



## FLARING TOOL

TA550 Series

### INSTRUCTION MANUAL



## TASCO JAPAN CO., LTD.

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Thank you for purchasing the TA550 series Flaring Tool.  
Please read this instruction manual carefully before use so that you can use the product properly.

TASCO JAPAN CO., LTD.

## Standards

This flaring tool complies with the new standards Class 1 and Class 2.

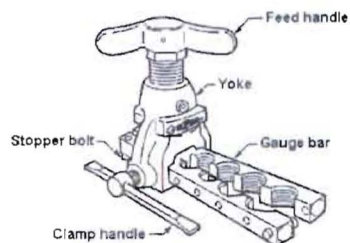
Class 1: Refers to R407C(E), R404, R507A, HFC134a and the conventional refrigerants.

Class 2: Refers to the refrigerant R410A.

## Applicable Tubes

- |                   |                                     |
|-------------------|-------------------------------------|
| 1. Type:          | annealed copper tube                |
| 2. Flaring angle: | 45° flare                           |
| 3. Sizes:         | 1/4", 5/16", 3/8", 1/2", 5/8", 3/4" |

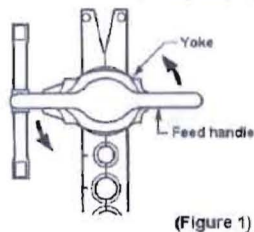
## Parts and Controls



## Flaring Procedure

### Step 1

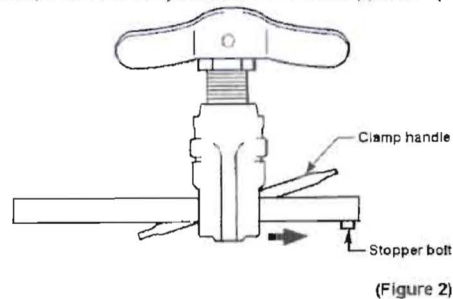
Turn the feed handle counterclockwise until it completely stops (Figure 1).



(Figure 1)

### Step 2

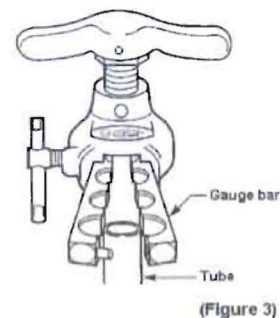
Loosen the clamp handle, and move the yoke until it hits the stopper bolt (Figure 2).



(Figure 2)

### Step 3

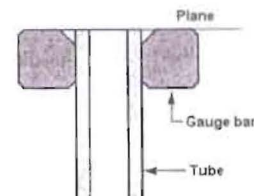
Open the gauge bar, insert the tube into the corresponding hole, and lightly hand tight the gauge bar (Figure 3).



(Figure 3)

### Step 4

Set the tube as shown in Figure 4.



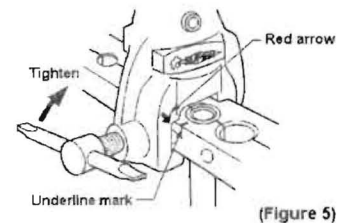
(Figure 4)

Note: Figure 4 is only an indication to meet the standard and therefore cannot always meet the standard depending on the condition of the cut surface.

After flaring the tube and before continuing the work, measure the size to check that it is within the standard.

### Step 5

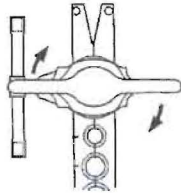
Move the yoke until it covers the tube, align the red arrow on the yoke with the underline mark on the gauge bar, and then tighten the clamp handle firmly (Figure 5).



(Figure 5)

### Step 6

Turn the feed handle clockwise until the clutch goes off (Figure 6). When the clutch goes off, the feed handle will suddenly become light.



(Figure 6)

### Step 7

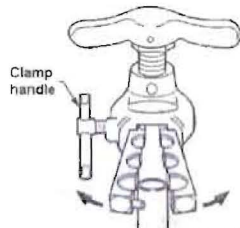
For a beautiful flared surface, give the feed handle one full turn or two after the clutch has gone off.

### Step 8

Repeat Step 1.

### Step 9

Loosen the clamp handle, move the yoke until it hits the stopper bolt, and open the gauge bar to remove the tube (Figure 7).



(Figure 7)

If the gauge bar is too tight to open, move the yoke up to the stopper bolt and tighten the clamp handle to easily open the gauge bar.

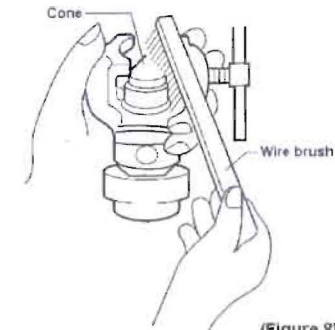
## Maintenance

1

Clean the flaring tool and lubricate the screws and other moving parts.

2

Remove tube scrap sitting on the cone by using a wire brush (Figure 8). Be careful not to damage the cone.



(Figure 8)

The gauge bar can be removed easily by unscrewing the two stopper bolts with a hexagonal spanner (nominal size 4 mm).



### CAUTION

For proper flaring:

- \*Check if the tube is not deformed.
- \*Using a deformed tube and/or roughly cut tube would lead to leakage.
- \*Cut the deformed part of a tube before using this flaring tool.
- \*When cutting a tube, be careful not to deform the cut surface.

## Warranty

### Terms of Warranty

1. This product is to be repaired free of charge if a failure occurs despite proper use during the period of warranty.
2. This warranty is valid for 1 year starting from the date of purchase.
3. In any of the following cases, this product is to be excluded from free-of-charge repair.
  - 1) Failures incurred by improper use.
  - 2) Failures due to handling and storage beyond its specifications.
  - 3) Failures due to modifications or repairs not done by the manufacturer or its entrusted technicians.
  - 4) Failures due to consumable components.
  - 5) Other failures not deemed to be the manufacturer's responsibilities.

Product Name: <b>Flaring Tool</b>	
Model: <b>TA550 series</b>	Serial number:
Date of purchase: M: /D: /Y:	
Period of warranty: For 1 year starting from M: /D: /Y:	
Customer	
Name: _____	
Address: _____	
Phone number: _____	
Dealer	
Address and name: _____	

\* To the dealer: Kindly take a few minutes and fill out the above form.

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