

## Snap-on TFM428

# Snap-on TFM428 Millimeter Size Bubble Flaring Set Instruction Manual

## 1. INTRODUCTION

This manual provides detailed instructions for the safe and effective use of the Snap-on TFM428 Millimeter Size Bubble Flaring Set. This tool is specifically designed for creating bubble flares on soft wall tubes up to 0.028 inches thick, primarily for automotive brake systems. Adherence to these instructions will ensure proper tool function and longevity.

## 2. SAFETY INFORMATION

Always observe the following safety precautions when using the Snap-on TFM428 Flaring Set:

- Wear appropriate personal protective equipment, including safety glasses, to prevent eye injury from metal shavings or fluid splashes.
- Ensure the workpiece is securely clamped before beginning any flaring operation.
- Do not use excessive force. The tool is designed for precise operation; forcing it can damage the tool or the tubing.
- Keep hands and fingers clear of moving parts during operation.
- Use the correct size adapter for the tubing to avoid improper flares or tool damage.
- Store the tool in its designated case when not in use to protect it from damage and corrosion.

## 3. PACKAGE CONTENTS

The Snap-on TFM428 Millimeter Size Bubble Flaring Set includes the following components:

- Main Flaring Tool Assembly (Yoke and Flaring Bar)
- Adapters for 4.75mm, 6mm, 8mm, and 10mm tubing
- TFM428PB Storage Case



This image displays the Snap-on TFM428 Millimeter Size Bubble Flaring Set, neatly organized within its red storage case. The set includes the main flaring tool, a yoke, and various adapters, all designed for precision brake line flaring.

## 4. SETUP

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Before beginning the flaring process, ensure your tubing is properly prepared:

1. **Cut Tubing:** Use a tubing cutter to make a clean, square cut on the end of the tube.
2. **Deburr:** Carefully deburr both the inside and outside edges of the cut tubing to remove any sharp edges or burrs. This is crucial for a proper, leak-free flare.
3. **Clean:** Ensure the tubing is clean and free of debris.

## 5. OPERATING INSTRUCTIONS

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Follow these steps to create a bubble flare:

1. **Select Flaring Bar Hole:** Open the flaring bar and select the hole that matches the diameter of your tubing (e.g., 4.75mm, 6mm, 8mm, or 10mm).
2. **Insert Tubing:** Insert the prepared tubing into the selected hole.
3. **Adjust Tubing Projection:** Position the tubing so that it extends slightly above the surface of the flaring bar. The exact projection may vary slightly depending on the desired flare height; typically, it should be just enough to allow the adapter to form the flare without bottoming out.
4. **Secure Tubing:** Close and tighten the clamps on the flaring bar to firmly hold the tubing in place. Ensure the tubing does not slip during the flaring process.

- 5. **Select Adapter:** Choose the correct adapter for the tubing size you are flaring.
- 6. **Position Yoke:** Place the yoke assembly over the flaring bar, aligning the cone of the yoke with the center of the tubing and the adapter.
- 7. **Form Flare:** Slowly turn the handle of the yoke clockwise. This will press the adapter into the tubing, gradually forming the bubble flare. Continue turning until you feel firm resistance, indicating the flare is fully formed. Do not overtighten.
- 8. **Release and Inspect:** Turn the yoke handle counter-clockwise to retract the cone. Loosen the flaring bar clamps and carefully remove the tubing. Inspect the newly formed bubble flare for uniformity, smoothness, and absence of cracks or imperfections.

## 6. MAINTENANCE

Proper maintenance ensures the longevity and performance of your flaring set:

- **Cleaning:** After each use, wipe down all components with a clean, dry cloth to remove any metal shavings, dirt, or oil.
- **Lubrication:** Periodically apply a light coat of machine oil to the threads of the yoke's screw mechanism to ensure smooth operation.
- **Storage:** Always store the flaring set in its TFM428PB storage case to protect it from dust, moisture, and physical damage.
- **Inspection:** Regularly inspect the flaring cone and adapters for wear, nicks, or damage. Damaged components can lead to improper flares and should be replaced.

## 7. TROUBLESHOOTING

If you encounter issues during flaring, consider the following:

- **Uneven Flare:** Ensure the tubing is cut squarely and deburred properly. Check that the tubing is clamped securely and not slipping. Verify the adapter is correctly centered.
- **Cracked Flare:** This can be caused by insufficient deburring, using too much force, or cold tubing. Ensure tubing is at room temperature.
- **Leaking Flare:** Often due to an improperly formed flare, burrs, or dirt. Re-cut and re-flare the tubing, ensuring cleanliness and proper technique.
- **Difficulty Turning Yoke Handle:** Lubricate the yoke's screw threads. Ensure the tubing is not over-projecting from the flaring bar.

## 8. SPECIFICATIONS

Feature	Specification
Model Number	TFM428
Flaring Type	Bubble Flare
Compatible Tube Thickness	Up to 0.028 inches (soft wall tubes)
Included Adapters	4.75mm, 6mm, 8mm, 10mm



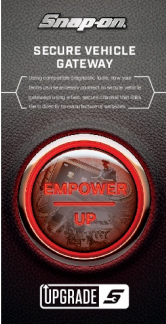
Package Dimensions	43 x 22 x 16 cm
Item Weight	500 g

## 9. WARRANTY AND SUPPORT

Please note the following regarding warranty and support for this product:

- As this is a parallel import product, a guarantee from an authorized domestic distributor is not offered.
- The product and its consumables are not covered under warranty, except for defects identified in new products at the time of purchase.

### Related Documents - TFM428

	<p><a href="#">ETHOS ZEESC312J User Manual - Snap-on Diagnostics</a></p> <p>User manual for the Snap-on ETHOS ZEESC312J automotive diagnostic scan tool. This guide provides detailed instructions on operation, maintenance, and troubleshooting for professional technicians.</p>
	<p><a href="#">Snap-on Torque Tools: Precision, Accuracy, and Durability</a></p> <p>Discover Snap-on's extensive catalog of professional torque tools, including advanced torque wrenches, drivers, testers, and multipliers designed for precision, accuracy, and lasting performance in demanding applications.</p>
	<p><a href="#">Snap-on Secure Vehicle Gateway: Account Creation and Usage Guide</a></p> <p>A comprehensive guide to setting up and using the Snap-on Secure Vehicle Gateway, detailing account creation steps for AutoAuth and Snap-on Profile Manager for seamless vehicle diagnostics.</p>



SAFETY INFORMATION

### [ShopStream Connect User Manual by Snap-on - Software for Diagnostic Tools](#)

This user manual provides comprehensive instructions for installing, connecting, operating, and managing data with Snap-on's ShopStream Connect PC-based diagnostic software. Learn about software updates, file transfers, and compatibility with various Snap-on diagnostic tools.



### [Snap-on Industrial Torque Range: Wrenches, Testers, and Calibrators](#)

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### [Snap-on Software Upgrade 18.4 Vehicle Coverage Guide - North America](#)

Snap-on's Software Upgrade 18.4 guide details expanded vehicle coverage and new features like Intelligent Diagnostics, SureTrack, and Pre-scan/Post-scan reports for professional automotive technicians. Compatible with Apollo D8, MODIS Edge, MODIS Ultra, SOLUS Edge, ZEUS, VERUS, and VERDICT diagnostic tools.