

HIGH Speed Flaring Tool

BQ350 and BQ351

(Supersedes BQ27008)

BrakeQuip

INNOVATIVE SOLUTIONS FOR AUTOMOTIVE PLUMBING

The Fastest Flaring Tool in The West Just Got Faster, Better and Less expensive!



Produce professional tube flares in a matter of seconds. This highly efficient tool allows you quick profits and improved customer service. Just dial and activate your required operation and your done! The BrakeQuip Flaring Tool has become the industry standard. It produces single and double flares to SAE and DIN standards on any light walled tubing 3/16" to 1/2".

Features:

- Punch turrets has OP-1* and OP-2* punches positioned side by side for efficiency
 - Cam lever operation provides speed and efficiency
 - Features automatic punch extraction
 - Smooth die channel does not mark tube
 - Comes in a rugged plastic case
- *OP-1 = First Operation,
OP-2 = Second Operation*

BQ350 - Creates 37° and 45° single and double flares as well as DIN. Includes 14-Die sets and 16-Punches.

Sizes: 45° - 3/16", 1/4", 5/16", 3/8", 1/2"
mm - 4.75, 6.00, 8.00, and 10.00.
37° - 3/16", 1/4", 5/16", and 3/8".
DIN - 3/16 (4.75mm) and 1/4".

BQ351 - is a basic version of the BQ350 which creates 45° single and double flares including DIN. Includes 5-die sets and 7-punches.

Sizes: 45° - 3/16", 1/4", 5/16" and 3/8" and
mm - 4.75mm DIN.

Creates these flares instantly:



37° Turret and DIN

45° Turret



SAE (Single),
"Bubble"



DIN (Single),
"Mushroom"



SAE/DIN
(Double)

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Direct: 1-865-251-9193
www.brakequip.com

BQ2027-0809

BQ350 / BQ351 Flaring Tool Instruction Sheet

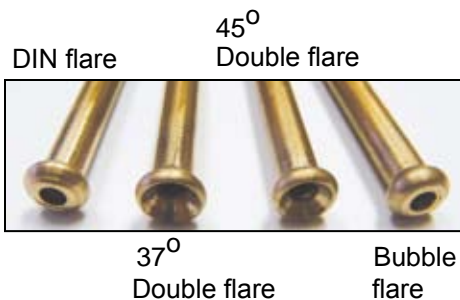
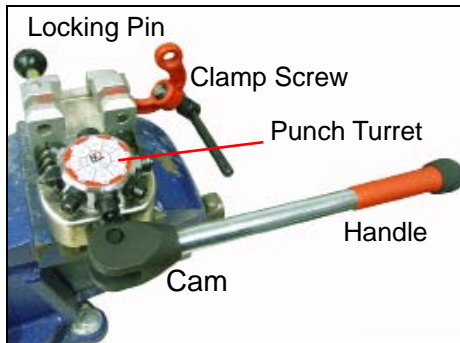
Note: Tube should be cut square and deburred inside and out before flaring.

A drop of oil on punch face reduces friction and can improve the results.

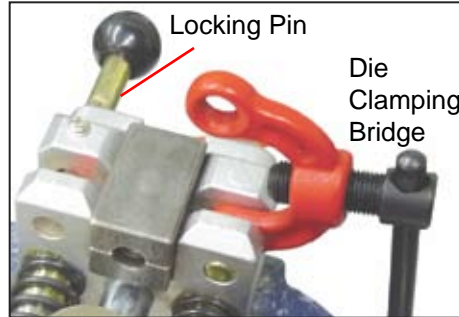
Important: Insert tube nut onto tube before flaring. Tube wall thickness must not exceed .035" (.89mm) and must be annealed for best results.

Tool Assembly

- Clamp base of tool in vice.
- Snap handle into operating cam.
- Select appropriate punch turret and snap onto post.



Flare Procedure



1. Slide locking pin out and swing open the die clamping bridge. Select the appropriate die set required and install into tool with forming end to die punch turret.



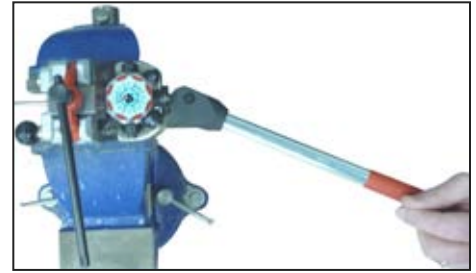
2. Insert tube through the back of die and slide it in until flush with the front of die.



3. Insure die is resting firmly against the die back step and tighten die clamp.



4. Rotate punch turret to OP. 1 of desired size.



5. Pull handle towards you until the punch presses into tube and is "bottomed out" in the die. It should be a positive feel that will not allow you to pull the handle any further.

6. Release - handle and punch turret will return automatically.

At this point you have made either a single "DIN" or "Bubble flare". If you require a "double" flare, you will need to do OP. 2. See as follows.

7. Rotate to the required punch size to Op. 2 to line up with tube.

Note: Op. 2 is always next to Op.1. Pull handle towards you again until the punch presses into tube and "bottoms out" in the die.

8. Release - handle and punch turret will return automatically.



9. Unscrew die clamp one half turn and slide out locking pin. Swing die clamping bridge away and remove tube from dies.

10. Inspect completed flared tube for flaws.