



Instructions for: PIPE FLARING KIT

Models: AK505 & AK506.V2

Thank you for purchasing a Sealey Product. Manufactured to a high standard this product will, if used according to these instructions and properly maintained, give you years of trouble free performance.



IMPORTANT: PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFE OPERATIONAL REQUIREMENTS, WARNINGS AND CAUTIONS. USE THIS PRODUCT CORRECTLY AND WITH CARE FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE AND/OR PERSONAL INJURY AND WILL INVALIDATE THE WARRANTY. PLEASE KEEP INSTRUCTIONS SAFE FOR FUTURE USE.

1. SAFETY INSTRUCTIONS

1.1. GENERAL SAFETY

- WARNING!** Ensure Health & Safety, local authority and general workshop practice requirements are adhered to when using this equipment.
- ✓ Familiarise yourself with the application and limitations, as well as the potential hazards, of the kit.
- ✓ This kit is suitable for flaring copper, brass or thin walled aluminium pipe. **DO NOT** use for flaring steel pipe.
- ✓ Maintain the kit in good condition (use an authorised service agent).
- ✓ Replace or repair damaged parts. *Use genuine parts only. Unauthorised parts may be dangerous and will invalidate the warranty.*
- ✓ Locate the flaring tools in a suitable work area. Keep the area clean and tidy and ensure there is adequate lighting.
- WARNING!** Always wear approved eye or face protection when using the flaring tools.
- ✓ Keep children and unauthorised persons away from the work area.
- ✓ Secure pipe clamp in a vice.
- x **DO NOT** use the kit for any purpose other than for which it is designed.
- x **DO NOT** use the kit if any parts are damaged or missing as this may cause failure and/or personal injury.
- x **DO NOT** allow untrained persons to use the kit.
- x **DO NOT** attempt to flare piping when you are tired or under the influence of alcohol, drugs or intoxicating medication.
- ✓ When not in use clean kit components, replace in case and store in a safe, dry, childproof area.

Remember! The safe operation of a vehicle, or other equipment, may well depend on the quality of the flare produced. Discard any flare which is malformed.

2. CONTENT

Check the content of the kit against the list below. If any item is missing or damaged, contact your supplier immediately.

2.1. AK505

- Pipe Clamp
- Flare Press, 45°
- Flare Dies - 3/16", 1/4", 5/16", 3/8", 7/16", 1/2", 5/8"

AK506.V2

- Pipe Clamp
- Flare Press, 45°
- Flare Dies - 3/16", 1/4", 5/16", 3/8", 7/16", 1/2", 5/8"
- Pipe Cutter with De-burring Blade

3. OPERATING INSTRUCTIONS

- WARNING!** Before using the flaring kit ensure that you have read and understood the Safety Instructions in Section 1.
- 3.1. The pipe end to be flared must be cut clean and square and be de-burred. Use pipe cutter supplied in AK506.V2 kit or Sealey model number: AK5051, if using kit AK505.
- 3.2. Mount the pipe clamp in a vice by the end 'A' (fig.1). Check that the wing nuts 'B' are accessible and can be turned and that the pipe clamp hole chamfers (and sizes) are uppermost.
- 3.3. Slacken the wing nuts 'B' and insert the prepared end of the tube - with flare nut 'C' (fig.1) fitted - up through the appropriately sized clamp hole. Adjust the protrusion of the pipe so that 'X' (fig.2) is between 1/8" to 3/16" depending on pipe size - the larger the pipe the greater 'X'. Tighten wing nuts.
- 3.4. Place the appropriately sized die in the pipe end and then fit the flare press 'D' (fig.1) onto the clamp and over the die.
- 3.5. Screw down press, and therefore die, until the 'single' flare is formed (fig.3). Remove press and die and check that flare is symmetrically formed.
- 3.6. To produce a 'double' flare, proceed as above to 3.5. Then remove die and screw press down into 'single' flare. This will compress top section ('E' fig.3) of 'single' flare into base of flare to produce a 'double' flare (fig.4). Again, check that flare is symmetrically formed.

