

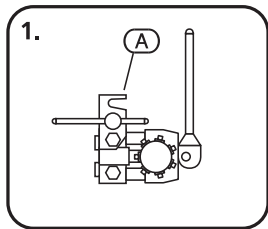


# INSTRUCTIONS FOR Brake Pipe Flaring Turret Kit

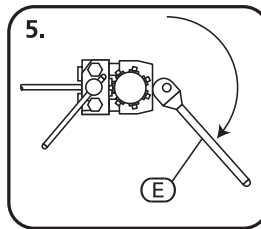
Stock No.23310

Part No.BPF/PRO/TURRET

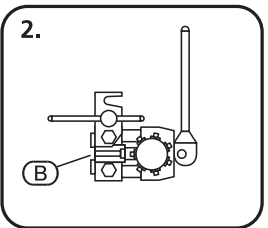
Ensure you are familiar with the various types of flares before using this equipment.



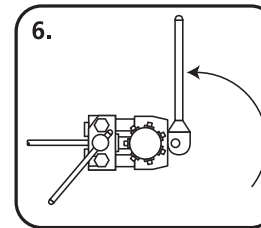
1. Clamp tool in a suitable bench mounted vice.  
Assemble the lever into the cam as shown.  
Loosen clamping screw to allow clamp (A) to swing open.



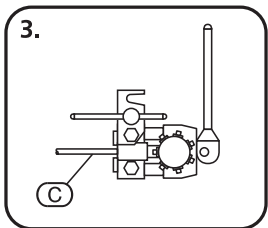
5. Pull lever (E) to engage the punch into the end of the pipe and continue until a solid resistance is felt.  
Return the lever to original position to withdraw punch.  
If the required flare calls for a second operation in chart.  
Rotate the turret until the OP.2 punch is facing and in line with pipe.  
Again operate lever to complete the form of the flare.



2. Consult chart and select die to produce required flare.  
Place die into cavity (B) as shown with split line horizontal and the counter bore towards the operating lever.

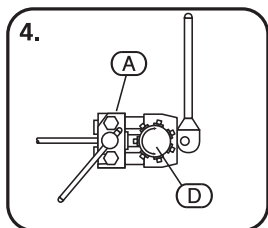


6. Return lever to the original position to withdraw the punch.  
Release the clamping screw and swing the clamp to open.  
Remove dies with pipe.  
If necessary a gentle tap on a suitable surface will release the dies from the pipe.



3. After the pipe has been prepared ensure tube nut has been fitted to pipe.  
Pass pipe (C) through the rear of the die until the prepared end is flush with the front end of die.  
Ensure that both halves of the die are contacting the die stops.

Check the quality of the flare to ensure the pipe did not move during the flaring.



4. Swing the clamp (A) into position and tighten the clamping screw.  
Recheck the dies and pipe are still correct.  
Select required OP.1 punch by rotating the turret (D) so that it is facing and in line with the pipe.

### Preparation of the Brake Pipe

- The end of the pipe must be cut square.
- The outside edge of the pipe must be chamfered approx 0.25mm at 45°.
- The bore of the pipe must be de-burred.
- If the pipe is plastic coated removed 3mm from the end of the pipe to be flared.
- Ensure the pipe is not scored or any metal removed during this operation.
- Do not use abrasive cloth.
- Blow any debris from the pipe after flaring.

SAE CONVEX			113°-117° DIN CONVEX			SAE DOUBLE			
Tube Dia.	OP.1 Punch	Die Set	Tube Dia.	OP.1 Punch	Die Set	Tube Dia.	OP.1 Punch	OP.2 Punch	Die Set
3/16"	1	4.75 - 3/16"	4.75mm	6	4.75 D	3/16"	1	7	4.75 - 3/16"
1/4"	2	1/4"	8mm	3	8mm D	1/4"	2	7	1/4"
5/16"	3	5/16"				5/16"	3	8	5/16"
3/8"	4	3/8"				3/8"	4	8	3/8"
8mm	3	8mm				4.75mm	1	7	4.75 - 3/16"
						8mm	3	8	8mm

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