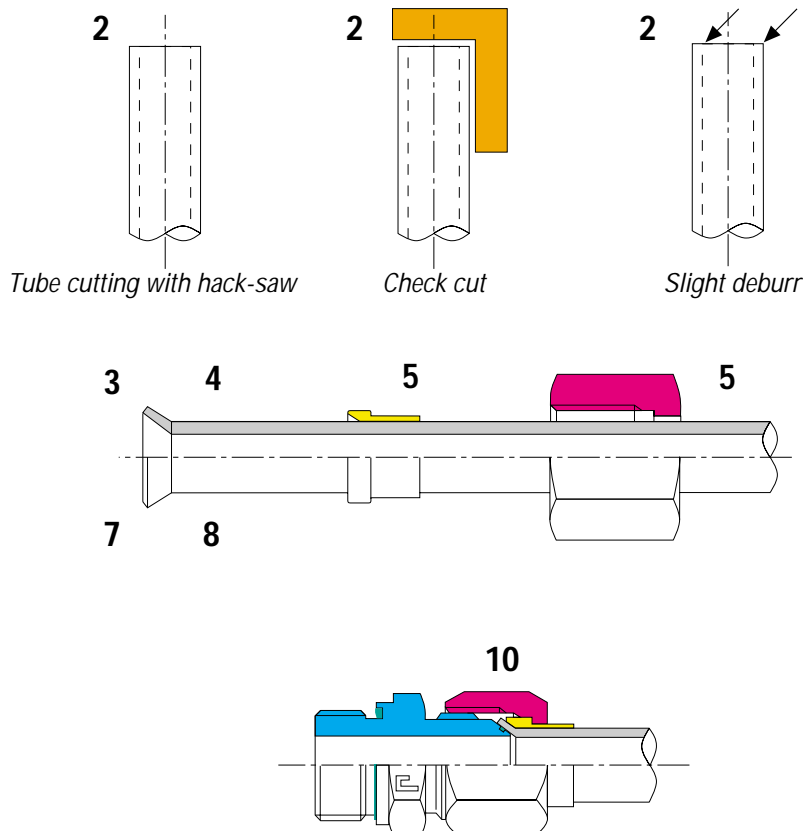
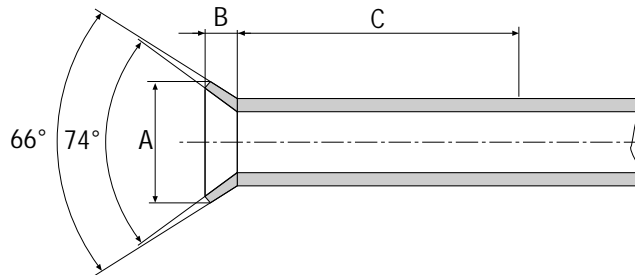


ASSEMBLY INSTRUCTIONS ACCORDING TO SAE J514

1. Before to start to flare the tube at 37° check for the correct parameters of all the tools to be used and substitute those not complying to the requirements.
2. Cut the tube at a 90° angle using the appropriate tool (do not use roll tube cutters). Check for the correct cut of the tube and deburr internally and externally.
3. Check for any damage that could impair the usefulness of the fitting, on the internal part of the tube. Never use a non complying tube.
4. Clean properly with appropriate products the part of the tube to be flared.
5. Assemble the nut and sleeve on the tube taking care that the open part of the nut is directed the same way where the tube shall be flared so as must be the head of the sleeve, see below.
6. To obtain the wanted length of the tube please add the "B" quote on the technical information datas for tube flaring. This length will be completely absorbed in the assembly phase by the overbearing of flared tube on the body of the fitting.
7. Flare the tube using the appropriate flaring machine, and carefully respecting all the indications in the below table. The drawings indicate the quotes that must be considered.
8. Check that the flaring of the tube has been made correctly and that no structural damages that could impair the correct working of the tube are present.
9. Clean nut, sleeve, fitting and tube and lubricate with suggested products.
10. Couple the flared tube on the fitting cone, and tighten by hand the nut on the body of the fitting to check the correct alignment of the parts involved, then using a wrench tighten until reaching the metal to metal contact of the conical parts.
11. Repeated assembly and disassembly will not alter the functionality of the products.
12. Please refer to the table on page 49 for the correct tightening torques to be applied.



TECHNICAL DATAS FOR THE FLARING OF THE 37° TUBE



ØMetric Tube	ØInch Tube	Flaring Ø		B	Blocking C
		A _{min}	A _{max}		
6x1	1/4x0,89	8,6	9,1	2,5	32
6x1,5	1/4x1,65	8,9	9,1	2,7	
8x1	5/16x0,89	10,2	10,9	2,3	35
8x1,5	5/16x1,65	10,2	10,9	2,5	
10x1	3/8x0,89	11,7	12,4	2	40
10x1,5	3/8x1,65	11,7	12,4	2,2	
12x1	1/2x0,89	16	16,8	3,7	45
12x1,5	1/2x1,65	16	16,8	3,9	
12x2	1/2x2,1	16	16,8	4,1	
14x1,5	-	19,3	20,1	4,8	45
14x2	-	19,3	20,1	5,1	
15x1,5	-	19,3	20,1	4,1	45
15x2	-	19,3	20,1	4,3	
16x1,5	5/8x1,65	19,3	20,1	3,4	45
16x2	5/8x2,1	19,3	20,1	3,6	
16x2,5	5/8x2,41	19,3	20,1	3,8	
18x2	-	23,4	24,1	5,1	50
18x2,5	-	23,4	24,1	5,3	
20x2	3/4x2,1	23,4	24,1	3,6	50
20x2,5	3/4x2,41	23,4	24,1	3,8	
20x3	3/4x3,05	23,4	24,1	4,1	
25x2	1x2,1	29,7	30,5	4,6	60
25x3	1x3,05	29,7	30,5	5,1	
30x2	-	37,6	38,4	6,7	60
30x3	-	37,6	38,4	7,2	
32x2	1 1/4x2,1	37,6	38,4	5,3	60
32x3	1 1/4x3,05	37,6	38,4	5,7	
38x3	1 1/2x3,05	43,2	43,9	5,4	70
38x4	1 1/2x4,05	*	*	5,8	

* For further information on the flaring diameter please contact our offices