

# Flaring tools for Triple-Lok® tubes

## Flaring tool selection guide

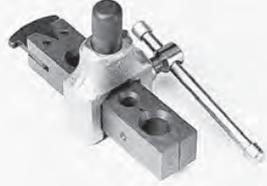
Manual flaring devices are available for on-site assembly and field repair of Triple-Lok® tube connections.

Manual flaring tools range from simple impact flarers to handpump-operated workshop devices. Flaring result and fitting performance depends strongly on the skill and effort of operator. Hand flaring tools are not recommended for efficient industrial production.

### Features, advantages and benefits of hand flaring tools

- 1. Flexible** – Manual flaring tools are portable and do not need any power supply. Therefore they are ideal for on-site assembly and field repair.
- 2. Special** – Each device has been especially developed to match Parker Triple-Lok® standards. The tube connections will fit properly without rework.

How to select the ideal flaring device for your application:

	Hand flaring tools 1004/210A	Impact flaring tool	KARRYFLARE	Parflare ECO
				
<b>Assembly method</b> Triple-Lok® O-Lok®	impact flaring not suitable	impact flaring not suitable	conventional flaring not suitable	conventional flaring not suitable
<b>Tube specification</b> Material	copper, steel	copper, steel, stainless steel	steel, stainless steel	steel, stainless steel
Dimension metric tube	6 to 16 mm (1004)	6 to 38/42 mm	6 to 38/42 mm	6 to 38/42 mm
Dimension inch tube	1/8" to 5/8" (210A)	1/4" to 1 1/2"	1/4" to 1 1/2"	1/4" to 1 1/2"
Min. U-bend	depending on vice	depending on vice	65 mm	70 mm
<b>Tools</b> Clamping dies	one device	vice block	Flaring die M15 ... (same dies used EOMAT)	Flaring die M15 ... (same dies used EOMAT)
Flaring pin	integral part of device	pin plus hammer	integral part of device	integral part of device
<b>Operation</b> Flaring	hammer impact	hammer impact	handpump	electro-hydraulic
Process control	manual	manual	pressure according to chart	pressure according to chart
Tube clamping	manual clamping	manual	automatic clamping	automatic clamping
<b>Specifications</b> Design	flaring device for use in vice	Hand tools for use in vice	portable desktop	portable desktop
Weight	approx. 1.5 kg	–	approx. 29 kg	approx. 30 kg
Dimension (WxLxH)	–	–	750x360x260 mm	750x360x300 mm
<b>Performance</b> Overall cycle time	approx. 1–3 min	approx. 1–3 min	approx. 30–60 sec.	approx. 15–20 sec.
Economic production quantity:	10 flarings per week	10 flarings per week	max. 50 flarings per day	max. 100 flarings per day
Quality	dependant on operator	dependant on operator	controlled process	controlled process
<b>Application</b>	on-site repair jobs only; Limited to small dimensions. Limited to single assemblies, not for industrial production, emergency repairs until industrial flared tube is available for replacement.		Efficient for on-site flaring of small quantities not for mass production	portable machine for repair and workshop

## Assembly tooling

### Manual flaring tools for Triple-Lok® tubes

These 37° flaring tools are for use with copper, aluminum alloy, and thin wall steel or stainless steel tubes. A vice block is clamped together with the tube end into a vice. Flaring pin is used with a hammer. Separate tooling sets for each tube size in metric and inch dimensions are available.

These hand tools are suitable for small on-site repair jobs. They are not suitable for thick-wall tubing and industrial production. A rigid vice must be available at the assembly site.

#### Features, advantages and benefits

1. **Light** – Hand flaring tools can be used at any assembly site where a proper workshop is not available
2. **Quick** – Hand flaring tools can be used for temporary repair until a proper spare tube has been made by machine

#### Applications

- Field repair of agricultural and construction vehicles
- Small, local repair workshops
- Mobile repair service

### Combination impact flarer 1004 for small dimension metric tube



#### Specifications

<b>Design:</b>	<b>Hand flaring tool for small on-site repair jobs</b>
<b>Operation:</b>	<b>Flaring pin Impact</b>
37° Flaring:	Triple-Lok® connection – ISO 8434-2/ SAE J514
Tube material:	copper, aluminum and low carbon steel
Tube diameter:	6 to 16 mm metric tube
Wall thickness:	max 15% of tube O.D.
Requirements:	Rigid vice and hammer
Performance:	Overall cycle time 1–3 min
Economic production quantity:	10 flarings per week

#### Operation

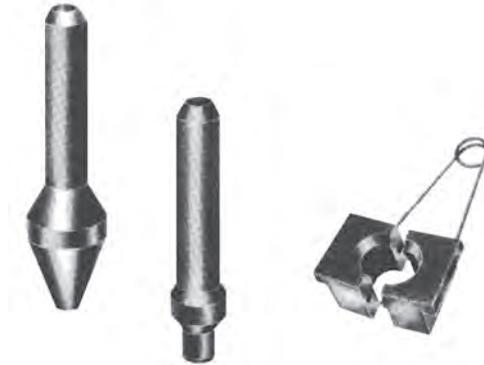
1. Clamp tube end flush in block halves
2. Clean and lubricate tube end and flaring pin
3. Form the flare by a few sharp hammer blows
4. Release vice and unclamp tube

**See chapter E for detailed instructions on Triple-Lok® assembly**

#### Ordering

Type	Order code
Combination impact flarer Complete device including Combination dies and pin	1004-74M
EO-NIROMONT Liquid lubricant in a brush-in-cap can (250 cc)	EONIROMONTAPPLICATOR

**Impact flaring tools for metric and inch tube**



**Specifications**

**Design:** Hand flaring tools for small on-site repair jobs  
**Operation:** Impact flaring pin  
**37° Flaring:** Triple-Lok® connection – ISO 8434-2/ SAE J514  
**Tube material:** copper, aluminum, steel and stainless steel tube  
**Tube diameter:** 6 to 38 mm/1/4" to 1 1/2"  
**Wall thickness:** max 15% of tube-O.D., max 10% of tube O.D. for tubes larger 20 mm tube O.D.  
**Requirements:** Rigid vice and hammer  
**Performance:** Overall cycle time 1–3 min  
**Economic production quantity:** 10 flarings per week

**Operation**

1. Clamp tube end flush in block halves
2. Clean and lubricate tube end and flaring pin
3. Form the flare by a few sharp hammer blows
4. Use pre-flaring pin for tube O.D. 20 mm/3/4" and larger
5. Release vice and unclamp tube

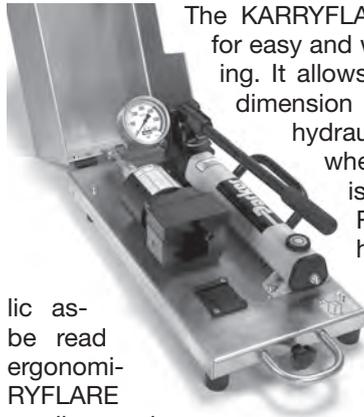
**See chapter E for detailed instructions on Triple-Lok® assembly**

Tools for metric tube			
Tube-O.D. mm	Pre-flaring pin Order code	Flaring Order code	Vice block Order code
06		P17408	M27406
08		P17408	M05742
10		P17408	M27410
12		P17414	M27412
14		P17414	M27414
15		P17414	M27415
16		P17414	M27416
18		P17418	M27418
20	P1E	P17418	M27420
22	P1E	P17422	M14742
25	P1E	P17422	M27425
30	P1E	P17432	M27430
32	P1E	P17432	M27432
38	P1E	P17438	M24742

Tools for inch tube			
Tube-O.D. inch	Pre-flaring pin Order code	Flaring Order code	Vice block Order code
1/4"		P17408	M04742
5/16"		P17408	M05742
3/8"		P17408	M06742
1/2"		P17414	M08742
5/8"		P17414	M10742
3/4"	P1E	P17418	M12742
7/8"	P1E	P17422	M14742
1"	P1E	P17422	M16742
1 1/4"	P1E	P17432	M20742
1 1/2"	P1E	P17438	M24742

Type	Order code
Tool lubricant 0.25L bottle	EONIROMONTFLUESSX

## KARRYFLARE Portable flaring device for Triple-Lok®



The KARRYFLARE is a portable device for easy and workmanlike 37° tube flaring. It allows the flaring of even large dimension steel and stainless steel hydraulic tube at assembly sites where Parflange® technology is not available. The KARRYFLARE consists of a hydraulic flaring unit and a hand pump. The hydraulic assembly pressure can be read on a gauge which is ergonomically located. The KARRYFLARE is ideal for tube flaring of small quantities and on-site tube installation.

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It is practical, simple to operate, reliable and easy to transport. The KARRYFLARE comes as one unit with all components firmly attached to a practical carrying frame.

### Technical data

Application: 37° flaring of hydraulic tube  
Flare dimensions and geometry according to ISO 8434 / SAE J514  
For Parker Triple-Lok® hydraulic fittings  
Tube outer diameter: 6 to 38 mm / ¼ to 1 ½"  
Maximum capacity: 38 x 4 mm / 1 ½ x 0.120"  
With special flaring pin up to 42 mm tube O.D.  
Tube material: steel and stainless steel  
Minimum width U-bend: 70 mm  
Weight: approx. 29 kg  
Dimensions: approx. L 750 mm x W 360 mm x H 260 mm  
Hydraulic oil: H-LP32-1.2 liter

### Ordering

KARRYFLARE device and accessories

Description	Order code
<b>KARRYFLARE</b> Manual flaring device KarryFlare including handpump, carrying case and manual tank filled with hydraulic oil, 37° flaring pin installed. Flaring dies "M15" must be ordered separately.	KARRYFLARE
<b>Accessoires</b>	
Tool lubricant 0.25L bottle	EONIROMONTFLUCESSX
EO-NIROMONT Liquid lubricant in a brush-in-cap can (250 cc)	EONIROMONTAPPLICATOR
Promotion leaflet	LEAF/4049-D1/UK/DE
<b>Spare parts</b>	
Flaring bloc, complete	KARRYFLARE/BLOC
Standard Flaring pin 6–38 mm, with O-ring	KARRYFLARE/FPIN
Special Flaring pin 42 mm, with O-ring	KARRYFLARE/FPIN42
Tube stop with guide	KARRYFLARE/TSTOPKPL
Pressure chart sticker	KARRYFLARE/CHART

### Performance

Cycle time: 30–60 sec.  
Economic production quantity: max 50 flarings per day

### Features, advantages and benefits

1. Flexible on-site tube flaring
2. Simple operation
3. KARRYFLARE is portable and does not require any power supply
4. Flaring quality is comparable to EOMAT
5. Saves time and effort compared to manual impact flaring
6. Safe and consistent result
7. All elements are ergonomically located
8. Robust, light metal transport box
9. Telescopic handle and wheels for convenient trolley transport
10. Uses "M15" flaring dies (EOMAT/1015)

### Applications

- Assembly of 37° flare fittings in small quantities
- On-site repair of agricultural vehicles and mobile construction equipment
- Repair workshops and plant maintenance
- Mobile repair service

KARRYFLARE		
 Tube-O.D. Ø [mm] - Ø [Inch]		 Triple-Lok®, P [bar]
6	1/4	35
8	5/16	45
10	3/8	60
12	1/2	60
14		80
15		100
16	5/8	100
18		120
20	3/4	160
22		160
25	1	180
28		215
30	1 1/4	230
35		270
38	1 1/2	280
42		320