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**NAVAC**  
Making Your Job More Enjoyable

Flaring Tool  
**NTF66 NTF66C**  
User Manual



Failure to follow warnings could  
result in death or serious injury.

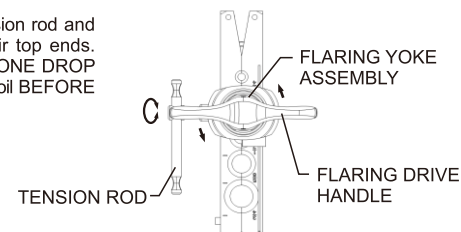
**SAVE THIS MANUAL  
FOR FUTURE REFERENCE**

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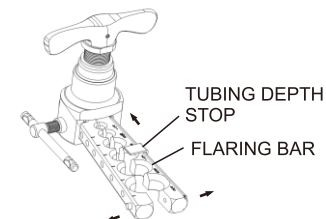
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## OPERATING INSTRUCTIONS

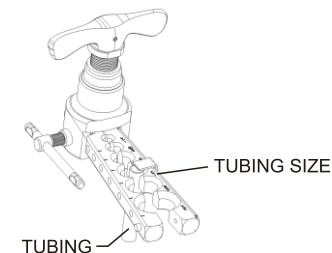
1. Before using, back out the tension rod and the flaring drive handle to their top ends. OIL FLARE CONE FACE with ONE DROP of refrigeration or vacuum pump oil BEFORE EACH FLARE.



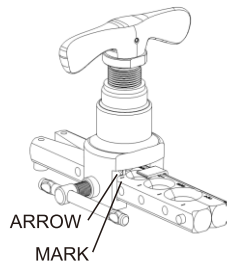
2. Move the yoke assembly to the end of flaring bar (end with pins) and spread the tube flaring open. Move the tubing depth stop to the size tubing to be flared.



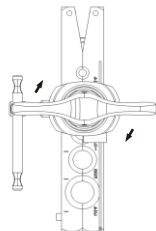
3. Insert the tube into the correct hole according to its diameter and size marked on the flaring block. Make sure that the tubing is inserted up to the depth stop before tightening. Make sure to PUT FLARE NUT ON FIRST!



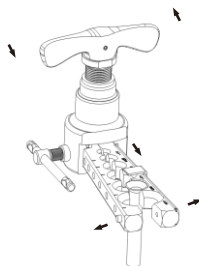
4. Align the yoke with the arrow at the mark on the flaring bar, then tighten the tension rod. You should feel the ball bearing opposite the tension rod settle into place. If the tubing is out of round and the yoke won't slide into position, tighten the tension rod gradually and back off, and slide yoke into place.



5. Turn the flaring drive handle clockwise until the clutch disengages automatically. Turn 2 or 3 more times to make sure the flare smooth and burnished by the eccentric cone.



6. Back the cone out of the tubing by turning the flaring drive handle counter-clockwise to the top. Then loosen the flare block tension rod, slide the yoke back, and open the tube flaring bar to remove tubing. Inspect the finished flare.

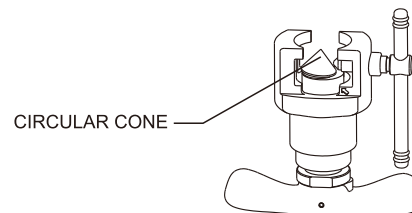


## MAINTENANCE

### Caution:

Make sure to raise the flare cone before releasing the flare tension rod or you may pinch or cut your hands!

1. Keep the 45° circular cone clean by wiping away any copper dust after using.
2. Add lubricant frequently to the flare block tension rod and flaring drive threads.
3. Frequently grease the inside bearings and coupling of the flaring drive rod.



## APPLICATION

Model	NTF66	NTF66C
Tubing O.D.	1/4", 5/16", 3/8", 1/2", 5/8", 3/4"	1/4", 5/16", 3/8", 1/2", 5/8", 3/4"
Accessory	/	NTC11