



# PFT409

## Pistol Grip Flaring Tool

### Parts List

#### DIES

##### INCLUDED    OPTIONAL

PFT205	PFT245
PFT210	PFT250
PFT215	PFT255
PFT220	PFT260

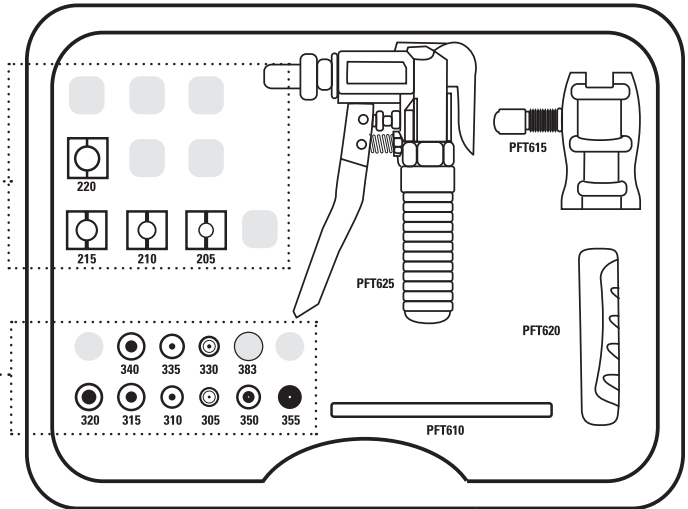
#### PUNCHES

##### INCLUDED

PFT305	PFT335
PFT310	PFT340
PFT315	PFT350
PFT320	PFT355
PFT330	PFT383

##### OPTIONAL

PFT325
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#### INCLUDED IN KIT

PART NO.	DESCRIPTION	PART NO.	DESCRIPTION
PFT205	Die – 3/16" (4.75 mm) 45° & DIN	PFT340	Punch – 5/16" (8 mm) DIN
PFT210	Die – 1/4" 45° & DIN	PFT350	Punch – 3/16" & 1/4" 45° OP2
PFT215	Die – 5/16" (8 mm) 45° & DIN	PFT355	Punch – 5/16" x 3/8" 45° OP2
PFT220	Die – 3/8" 45°	PFT383	Punch – OP0
PFT305	Punch – 3/16" (4.75 mm) 45° OP1	PFT610	PFT409 Yoke Set Screw Handle
PFT310	Punch – 1/4" 45° OP1	PFT615	PFT409 Yoke
PFT315	Punch – 5/16" (8 mm) 45° OP1	PFT620	PFT409 Yoke Handle
PFT320	Punch – 3/8" 45° OP1	PFT625	PFT409 Hydraulic Handle
PFT330	Punch – 3/16" (4.75 mm) DIN	PFT630	PFT409 Case
PFT335	Punch – 1/4" DIN		

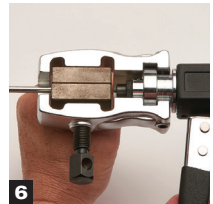
#### OPTIONAL (Sold Separately)

PART NO.	DESCRIPTION	PART NO.	DESCRIPTION
PFT245	Die – 3/16" (4.75 mm) 37°	PFT260	Die – 3/8" 37°
PFT250	Die – 1/4" 37°	PFT325	Punch – 3/16" (4.75 mm) 37° OP2
PFT255	Die – 5/16" 37°		

**NOTE:** Some cutouts in standard kit intentionally left empty. Use these for optional punches and dies, sold separately. 5/16" & 3/8" dies grooved for extra grip when used with steel and coated tubing.

# PFT409 Pistol Grip Flaring Tool Instructions

1. Make sure tubing end is cut straight and deburred.
2. Install handle into threaded hole in bottom of yoke. (Fig. 1)
3. Select die set which corresponds to desired flare.
4. Install die set vertically into yoke, such that the interface between the two halves is visible. (Fig. 2)
5. Position tubing flush with end of die set. (Fig. 3)
6. Install set screw handle and tighten set screw to press die halves together and hold tubing firmly in place. (Fig. 4)
7. Select punch that corresponds to desired flare.
8. Slide punch into chuck end of tool. (Fig. 5)
9. Insert tool into groove in yoke. Ensure punch is aligned with center axis of tube. (Fig. 6)
10. Holding yoke with handle, hold pistol grip with other hand and pull lever to press punch into die. Continue to pull and release lever until movement stops. (Fig. 7)
11. Press lever on rear of tool to retract punch out of tube. (Fig. 8)  
Flare is complete. (Fig. 9)
12. If creating a double flare, insert cone-shaped punch corresponding to tube size into chuck end and repeat steps 9 through 11. (Fig. 10)



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WARNING: Cancer and Reproductive Harm - www.P65Warnings.ca.gov

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