

SAFETY NOTICE

To understand the functioning of the tools, it is necessary to read the manual first!

- > Read these instructions before assembling, during installation and throughout use and in the proper sequence
- > Always refer to the OEM manufacturer's instructions and service manuals for the latest data and to maintain the correct sequence
- > These work instructions and the recommended tools are meant to serve as aides only and are by no means a guarantee for certain results.
- > This tool kit is a special collection and it has been tested and used successfully on several occasions. It is of the utmost importance to maintain the correct procedure as per the instructions
- > The use of the tools should only be carried out by qualified personnel!



ATTENTION
Special caution



CORRECT



LIGHT BULB
Hint or recommendation



WRONG



SAFETY GOGGLES
Wearing safety goggles
necessary

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No.	PART.-NR.	Description	6133213	6133214
1	6133219	Basic Device	1	1
2	9133140 F	Handle for Basic Device	1	1
3	6133222	Depth Gauge	1	1
4	6133220	Ram Assembly	1	1
5	6135200	Pipe Deburring Tool	-	-
6	6134500	Brake Pipe Bending Tool	-	1
7	3121040	Pipe Cutter Tubex 04	-	1
8	6133216	Punch no. 1 SAE convex	1	1
9	6133215	Punch no. 6 DIN convex	1	1
10	6133217	Punch no. 7 SAE double	1	1



No.	PART.-NR.	Description	61339030
1	6133219	Base unit without handle for brake pipe flaring tool	1
2	9133140 F	Handle "F" for flaring tool 4.75 mm DIN + SAE	1
3	6133220	Flaring die holder and pressing device with spindle for brake flaring tool	1
4	6133222	Depth stop gauge for brake pipes	1
5	61332310	Pipe deburring tool for in. diameters up to 11.5 mm & ex. diameters up to 15.0 mm	1
6	6133215	Flaring die E 4.75 mm OP6 DIN convex	1
7	6133216	Flaring die E 4.75 mm OP1 SAE convex	1
8	6133217	Flaring die E 4.75 mm OP7 SAE double	1
9	61345000	Bending tool for brake pipes	1
10	61339010	Brake pipe clamp size 1 "narrow"	2
11	61339020	Brake pipe clamp size 2 "wide"	2
12	7061010	One-hand automatic wrench 1	1
13	31210300	Mini ratchet pipe cutter 4.75 mm	1

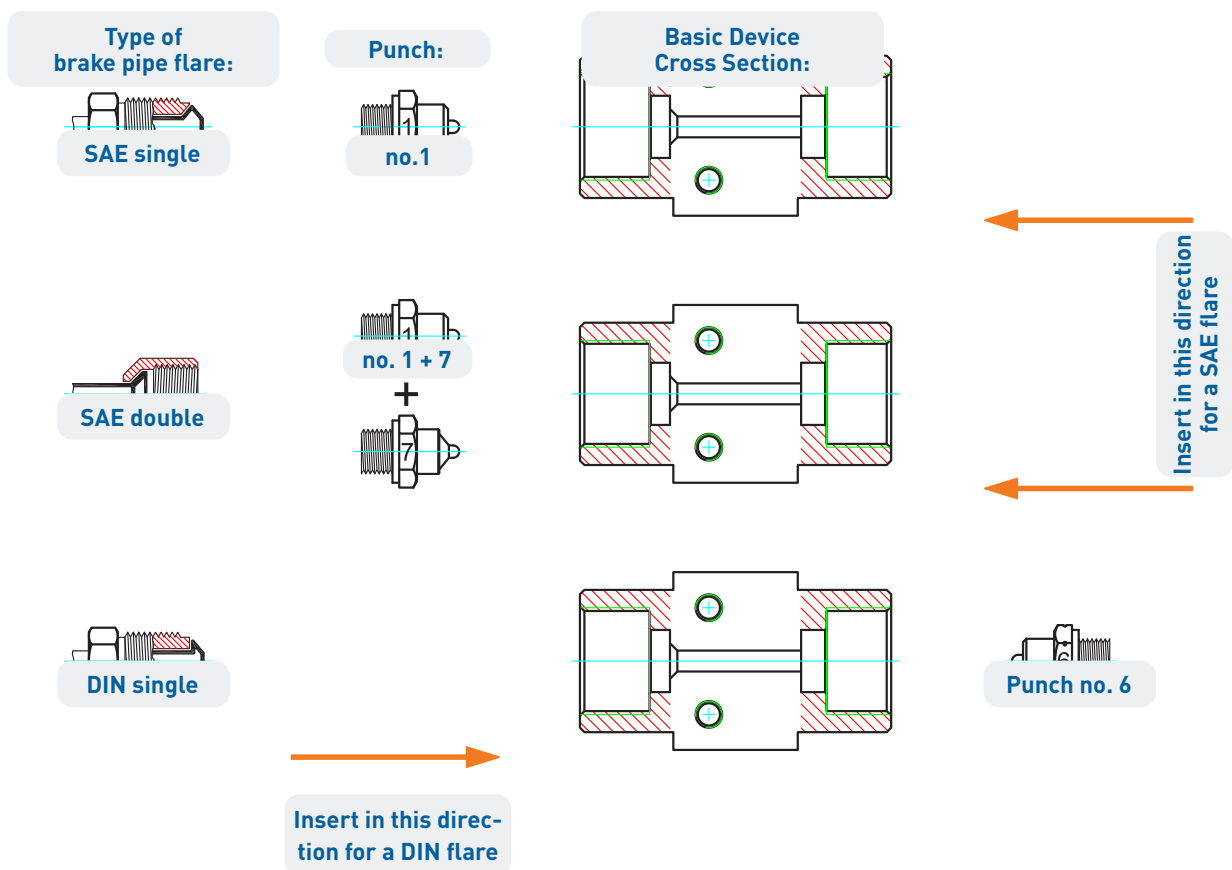
1. PREPARATION OF THE BRAKE PIPE THAT NEEDS TO BE FLARED

Cut the pipe plan with the Pipe Cutter **7** . Deburre the inside and outside with the Pipe Deburring Tool **5** and remove the swarf with compressed air.



2. SELECTING THE REQUIRED FLARE

Select the appropriate flare using the drawing.



3. MANUAL



3.1 CLAMPING THE PIPE

Unscrew the clamping nuts M6 of the Basic Device and insert depending on the desired flare (SAE or DIN), the pipe from the relevant side in the Basic Device. (See page 5)

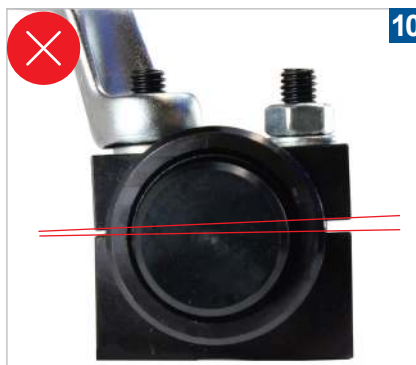
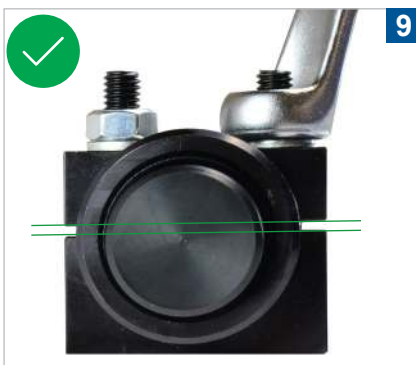


Slide the Depth Gauge **3** in the Basic Device until it stops in order to bring the pipe in the correct position to be flared.



Tighten the clamping nuts M6 alternately with a spanner 10 (max. 14 Nm) so that the upper jaw is always approximately parallel to the lower jaw.

See pictures **9** and **10**.



3.2 MOUNTING THE PUNCH

Screw the selected Punch in the pressure screw of the Ram Assembly and **tighten it with a spanner 14.**



Unscrew the pressure screw until the pin in the slot can be pushed back to the stop.



Screw the Ram Assembly with the Punch from the proper side (SAE or DIN) until the O-ring is touching.





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3.3 FLARING

Turn the pressure screw clockwise with a spanner 27.

The flaring is completed as soon as a noticeable larger effort is necessary.

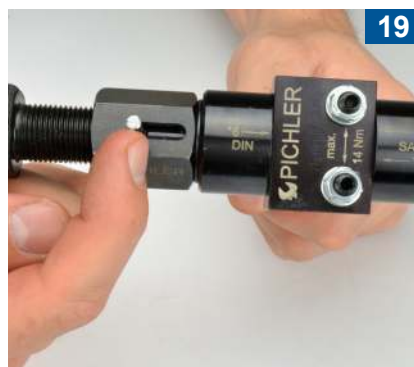


ATTENTION

The pin must not be pressed to the front stop of the slot.



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19

Unscrew the pressure screw so far that the pin can be pushed to the rear end of the slot.



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Only now unscrew the Ram Assembly with Punch from the Basic Device.



ATTENTION

When making a SAE double flare stays the pipe clamped in the Basic Device. In this case replace the Punch by Punch 7 SAE and repeat the flaring operation.

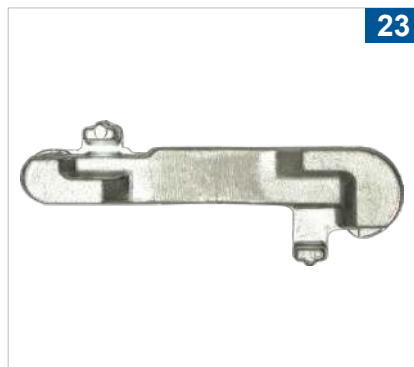
See 3.2 - 3.3

Loosen the lock nuts, push the upper clamping jaw upward and remove the pipe from the Basic Device.



4. BRAKE PIPE BENDING TOOL

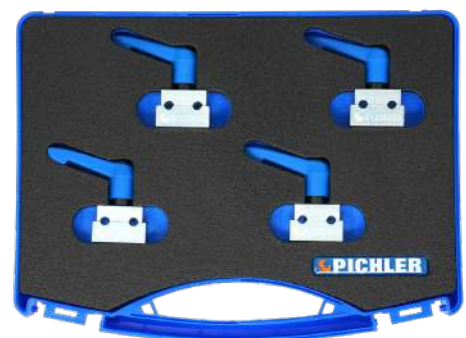
With the Brake Pipe Bending Tool can the flared pipe easily be bent into the desired shape.



LIGHT BULB



The easiest and most convenient way of bending the brake pipe is with our Universal Brake Line Bending Tool. With the included brake pipe clamps the new brake line can be fitted parallel to the existing one to accurately reproduce the original shape.

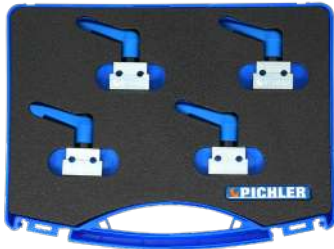


61339015

RECOMMENDED ACCESSORIES

BRAKE LINE HOLDING CLAMPS UNI SET 4 PCS.

61339015



PIPE DEBURRING TOOL FOR INTERNAL UP TO 11.5MM FOR EXTERNAL UP TO 15.0MM

61332310



BRAKE BLEEDING SPANNER 11

6134465



**BRAKE BLEEDER VALVE REPAIR KIT
12 PC. 1/4" 1/8"**

9353010



**BRAKE CALLIPER PISTON WIND
BACK TOOL**

61388460



**UNIVERSAL BRAKE CALLIPER PISTON WIND
BACK ADAPTERS WITH 2 AND 3 PINS**

61388475



**EXTRA THIN REACTION PLATE FOR
BRAKE CALLIPER PISTON WIND BACK TOOL**

61388465



**UNIVERSAL BRAKE CALLIPER PISTON
SPREADER**

61306000



BRAKE PIPE CLEANING TOOL

61290000



LINE CLAMP AND STOPPER SET

60504300



BRAKE FLUID TESTER MOD. EBT

4223500



BRAKE FLUID TESTER MOD.L

4224000





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