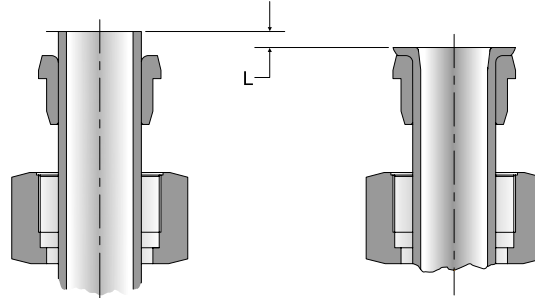


**Flanging Steps:**

1. Determine the extra cut-off length required for the Parflange process by referring to **Tables T9** and **T10**. (Each table is only a guide. Variations in tube wall thickness and inconsistency in quality of tube cut-off may affect actual dimensions. User should verify actual extra tube cut-off length with one or two flanges prior to large scale flanging.)
2. Select the proper tooling for the tube size. The tube OD, wall thickness and material must be known for proper selection. Refer to **Table S5** on page S26 for flanging capability by Parflange machine and availability of tooling

3. With the sleeve properly positioned within the die set, place the set into the die holder of the machine.
4. Insert the tube through the die opening until it comes in contact with the tube stop. Do not forget to position the tube nut over the tube in the proper orientation, especially if the other tube end has already been flanged, or the tube has sharp bends.
5. Flange the tube as shown in **Figure T16**.

**Note:** For more information on Parflange procedures, machines, etc., Contact Parker.



**Fig. T17 – Extra cut-off length**

Tube O.D. (in.)	Tube Wall Thickness – Inch										
	.028	.035	.049	.065	.083	.095	.109	.120	.134	.156	.188
1/4	3/16	13/64	5/32								
3/8		9/64**	9/64	5/32	5/32	5/32					
1/2		5/32**	9/64	9/64	9/64	9/64					
5/8			5/32	5/32	7/64	11/64	5/32	11/64			
3/4		5/32*	5/32	5/32	1/8	7/64	9/64	5/32	11/64		
1		9/64*	9/64*	9/64	9/64	7/64	11/64	11/64	316		
1 1/4					5/32	7/64	7/64	1/8	5/32	11/64	11/64
1 1/2				11/64	11/64	3/16	3/16	3/16	3/16	15/64	7/32

\*For Seal-Lok Lite only.  
\*\*For both Seal-Lok and Seal-Lok Lite.

**Table T9 – Extra tube cut-off length guide for inch tube**

Tube O.D. (in.)	Metric Tube Outside Diameter (mm)															
	6	8	10	12	14	15	16	18	20	22	25	28	30	32	35	38
1.0	4.5 11/64	5.5** 7/32	2.5** 3/32	3.5** 9/64	—	5.0 13/64										
1.5	5.5 7/32	5.0 13/64	4.0 5/32	4.5** 11/64	4.5 11/64	4.5 11/64	3.0 1/8	6.0 15/64								
2.0			3.5 9/64	4.5 11/64	6.0 15/64	5.0 13/64	3.0 1/8	5.5 7/32	4.0 5/32	6.5 1/4	4.5 11/64	6.0 15/64	5.0 13/64	—	—	5.5 7/32
2.5				4.5 11/64	5.5 7/32	5.0 13/64	3.5 9/64	6.5 1/4	4.0 5/32	7.0 9/32	4.5 11/64	7.5 19/64	5.5 7/32	—	—	—
3.0							3.0 1/8	6.0 15/64	4.0 5/32	7.0 9/32	4.5 11/64	7.0 9/32	5.0 13/64	4.0 5/32	7.0 9/32	5.0 13/64
3.5									4.0 5/32	—	4.5 11/64	—	—	—	—	—
4.0									3.5 9/64	—	4.5 11/64	—	5.5 7/32	4.0 5/32	—	5.0 13/64
5.0											4.0 5/32	—	—	—	—	5.0 13/64

\*For Seal-Lok Lite only.  
\*\*For both Seal-Lok and Seal-Lok Lite.

**Table T10 – Extra tube cut-off length guide for metric tube**

Dimensions and pressures for reference only, subject to change.