



Rolo-Flair®

Manual Rotary Flaring Tool

(For soft metal tube)

Precision burnished 37° and 45° flares in tube sizes from 2 (1/8" O.D.) to 12 (3/4" O.D.) with an easy turn of the handle. For use with copper and aluminum alloys. A depth gauge allows proper positioning of tube for consistent flaring.

HOWTO USE: Open die, insert tube up to the gauge and clamp the tube in the die. Turn drive handle clockwise to flare, then counterclockwise for retracting flaring cone. Open clamping die by loosening wing nut and remove flared tube.

Part Name	Part No.
Rolo-Flair for 37° flares (for 1/8", 3/16", 1/4", 5/16", 3/8", 1/2", 5/8", 3/4", O.D.)	212FB
Rolo-Flair for 45° flares (for 1/8", 3/16", 1/4", 5/16", 3/8", 1/2", 5/8", 3/4", O.D.)	945TH

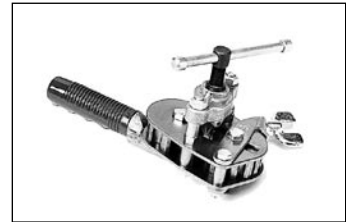


Fig. S64 — Rolo-Flair

Combination Flarer

For 1/8", 3/16", 1/4", 5/16", 3/8", 1/2", 5/8", O.D. tube.

The combination flarer is a 7-in-1 impact tool for flaring (37°) soft copper, aluminum and fully annealed steel tube, sizes 2 (1/8" O.D.) through 10 (5/8" O.D.). Maximum wall thickness: 1/8" to 3/8" is 15% of tube O.D., 1/2" and larger is 10% of tube O.D.

HOW TO USE: Insert tube into proper flare hole and fasten with clamping screw. Set hardened-steel flaring punch in tube and form flare with a few **sharp** hammer blows. (Tube should not project more than 1/16" above top of block.)

Part No.
210A



Fig. S65 — 210A Combination Flarer

Vise Block with Flaring Pin

These impact 37° flaring tools are for use with copper, aluminum alloy, and thin wall steel or stainless steel. Separate tooling set for each tube size 4 (1/4" O.D.) through 24 (1 1/2" O.D.). Maximum wall thickness: 1/8" to 3/8" is 15% of tube O.D., 1/2" and larger is 10% of tube O.D.

HOW TO USE: Clamp tube flush in matching halves of block in a bench vise. Give hardened steel flaring pin a few **sharp** blows with a hammer to form the flare.

Size	Tube O.D. (in.)	Part No.
4	1/4	4-2866
5	5/16	5-2866
6	3/8	6-2866
8	1/2	8-2866
10	5/8	10-2866
12	3/4	12-2866
14	7/8	14-2866
16	1	16-2866
20	1 1/4	20-2866
24	1 1/2	24-2866



Fig. S66 — Vise Block with Flaring Pin

Order vise block with flaring pin using part numbers above. The block and pin may be ordered separately by suffixing the part number with either Pin or Block.

Part Number Example:
4-2866 Block

Dimensions and pressures for reference only, subject to change.