



Hydra-Tool

Hydraulic Flaring And Pre-Setting Tool

Flaring

An efficient dependable device for 37° and 45° flaring of steel, stainless steel and copper tube. This task is made easy through hydraulic power provided by a hand or electric pump. The equipment is portable and easy to use.

This tool accommodates dies for tubes ranging in inch sizes from 4 through 32 (1/4" through 2" outside diameters) with wall thicknesses as great as .134", and metric sizes from 6mm through 50mm. The hydraulic "push" of the Hydra-Tool flares the tube to a 37° flare angle. A gauge can be provided to enable the operator to determine the pressure required to adequately flare any given material and wall thickness of the tube. Complete instructions are included with the Hydra-Tool. See bulletin 4392-B10. See the following for Hydra-Tool basic unit or kit, and choice of power sources and necessary tooling.

NOTE: Flaring die sets and other tooling are available in non-standard sizes upon request from the factory.

See [Appendix](#) for flaring pressures.

A video (on DVD) is included to provide instructions for proper use.

COMPONENTS REQUIRED

Part Name	Part No.
Hydra-Tool (basic unit).....	710400B
Hydra-Tool Male Adapter.....	6-8 F5OLO-S
"T" Adapter for Gauge.....	6 R6LO-S
Hose Assembly (for hand or electric pumps).....	910004
Adapter for Gauge.....	6 G6L-S
Pressure Gauge (0 - 10,000 psi).....	900044
Electric Hydraulic Pump (10,000 psi; 1/2 hp; 40-125 volt).....	900085
Hand Hydraulic Pump (10,000 psi; 2 speed).....	900086
Die Ring (1/4" - 1 1/4") (6mm - 32mm).....	710416A
Die Ring (1 1/2" - 2") (35mm - 50mm).....	710412
37° Flaring Cone (1/4" - 1 1/4") (6mm - 32mm).....	710419
37° Flaring Cone (1 1/2" - 2") (35mm - 50mm).....	710411
Die Retainer Assembly (1/4" - 1 1/4") (6mm - 32mm).....	710424-1
Die Retainer Assembly (1 1/2" - 2") (35mm - 50mm).....	710424-2
Flaring Die Sets.....	See pages S30 - S31
Lubricant.....	STP*
45° Flaring Cone (1/4" - 1").....	910312

*STP Lubricant is the only lubricant recommended for use with Hydra-Tool.

REPLACEMENT PART

Part Name	Part No.
Tube Stop Assembly.....	710420B

OPTIONAL ACCESSORIES

Part Name	Part No.
Hydra-Tool Carrying Case.....	720377
Sturdy wood case for Hydra-Tool and tooling. (Hydra-Tool kit is shipped in this carrying case.)	



Fig. S67 — Hydra-Tool



Fig. S68 — Electric Pump



Fig. S69 — Hand Pump



Fig. S70 — Flaring Cone



Fig. S71 — Die Ring



Fig. S72 — Die Retainer

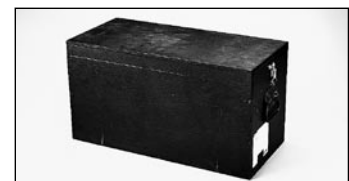


Fig. S73 — Carrying Case

Dimensions and pressures for reference only, subject to change.