

INVERTED FLARE



Tube O.D.	1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1
Thread O.D. threads per inch	5/16-28	3/8-24	7/16-24	1/2-20	5/8-18	11/16-18	3/4-18	7/8-18	1-1/16-16	1-3/16-16	1-5/16-16

•Typical Application

Hydraulic brake, power steering, fuel lines and transmission cooler lines, LP and natural gas.

•Working Pressure Ranges

Temperature and type of tubing used are important factors. However, the following table is a good guide for proper selection. Temperature 73°F with copper tubing:

PSI	Tube O.D. (in.)	Tube Wall (in.)
2800	1/8	.030
1900	3/16	.030
1400	1/4	.030
1200	5/16	.032
1000	3/8	.032
750	1/2	.032
650	5/8	.035
550	3/4	.035

•Vibration

Excellent resistance.

•Temperature Range

-65°F to +250°F (-53°C to +121°C) range at maximum operating pressures.

•Used With

Copper, brass, aluminum and steel hydraulic tubing that can be flared.

•Advantages

Very low cost and reusable. Seats and threads are internal and protected. Compact, excellent vibration life. Short nut affords very close tube bends. Steel or brass tube nut.

•Tolerance

+/- .03 on all dimensions.

•Conformance

Meets specifications and standards of ASA, ASME, SAE and MS (Military Standards).

•Assembly Instructions

- 1-Cut tubing to desired length. Make sure all burrs are removed and the ends are cut square.
- 2- Slide nut on tube. Threaded end "A" of nut must face out.
- 3- Flare end of tube with a 45° flaring tool.
 - a- Measure flare diameter.
 - b- Examine flare for excessive thin out.
 - c- On thin wall, welded or brazed tubing, use double flare to prevent pinch-off and cracked flares.
- 4- Lubricate threads and assemble to fitting body. Nut should be turned hand tight.
- 5- Tighten assembly with wrench until a solid feeling is encountered. From that point, apply a one-sixth turn.

Note: Do not over-torque as it may damage the fitting or split the tubing at the flare.

PRICING FILE AVAILABLE ONLINE

STANDARD METRIC THREADS

Description Tube Size	Thread O.D.	Crest (Pitch)	Thread Description
Japanese 3/16"	10mm	1.0mm	M10 x 1.0
European 3/16"	10mm	1.0mm	M10 x 1.0
GM 6mm	12mm	1.0mm	M12 x 1.0
Fuel 5/16"	14mm	1.5mm	M14 x 1.5
Fuel 3/8"	16mm	1.5mm	M16 x 1.5

Measuring Metric Threads: Measure the O.D. of the threads and the crest to crest distance (pitch) in millimeters between threads.

Actual O.D. of male inverted flare threads

5/16"-28 2800 PSI	3/8"-24 1900 PSI	7/16"-24 1400 PSI	1/2"-20 1200 PSI	5/8"-18 1000 PSI	3/4"-18 750 PSI	7/8"-18 650 PSI	1-1/16"-16 550 PSI
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1/8"

3/16"

1/4"

5/16"

3/8"

1/2"

5/8"

3/4"