DRAPER® Expert

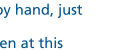
Ensure you are familiar with the various types of flare before using this equipment.

Preparation of the brake pipe

The end of the pipe must be cut square.
The outside edge of the pipe must be chamfered approx 0.25mm at 45°.
The bore of the pipe must be de-burred.
If the pipe is plastic covered, this must be cut back for 6mm from the end of the pipe to be flared.
Ensure the pipe is not scored or any metal removed during this operation.
When flaring steel pipe which has paint protection the dies and pipe must be oil & grease free for the length of the die.
If grease or any other oil gets onto the dies & pipe this can cause the pipe to slip back in the die this will not produce a perfect flare.
To safe guard against this the dies and the pipe need to be completely degreased.
Another method to resolve this problem is to remove the paint with abrasive cloth for the die length.

A spot of grease on the end of the punch is important to help the flare process.

1 The stop must be screwed into the tool to within 5mm of the hexagon.



2 Place the tool onto pipe.
3 Tighten the locking screws by hand, just enough to grip the pipe.

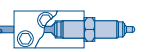
Important,do not over tighten at this stage or the stop will damage the pipe.

4 Screw the stop into the tool until fully tightened (a 16mm reversible ratchet spanner is recommended, Stock No.06624 not included).

5 Tighten the locking screws fully to clamp the pipe (a 10mm reversible ratchet spanner is recommended, Stock No.06618 not included).

Critical, if the locking screws are not tight enough then the pipe will push back during the flare process and will not produce the correct flare.

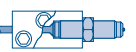
6 Undo and remove the stop.
7 Insert the OP1 end punch (I.D groove) and tighten fully up to hexagon



8 Remove the punch. The convex flare is now complete. Go to step 11

For double flare:

9 Rotate and insert the OP2 end punch and tighten fully up to hexagon



10 Remove the punch.
11 Undo the locking screws and remove the tool from the pipe.

The flare is now complete.