

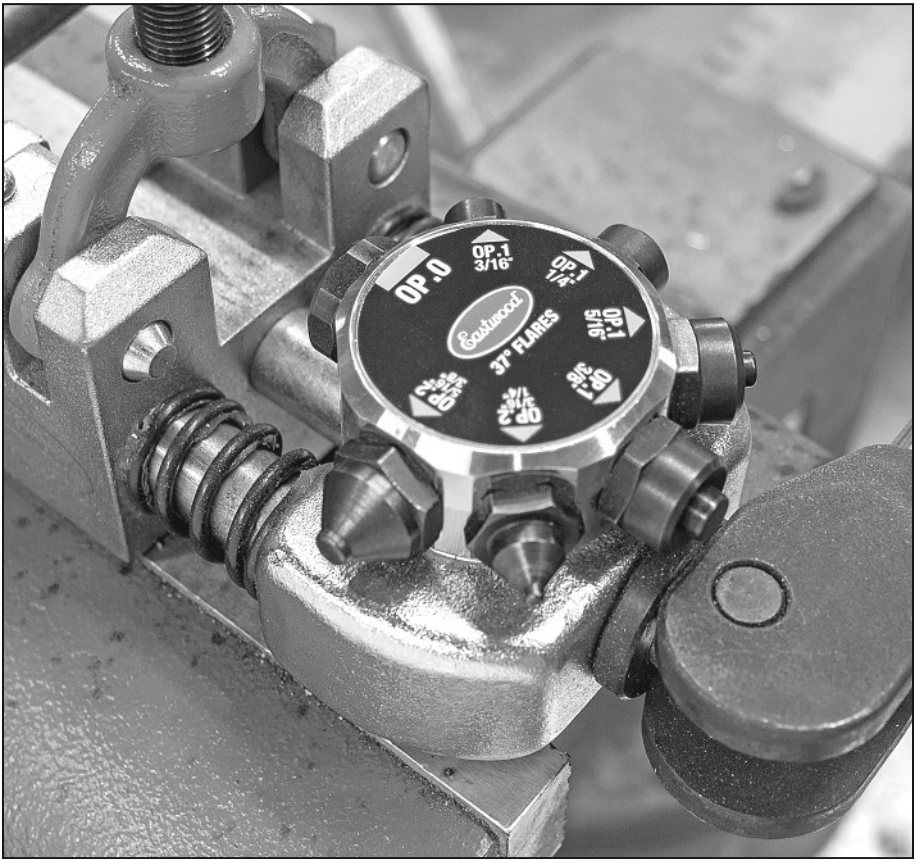
Eastwood

DO THE JOB RIGHT.

Part #30005

37°/AN/JIC DIE SET INSTRUCTIONS

For use with #25304



This kit from Eastwood allows you to use your **Eastwood Brake Tube Flaring Tool** (25304) to create 37° flares in hard lines in a variety of materials including steel, aluminum, and stainless steel. The 37° flare is used when incorporating AN fittings and JIC fittings, both of which require a 37° flare to seal. These types of fittings can be used to plumb fuel, oil, coolant, brake fluid, and other liquids in a low or high pressure.

WARNINGS

- Always wear ANSI approved eye protection when using this tool.
- Securely clamp tool in a vise that is rated for the load applied by the flaring operation.
- Always wear gloves when operating this tool to avoid cuts from sharp metal edges.
- Keep fingers and other body parts away from pinch areas on this tool while in use.

INCLUDES

- 37° Die Head
- 3/16" Die Block
- 1/4" Die Block
- 5/16" Die Block
- 3/8" Die Block



OPERATION

DETERMINE TUBING AND FITTING SIZES

It is critical to match your fitting sizes to the tubing sizes you will be using. Using the chart below you can convert your tubing size to the correct size AN fitting. The AN Sizes are derived from the tubing size based on 1/16" (ex. 3/16 tubing is sized as -3AN).

AN to Fractional Conversion Chart	
Tubing Size	AN Size
3/16"	-3
1/4"	-4
5/16"	-5
3/8"	-6

PREPARING TUBING

1. Square cut the tube end. A tubing cutter works well for this.
2. Chamfer the outside and ream the inside of the tubing to remove any burrs. Remove any metal chips from inside the tubing.
3. Wipe the exterior of the tubing clean to remove any metal chips.
4. Very lightly lubricate the end of the cut tubing with oil or anti seize compound.
5. Place appropriate fittings over the end of the tubing with the flare end facing outward.

TOOL SET UP AND OPERATION

1. Place 1-1/2" x 1-1/2" square offset base of tool (opposite the clamp) into a secure vise (Fig 1).
2. If the 45° / Brake Flare Die head is in place on the tool, remove it by simply pulling up on the block as it uses a ball detent to hold it in place. Install the 37° Die Head onto the round boss. Be sure to seat the Die Head fully and snap over the ball detent (Fig 2).
3. Place 11" foam gripped handle into hole in lever base. Be sure to seat handle fully and snap groove into ball detent on side of hole.
4. Pull Clamp Pin (black knob) out releasing clamp (Fig 3).
5. Rotate clamp upward.
6. Choose the split die size that matches the tubing you will be flaring. Insert the dies into the rectangular recess in the tool base with the sizes stamped on the die facing towards the rotating Die Head and the back end firmly against the step (Fig 4).
7. Place the tube between the die halves with the tube end flush with the flared end of the dies. The flat faced OP.0 die is a gauge used to line up the end of the tube flush with the split dies. Rotate the Die Head so that the flat faced OP.0 is facing the end of the tube. Move the lever inward toward yourself until it stops and makes the tubing flush with the split dies (Fig 5). NOTE: The tube end **MUST BE FLUSH** with the end of the die set to create a complete double flare (Fig 6).

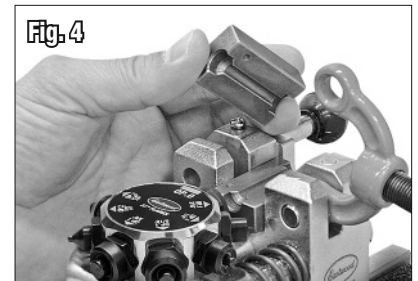
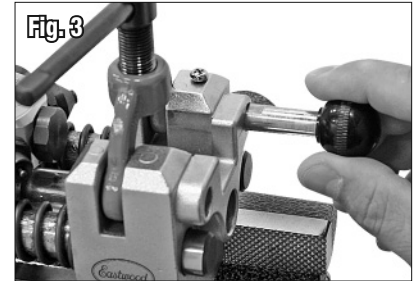
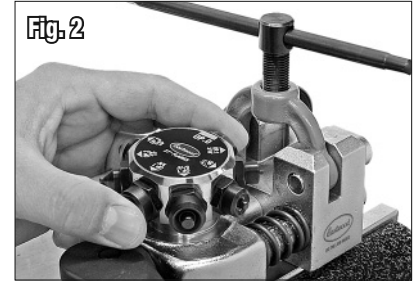
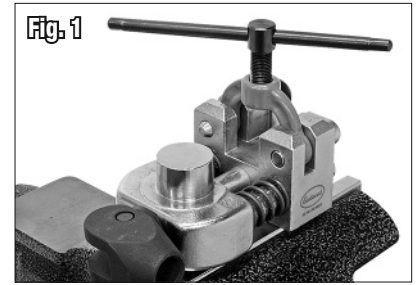
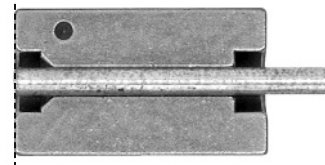
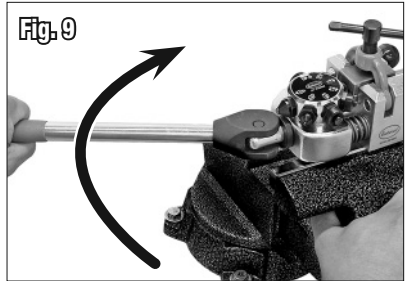


Fig. 6

Tube end must be flush with end of die



8. Rotate clamp back into place, push Clamp Pin through holes and back into the tool until the black knob seats against the body of the tool.
9. Tighten threaded retainer T Handle screw in clamp securely against the die set (Fig 7).
10. Spin rotating die head with the appropriate size OP.1 flaring die lined up with the end of the tube (Fig 8).
11. Move lever against tool body exerting sufficient force to create a flare, continuing until it stops (Fig 9).
12. Spin rotating die head with one of the two appropriate sized OP.2 dies lined up with the end of the tube.
13. Move lever against tool body exerting sufficient force to create the final step of the flare, continuing until it stops.
14. Loosen threaded retainer T handle screw, pull back the repainting pin and then remove the split dies.
15. Remove the finished flared tube from the dies. A slight tap on a hard surface may be required to release the tube from the dies.
16. Proceed to install the flared line on the application.



If you have any questions about the use of this product, please contact
 The Eastwood Technical Assistance Service Department: 800.544.5118 >> email: techhelp@eastwood.com
 PDF version of this manual is available online >> eastwood.com/30005manual
 The Eastwood Company 263 Shoemaker Road, Pottstown, PA 19464, USA
 US and Canada: 800.345.1178 Outside US: 610.718.8335
 Fax: 610.323.6268 eastwood.com