

# OPERATING INSTRUCTIONS

## PUSH CONNECT, GM FUEL LINE FLARING, 45° DOUBLE FLARING, METRIC BUBBLE FLARING, GM TRANSMISSION COOLING LINE\*



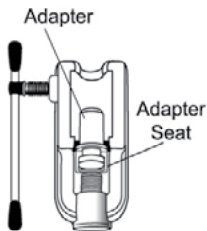
**WARNING! Wear safety goggles when using this tool.**

### PRE-OPERATION SET-UP

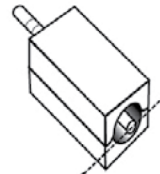
- Open the relief valve to fully recess the piston, then close tightly.
- Rotate the yoke fully counter-clockwise to bottom out the adapter seat.

### PUSH CONNECT, GM FUEL LINE FLARING, GM TRANSMISSION COOLING LINE INSTRUCTIONS

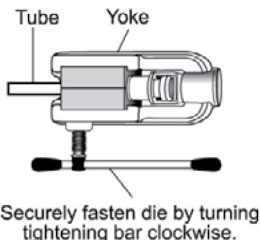
- 1) Rotate the yoke fully counter-clockwise.  
Place the adapter onto the adapter seat on  
the end of the piston.



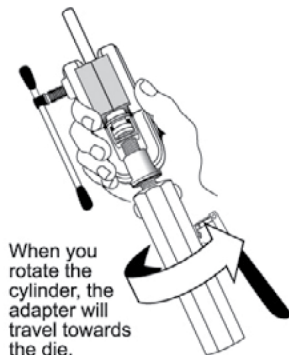
- 2) Insert the tube between the dies so it is  
even with the edge as shown.



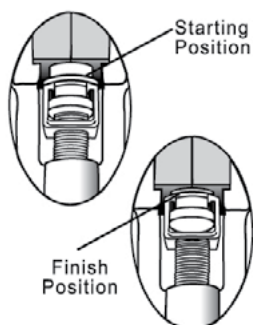
- 3) Insert dies and tubing into the yoke using  
the stabilizing lever. Make sure die and  
tube are level prior to tightening.  
**(important to securely fasten  
before moving on to step #4)**



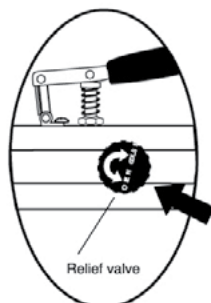
- 4) Grasp the yoke and rotate the hydraulic  
cylinder clockwise until it stops.  
(The adapter should engage the die.)



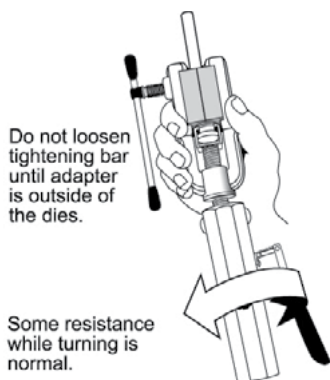
- 5) Begin squeezing the lever and continue until the edge of the adapter meets the die or pumping action shows substantial resistance.



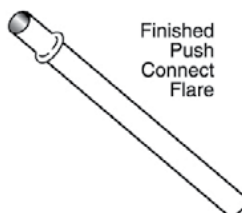
- 6) Release the pressure by opening the relief valve.



- 7) Grasp the yoke and rotate the tool counter-clockwise to remove the adapter from the die.

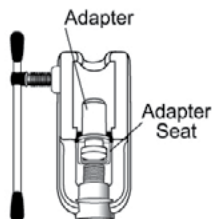


- 8) Loosen the tightening bar and remove the tube. It should look something like the sketch below.



## 45° DOUBLE FLARING AND METRIC BUBBLE FLARING INSTRUCTIONS

- 1) Rotate the yoke fully counter-clockwise. Place the MALE adapter onto the adapter seat on the end of the piston.

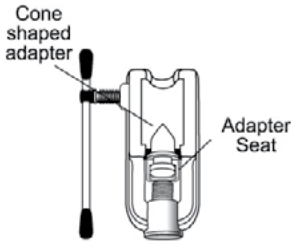


**\*Remember to use the correct die set.**

- 2) Follow steps 2-7 of push connect flaring instructions.

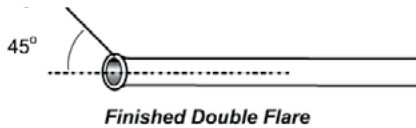
If forming 45° double flares continue to step 3. If forming metric bubble flare, loosen "T" handle and remove die blocks and tube.

3) Remove the male adapter and insert the cone shaped adapter onto the adapter seat.



4) Follow steps 4-7 of push connect flaring instructions.

5) Loosen the tightening bar and remove tube. It should look something like the sketch below.



## TROUBLESHOOTING

**The piston does not seem to advance when the lever is pushed.**

- Close the relief valve.
- The hydraulic fluid is too cold. Close the relief valve and pump the lever several times to warm the oil.

**The push connect flare does not seem to be formed correctly.**

- After the tubing is positioned in the tool the yoke must be rotated into the die before one begins to squeeze the lever.
- The tightening bar must be very tight.

**The tubing is stuck inside the adapter.**

- After flaring, you must rotate the yoke counter-clockwise to pull the adapter out of the tubing. This must be done prior to releasing the tightening bar and attempting to remove the tubing.

## REPLACEMENT PARTS

Part #	Description	Part #	Description
<b>71202</b>	Hydra-Flare Assembly	<b>71097-01</b>	45° Flaring Cone
<b>72485-PB</b>	Plastic Box for 72475		
<b>Push Connect Adapter Die Sets</b>			
<b>71205</b>	5/16" Push Connect Adapter	<b>71215</b>	5/16" Push Connect Die Set
<b>71206</b>	3/8" Push Connect Adapter	<b>71216</b>	3/8" Push Connect Die Set
<b>71204</b>	1/4" Push Connect Adapter	<b>71214</b>	1/4" Push Connect Die Set
<b>45° &amp; Double Flaring Adapter Die Sets</b>			
<b>71097-01</b>	45° Cone		
<b>71097-03</b>	3/16" Double Flare Adapter	<b>71097-13</b>	3/16" Double Flare Die Set
<b>71097-04</b>	1/4" Double Flare Adapter	<b>71097-14</b>	1/4" Double Flare Die Set
<b>71097-05</b>	5/16" Double Flare Adapter	<b>71097-15</b>	5/16" Double Flare Die Set
<b>71097-06</b>	3/8" Double Flare Adapter	<b>71097-16</b>	3/8" Double Flare Die Set
<b>71097-08</b>	1/2" Double Flare Adapter	<b>71097-18</b>	1/2" Double Flare Die Set
<b>GM Fuel Line Adapter Die Sets</b>			
<b>71405</b>	5/16" Adapter	<b>71415</b>	5/16" Die Set
<b>71406</b>	3/8" Adapter	<b>71416</b>	3/8" Die Set
<b>Metric Bubble Flaring Adapter Die Sets</b>			
<b>71475-4M</b>	4.75 mm Adapter	<b>71475-14M</b>	4.75 mm Die Set
<b>71475-6M</b>	6 mm Adapter	<b>71475-16M</b>	6 mm Die Set
<b>71475-8M</b>	8 mm Adapter	<b>71475-18M</b>	8 mm Die Set
<b>71475-10M</b>	10 mm Adapter	<b>71475-110M</b>	10 mm Die Set
<b>GM Transmission Cooling Line Adapter Die Sets</b>			
<b>71099-06</b>	3/8" Adapter	<b>71099-16</b>	3/8" Die Set
<b>71099-08</b>	1/2" Adapter	<b>71099-18</b>	1/2" Die Set

Technical Assistance: Please call 1-888-825-6989

\*Please note these instructions cover all dies and adapters available.  
Your model may not include all of the dies and adapters listed.

WARNING: This product contains one or more chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.