

# 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"