



# Inch and Metric Flaring Tooling for 1025 and 1050 Parflange Machines

Tube Size O.D. x Wall Thickness (in.)	Tooling for 37°/74° Tube Flaring		Available Flaring Tooling			
	Pin Part Number	Die Part Number	1040		1025	
			-S	-SS	-S	-SS
1/4 x .020	B4004X020074	M4004074	•	•	•	•
1/4 x .028	B4004X028074	M4004074	•	•	•	•
1/4 x .035	B4004X035074	M4004074	•	•	•	•
1/4 x .049	B4004X049074	M4004074	•	•	•	•
1/4 x .065	B4004X065074	M4004074	•	•	•	•
3/8 x .020	B4006X020074	M4006074	•	•	•	•
3/8 x .028	B4006X028074	M4006074	•	•	•	•
3/8 x .035	B4006X035074	M4006074	•	•	•	•
3/8 x .049	B4006X049074	M4006074	•	•	•	•
3/8 x .065	B4006X065074	M4006074	•	•	•	•
1/2 x .028	B4008X028074	M4008074	•	•	•	•
1/2 x .035	B4008X035074	M4008074	•	•	•	•
1/2 x .049	B4008X049074	M4008074	•	•	•	•
1/2 x .065	B4008X065074	M4008074	•	•	•	•
1/2 x .083	B4008X083074	M4008074	•	•	•	•
5/8 x .035	B4010X035074	M4010074	•	•	•	•
5/8 x .049	B4010X049074	M4010074	•	•	•	•
5/8 x .065	B4010X065074	M4010074	•	•	•	•
5/8 x .083	B4010X083074	M4010074	•	•	•	•
5/8 x .095	B4010X095074	M4010074	•	•	•	•
3/4 x .035	B4012X035074	M4012074	•	•	•	•
3/4 x .049	B4012X049074	M4012074	•	•	•	•
3/4 x .065	B4012X065074	M4012074	•	•	•	•
3/4 x .083	B4012X083074	M4012074	•	•	•	•
3/4 x .095	B4012X095074	M4012074	•	•	•	•
3/4 x .109	B4012X109074	M4012074	•	•	•	•
1 x .035	B4016X035074	M4016074	•	•	•	•
1 x .049	B4016X049074	M4016074	•	•	•	•
1 x .065	B4016X065074	M4016074	•	•	•	•
1 x .083	B4016X083074	M4016074	•	•	•	•
1 x .095	B4016X095074	M4016074	•	•	•	•
1 x .109	B4016X109074	M4016074	•	•	•	•
1 x .120	B4016X120074	M4016074	•	•	•	•
1 1/4 x .049	B4020X049074	M4020074	•	•	•	•
1 1/4 x .065	B4020X065074	M4020074	•	•	•	•
1 1/4 x .083	B4020X083074	M4020074	•	•	•	•
1 1/4 x .095	B4020X095074	M4020074	•	•	•	•
1 1/4 x .109	B4020X109074	M4020074	•	•	•	•
1 1/4 x .120	B4020X120074	M4020074	•	•	•	•
1 1/2 x .065	B4024X065074	M4024074	•	•	•	•
1 1/2 x .083	B4024X083074	M4024074	•	•	•	•
1 1/2 x .095	B4024X095074	M4024074	•	•	•	•
1 1/2 x .109	B4024X109074	M4024074	•	•	•	•
1 1/2 x .120	B4024X120074	M4024074	•	•	•	•

Tooling suitable for 37°/74° flaring of steel, stainless steel, aluminum, monel, copper, and cupro-nickel tube materials. For 37°/74° flaring, one die covers each tube O.D.; a different pin is required for each tube wall. Setscrews in flaring dies may require slight adjustment for different tube materials and/or tube walls.

**Table S7 — Parflange Flaring Tooling for Inch Sizes**

Tube Size O.D. x Wall Thickness (mm)	Tooling for 37°/74° Tube Flaring		Available Flaring Tooling			
	Pin Part Number	Die Part Number	1040		1025	
			-S	-SS	-S	-SS
6 x 1	B4007406X1M	M4007406M	•	•	•	•
6 x 1.5	B4007406X1.5M	M4007406M	•	•	•	•
8 x 1	B4007408X1M	M4007408M	•	•	•	•
8 x 1.5	B4007408X1.5M	M4007408M	•	•	•	•
10 x 1	B4007410X1M	M4007410M	•	•	•	•
10 x 1.5	B4007410X1.5M	M4007410M	•	•	•	•
12 x 1.5	B4007412X1.5M	M4007412M	•	•	•	•
12 x 2	B4007412X2M	M4007412M	•	•	•	•
15 x 1.5	B4007415X1.5M	M4007415M	•	•	•	•
15 x 2	B4007415X2M	M4007415M	•	•	•	•
16 x 1.5	B4007416X1.5M	M4007416M	•	•	•	•
16 x 2	B4007416X2M	M4007416M	•	•	•	•
18 x 2	B4007418X2M	M4007418M	•	•	•	•
20 x 2	B4007420X2M	M4007420M	•	•	•	•
20 x 2.5	B4007420X2.5M	M4007420M	•	•	•	•
25 x 2	B4007425X2M	M4007425M	•	•	•	•
25 x 2.5	B4007425X2.5M	M4007425M	•	•	•	•
25 x 3	B4007425X3M	M4007425M	•	•	•	•
30 x 2.5	B4007430X2.5M	M4007430M	•	•	•	•
30 x 3	B4007430X3M	M4007430M	•	•	•	•
32 x 3	B4007432X3M	M4007432M	•	•	•	•
38 x 3	B4007438X3M	M4007438M	•	•	•	•
38 x 4	B4007438X4M	M4007438M	•	•	•	•

Tooling suitable for 37°/74° flaring of steel, stainless steel, aluminum, monel, copper, and cupro-nickel tube materials. Apply LB 2000 lube to flaring pin. Setscrews in flaring dies may require slight adjustment for different tube materials and/or tube walls.

**Table S8 — Parflange Flaring Tooling for Metric Sizes**



**Fig. S80 — Flaring Pin**



**Fig. S81 — Flaring Die**

Dimensions and pressures for reference only, subject to change.