

# Metric Bubble (ISO) Flaring Tool Set

- Designed for metric soft steel brake lines where an "ISO" or bubble style flare is required.
- Includes adapters for 4.75 mm (3/16"), 6 mm, 8 mm, and 10 mm tubing.

Set includes:

## Description

Yoke Assembly,

Flaring Bar

Gauge/Wrench and four Adapters: 4.75 mm (3/16"), 6 mm, 8 mm, and 10 mm



**WARNING:** Wear eye protection that meets ANSI Z87.1 and OSHA standards.

## Flaring Instructions

1. Carefully make a square cut on the tubing end to be flared, deburr inside of tubing, and then chamfer outside of tubing.
2. Insert tubing into correct size hole on flaring bar. Place the adapter wrench on the surface of the flaring bar with the notch in the wrench over the tubing end. Position the tubing so the end of the tubing is flush with the top of the notch (see Figure 1).
3. Tighten wing nuts securely, starting with the wing nut nearest the tubing. Select the adapter that fits the tubing, screw the adapter into the forcing screw, tighten with the adapter wrench (see Figure 2).
4. Place yoke assembly over flaring bar. Line up center of adapter to center of tubing. Tighten forcing screw until the adapter rests on the flaring bar (see Figure 3).
5. Loosen the forcing screw and remove the yoke assembly. The bubble flare is complete.

