and store it in a dry place to prevent rust or damage.

Warning: Never use a damaged or worn-out flaring tool, as this can lead to poor connections or tool failure.

OPERATION PREPARATION

Prepare Pipes of Corresponding Diameter

Select pipe sizes that match the flaring tool, and ensure the pipe ends have clean, straight cuts free from bends, deformations, or corrosion. If necessary, use a pipe cutter to achieve a straight edge.

Deburr the Cut Edges

If burrs remain after cutting, smooth the edges using a reamer, file, or dedicated deburring tool to prevent tool damage or compromised connection quality during flaring.

Install Fittings

Before flaring the pipe end, ensure the appropriate fitting is installed on the pipe to guarantee a secure and reliable connection.

Selecting Tool Connection Method

For mobile operations (e.g., on vehicles), keep the handle firmly attached to the tool for flexible control.

ATTENTION!

When working on a bench vise, remove the handle and secure the tool's lower section in the vise to enhance stability and efficiency.



OPERATING STEPS (FOR 1/4" / 6.35MM PIPE PROCESSING):

1.SINGLE FLARE Processing Steps:

- 1)Loosen the flaring tool's locking screw.
- 2)Screw in the positioning bolt.
- 3)Position the pipe: Ensure it is snug against the positioning bolt.
- 4)Tighten the flaring tool's locking screw.
- 5)Unscrew and remove the positioning bolt.
- 6)Apply lubricant to the convex end of the 1/4" (6.35mm) flaring punch.
- 7)Tighten the 1/4" (6.35mm) punch: Insert a hex key into the punch hole and rotate to apply force until fully tightened.Once fully secured, unscrew the punch to complete the flare.



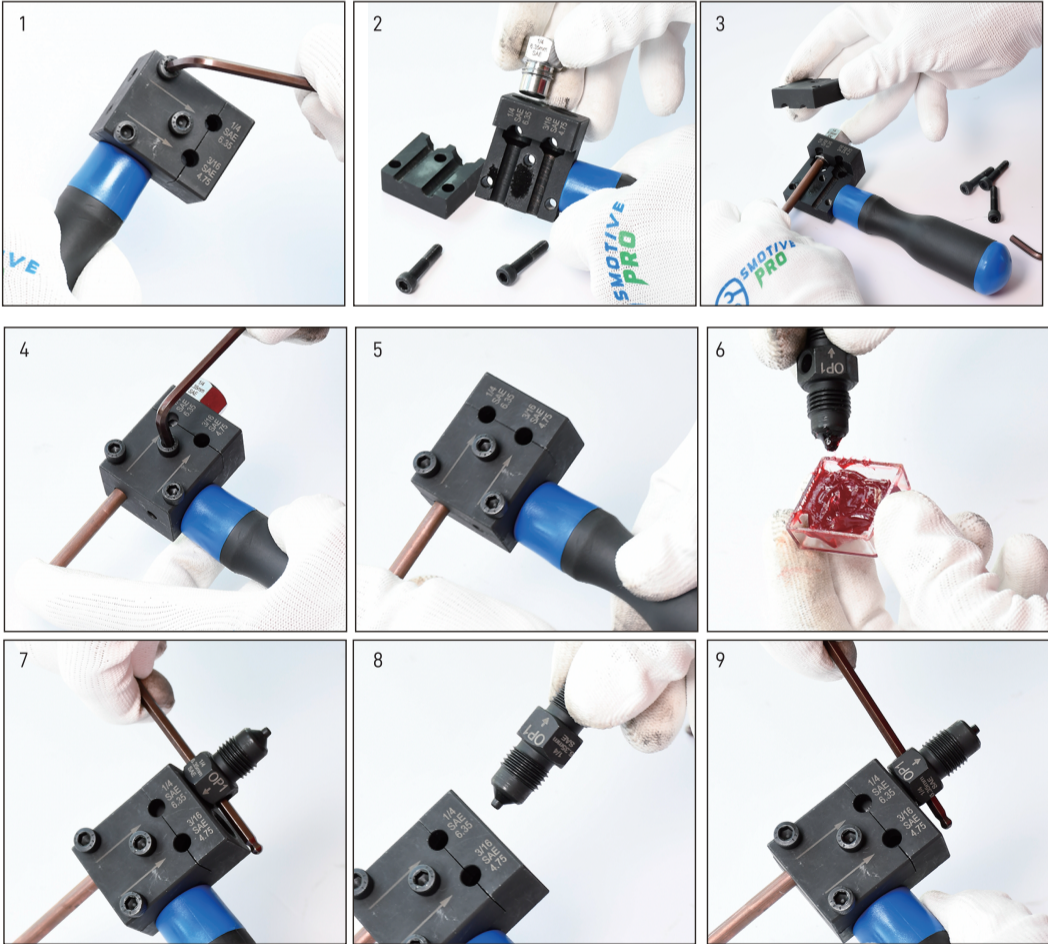
2. BUBBLE FLARE Processing Steps:

- 1)Loosen the flaring tool's locking screw.
- 2)Screw in the positioning bolt.
- 3)Position the pipe: Ensure it is flush against the positioning bolt.
- 4)Tighten the flaring tool's locking screw securely.
- 5)Unscrew and remove the positioning bolt.
- 6)Apply lubricant to the concave end of the 1/4" (6.35mm) flaring punch.
- 7)Tighten the 1/4" (6.35mm) punch: Insert a hex key into the punch's drive hole and rotate clockwise to apply gradual pressure. Continue tightening until maximum resistance is achieved (do not over-torque). Unscrew the punch to reveal the completed bubble flare.



3. DOUBLE FLARE Processing Steps:

- 1)Loosen the locking screw of the flaring tool.
- 2)Tighten the positioning bolt.
- 3)Place the pipe: the pipe should be near the positioning bolt.
- 4)Tighten the locking screw of the flaring tool.
- 5)Loosen the positioning bolt.
- 6)Apply lubricant to the concave end of the 1/4" (6.35mm) punch.
- 7)Tighten the 1/4" (6.35mm) punch: Use a hex wrench to insert into the punch hole and rotate to apply force until it is tightly secured. Then remove the punch.
- 8)Do not loosen the locking screw of the flaring tool yet. Do not remove the pipe. Instead, directly unscrew the concave end of the 1/4" (6.35mm) punch.
- 9)Flip the punch and replace it with the convex end of the 1/4" (6.35mm) punch. Rotate and tighten the punch until it can no longer be tightened to complete the process.



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