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JEGS 80087

JEGS 45 Degree Double Flare Tool

Model: 80087

Product Overview

The JEGS 45 Degree Double Flare Tool is designed for creating precise double flares on various types of tubing, including stainless steel, steel, aluminum, and 0.040" copper tubing. This tool is essential for automotive and other applications requiring secure, leak-free connections in fluid lines.

The kit includes a lever-lock flaring bar, a floating cone yoke assembly, and multiple dies to accommodate common tubing sizes. Its robust construction ensures durability and accuracy for professional and DIY use.

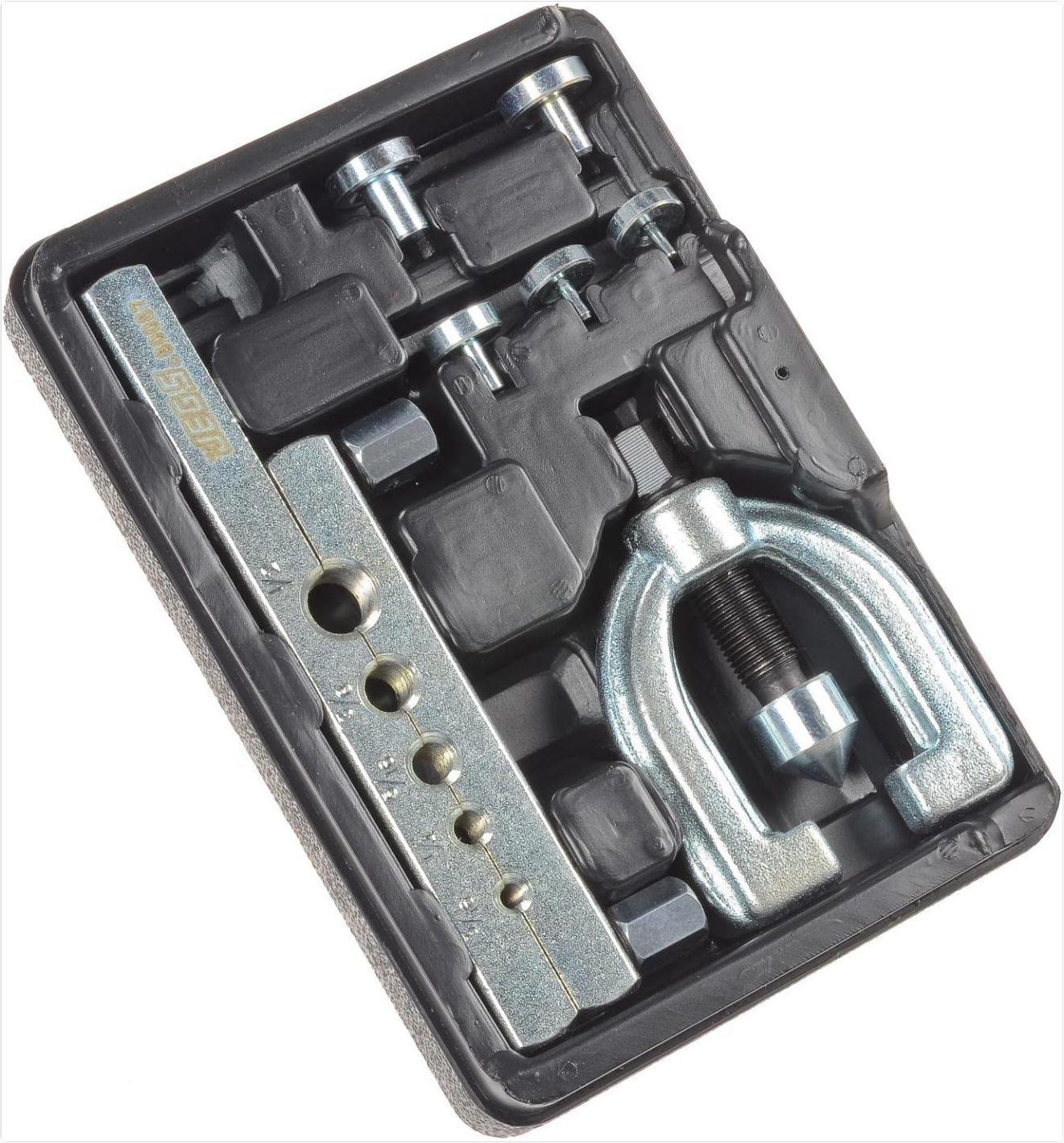

Figure 1: The JEGS 45 Degree Double Flare Tool kit, showcasing the flaring bar, yoke assembly, and various dies within its storage tray.

Kit Contents

- Lever-Lock Flaring Bar (for tubing sizes: 3/16", 1/4", 5/16", 3/8", 1/2" O.D.)
- Yoke Assembly with Floating Cone
- Multiple Dies for Double Flaring
- Storage Tray
- Instruction Manual

Setup and Preparation

1. **Inspect Components:** Before use, ensure all components of the flare tool kit are present and free from damage.

2. **Prepare Tubing:**
    - Cut the tubing to the desired length using a tubing cutter, ensuring a clean, square cut.
    - Deburr both the inside and outside edges of the tubing end. A clean, burr-free edge is critical for a proper flare.
    - Clean the tubing thoroughly to remove any debris or metal shavings.
3. **Select Correct Die:** Choose the appropriate die for the tubing size you are working with.

Operating Instructions: Creating a Double Flare

Follow these steps carefully to create a professional double flare:

1. **Insert Tubing into Flaring Bar:**
    - Open the lever-lock flaring bar and insert the prepared tubing into the correct size hole.
    - Position the tubing so that it extends slightly beyond the face of the flaring bar. The exact extension depends on the tubing size and the die being used. Refer to the tool's markings or specific instructions for precise measurement.
    - Securely close the lever-lock to clamp the tubing firmly in place. Ensure the tubing is straight and not angled.
2. **First Flare (Pre-Flare):**
    - Place the selected die into the end of the tubing.
    - Position the yoke assembly over the flaring bar, aligning the floating cone with the center of the die.
    - Slowly turn the handle of the yoke assembly clockwise. The floating cone will press the die into the tubing, forming the first, inverted flare.
    - Continue turning until the die bottoms out against the flaring bar. Do not overtighten.
    - Unscrew the yoke assembly and remove the die. The tubing should now have an inverted, funnel-like shape.
3. **Second Flare (Finishing Flare):**
    - Without removing the tubing from the flaring bar, reposition the yoke assembly over the flaring bar. This time, the floating cone will directly engage the inverted flare.
    - Slowly turn the handle of the yoke assembly clockwise. The floating cone will push the inverted flare back onto itself, creating the double flare.
    - Continue turning until the floating cone bottoms out against the flaring bar. This ensures a complete and uniform double flare.
    - Unscrew the yoke assembly.
4. **Remove and Inspect:**
    - Open the lever-lock flaring bar and carefully remove the flared tubing.
    - Inspect the double flare for uniformity, cracks, or imperfections. A properly formed double flare should be smooth, concentric, and free of defects.

Maintenance

- **Cleaning:** After each use, wipe down all components of the flare tool 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 assembly's screw and the moving parts of the flaring bar to ensure smooth operation and prevent corrosion.

- **Storage:** Store the tool and all its components in the provided storage tray in a clean, dry environment to protect it from dust, moisture, and damage.

Troubleshooting

Problem	Possible Cause	Solution
Uneven or Crooked Flare	Tubing not cut square; tubing not deburred; tubing not clamped straight in flaring bar; die or cone not centered.	Ensure tubing is cut square and deburred. Re-clamp tubing straight and tight. Verify die and cone alignment before tightening.
Cracked or Split Flare	Tubing material too hard for tool; tubing not properly deburred; overtightening; incorrect die used.	Confirm tubing material is compatible. Ensure tubing is thoroughly deburred. Avoid overtightening. Use the correct size die.
Flare Too Small or Too Large	Incorrect tubing extension from flaring bar; incorrect die used.	Adjust tubing extension as per instructions. Ensure the correct die is selected for the tubing size.
Tool Difficult to Operate	Lack of lubrication; debris in threads.	Clean and lubricate the yoke assembly threads and other moving parts.

Specifications

- **Model Number:** 80087
- **Flare Type:** 45 Degree Double Flare
- **Compatible Tubing Materials:** Stainless Steel, Steel, Aluminum, 0.040" Copper Tubing
- **Compatible Tubing Sizes (O.D.):** 3/16", 1/4", 5/16", 3/8", 1/2"
- **Item Weight:** Approximately 3 pounds
- **Product Dimensions:** Approximately 7.5 x 5.6 x 1.2 inches
- **Manufacturer:** JEGS

Warranty and Support

For warranty information, technical support, or replacement parts, please contact JEGS customer service directly. Refer to the contact information provided with your purchase or visit the official JEGS website.

JEGS Customer Service: Visit JEGS.com/contactus

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