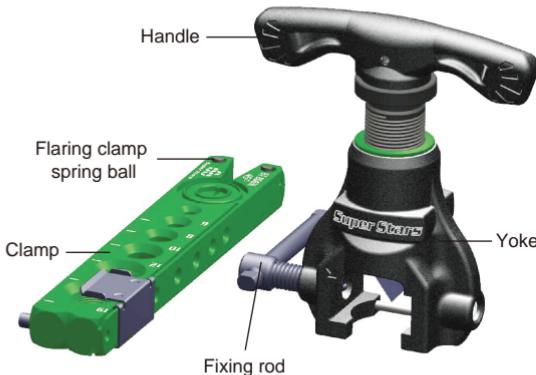


Thanks for purchasing  products. For safe and correct using, please read this user instruction carefully before using the product.



REPAIR & MAINTENANCE

1. Clean the tool after use, keep the eccentric cone clean.
2. Lubricate the fixing rod and handle with engine oil.
3. Make sure lubricate the bearing in yoke and handle connection, screws with engine oil frequently.



ITEM NO	PRODUCT NAME AND SPECIFICATION
ST-806A	For inch: 1/4", 5/16", 3/8", 1/2", 5/8", 3/4"
ST-806FT-L	ST-806+ST-532 +ST-207 For metric and inch: 1/4", 5/16", 3/8", 1/2", 5/8", 3/4" & 6,8,10,12,16,19mm
ST-809	Metric & inch: 1/4", 5/16", 3/8", 1/2", 5/8", 3/4" & 6,8,10,12,16,19mm

Range of application: suitable for soft copper tube, aluminum tube and other soft tubes.



ECCENTRIC FLARING TOOL MANUAL INSTRUCTION



**ST-806A ST-809AM
ST-806FT-L**

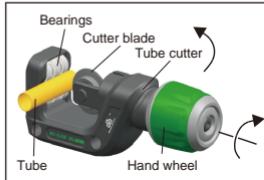
PREMIUM REFRIGERATION TOOL SERIES

Thanks for purchasing  products. For safe and correct using, please read this user instruction carefully before using the product.

USER INSTRUCTION

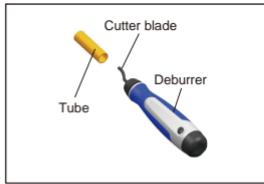
1. Prepare before making flare-cut tube

Put the tube between 2 rows of bearings on tube cutter. Forward the cutter blade by rotating the hand wheel in clockwise. When the blade touches the tube, keep rotate the hand wheel at 1/4 round to cut in the tube and then rotate cutter at 2-3 rounds. repeat rotate hand wheel at 1/4 round and then rotate cutter at 2-3 rounds until the tube is cut off.



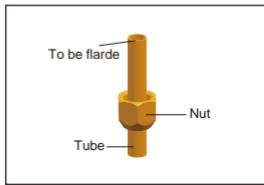
2. Prepare before making flare-deburr tube

Put the deburrer blade inside the tube and rotate it in clockwise to remove burrs on tube ends.



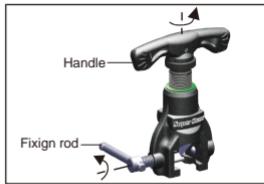
3. Prepare before making flare-put a nut on

Put a nut on tube as shown in figure.



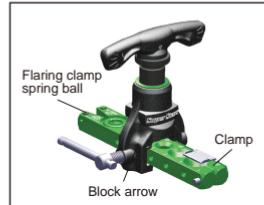
4. Prepare before making flare-rotating handle

Loose position rod before using and loose the handle up to the top, place the bar into block for flaring.



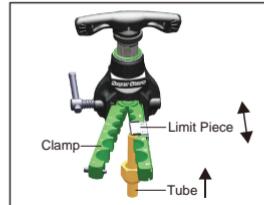
5. Prepare before making flare-install flaring bar

Insert flaring bar with spring bar into block with the hole of one end of the arrow.



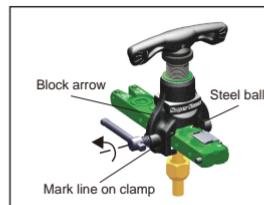
6. Prepare before making flare-put on a tube

Open the clamp, Slide the copper limit piece to required size of pipe clamping hole, put copper, make the end of the pipe touch the copper limit piece.



7. Prepare before making flare-tighten the fixing rod

Insert clamp with tube in yoke until the ball on clamp get stuck in the correct size ball fixing position. Meanwhile the yoke edge line will aim to the mark line on clamp. Then tighten the fixing rod.



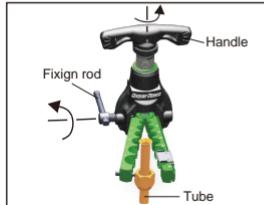
8. Making flares-rotate the handle

As shown in figure, rotate the handle in clockwise. keep rotating the handle 2-3 round after clutch is separated will make the flare more smooth and perfect.



9. Flaring work finished-remove away the tube

After flaring work finished, rotate the handle as shown in figure to retract the eccentric cone to the top. Release the fixing rod, open the clamp and take out the tube.



10. Flaring finish-Remove flaring clamp

Press spring ball of flaring clamp, meantime push and open the flaring bar, separate bar and block.

