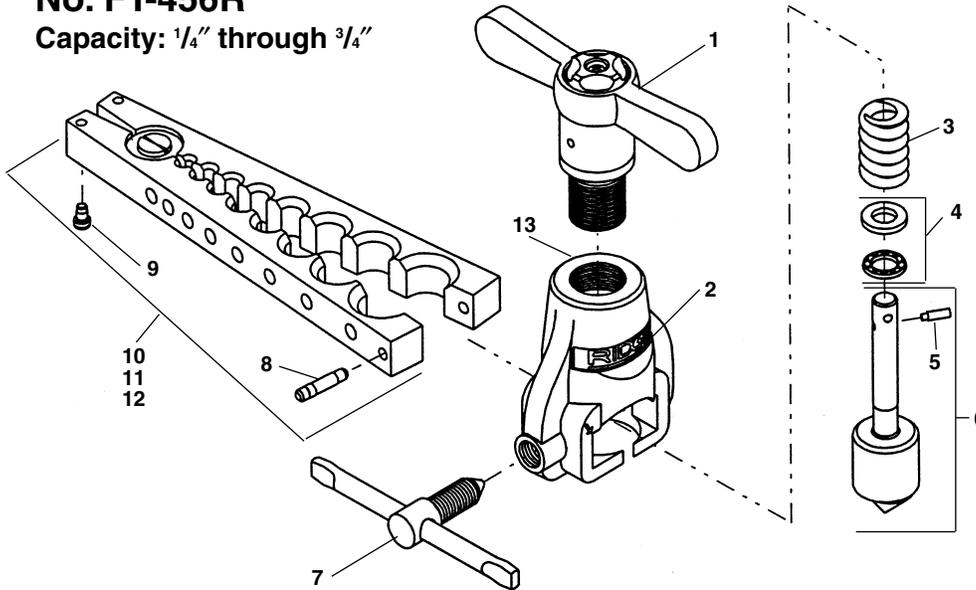


No. 458R

Capacity: 1/8" through 3/4"

No. FT-456R

Capacity: 1/4" through 3/4"

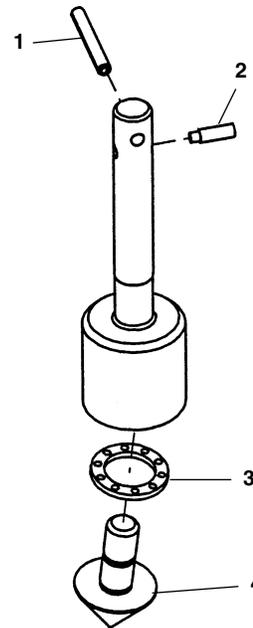
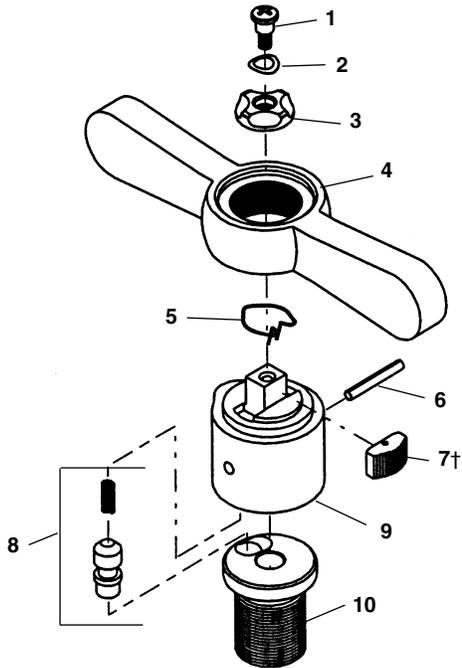


NOTE: Order parts by Catalog Number only. DO NOT order by Reference Number.

Ref. No.	Catalog No.	Description
—	70677	FT 456R Flare Tool F/Japan
—	83037	458R Flare Tool
1	83287	Ratchet Head Assembly
2	39722	Yoke Assembly
3	41485	Feed Spring
4	41520	Bearing Assembly
5	41505	Plunger Pin
6	41475	45° Shaft Assembly
7	41515	Clamp Screw Assembly
8	41455	Locating Pin
9	41450	Stop Pin
10	83282	FT 456R Flaring Bar Assembly
11	39727	458R Flaring Bar Assembly
12	50267	458mm Flaring Bar Assembly
13	76612	Plastic Washer - FT 456R

Ratchet Head Assembly

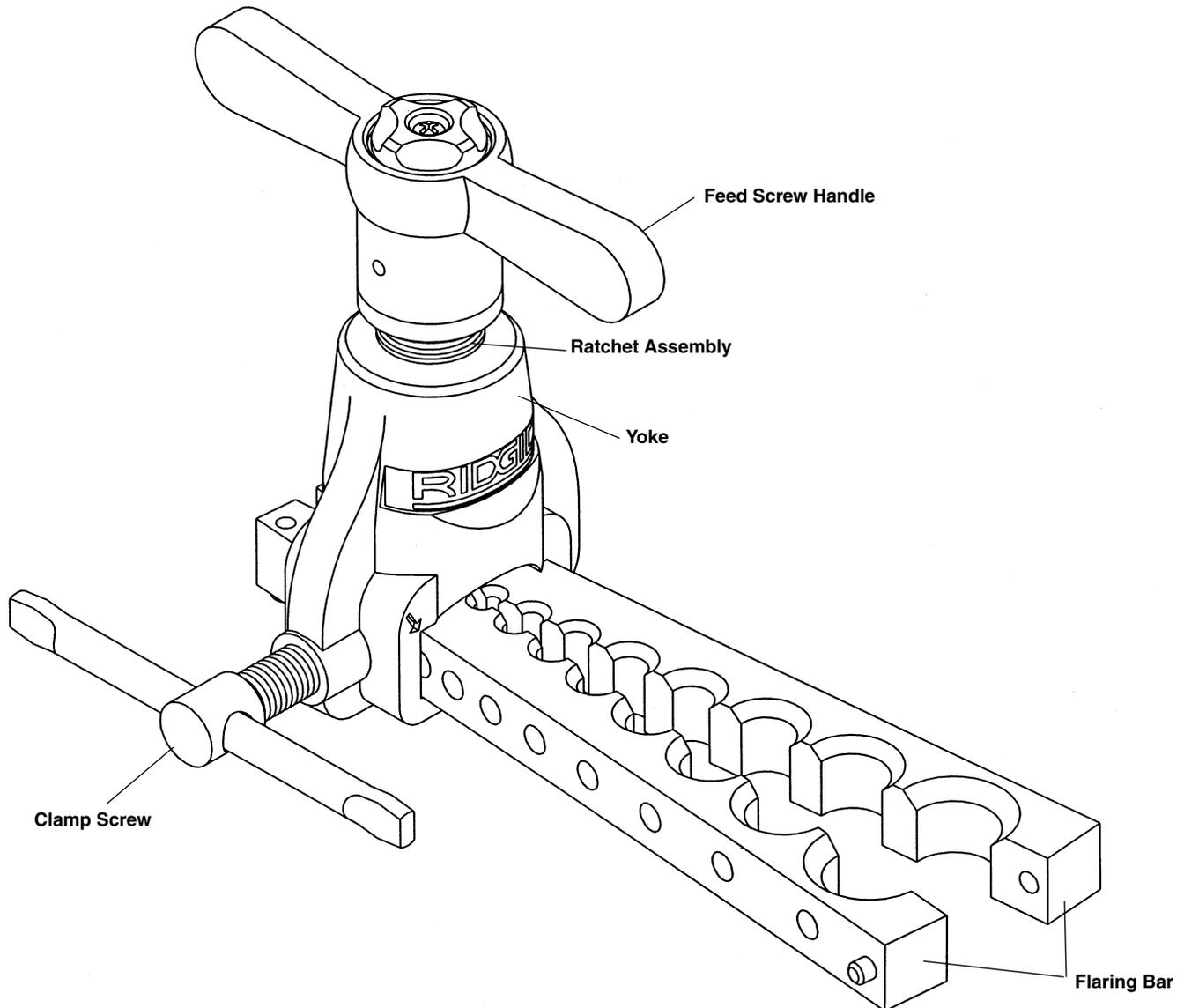
45° Shaft Assembly



Ref. No.	Catalog No.	Description
—	83287	Ratchet Head Assembly
1	83232	Screw
2	83237	Wave Spring Washer
3	83242	Reversing Cap Assembly
4	83247	Ratchet Handle Assembly
5	95347	Pawl Spring
6	34400	Spring Pin
7†	83257	Pawl with Pawl Spring
8	83267	Square End Plunger Assembly
9	83262	Ratchet Adapter
10	83272	Ramp Style Feed Screw

Ref. No.	Catalog No.	Description
—	41475	45° Shaft Assembly
1	34400	Spring Pin
2	41505	Plunger Pin
3	41470	Thrust Bearing
4	41460	45° Cone

† Ref. 7 – Position Pawl with Dimple Side Up



Operating Instructions

1. Cut and ream tubing.
2. Back off feed screw handle and clamp screw to permit flaring bars to slide freely through yoke. Slide yoke to hinged end of flaring bars.
3. Insert tube into proper size opening and close flaring bars. Push tube up from bottom of tool until it is even with top of flaring bars.

NOTE! OVERSIZE or UNDERSIZE flares can be made by adjusting tube position slightly above or below the top of flaring bars.

4. Slide yoke forward over tube until arrow on yoke meets line on flaring bars. Tighten clamp screw firmly.
5. Ratchet the feed screw handle clockwise until pressure kick-out releases. A few additional turns before backing off will burnish flare.
6. Back off feed screw handle as far as it will go. Release clamp screw and slide yoke back. Remove tube. If tube tends to stick, tighten clamp screw against tapered end of bars. This action will force bars open.