

## INSTRUCTIONS FOR SWAGING

### YELLOW JACKET® KIT 60440, 60453 & 60455

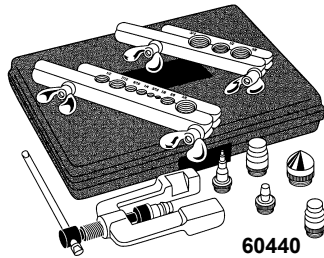
This tool is for swaging of soft copper, aluminum and brass tubing.

1. Select the proper swaging adapter and screw it onto the nut on the feed screw. Place a drop of oil on the adapter to help ensure smooth operation.
2. Prepare the tubing by cutting off squarely with a YELLOW JACKET® cutter. Also remove any internal burrs or rolled-in edges from end of tubing.
3. Insert tubing into flaring bars locating the tubing end above bars by one tubing diameter plus 1/8". Tighten the bar's wing nut closest to the tubing first and then tighten the other wing nut. This method of tightening can be done by hand and prevents tubing slippage. Example: Insert 3/8" tubing 3/8" + 1/8" or 1/2" above flaring bar.
4. Apply a small amount of refrigeration oil to swage adapter. Slip yoke over flaring bar and rotate so yoke "locks" onto the bar. Rotate feed screw with swage adaptor into tubing until the shoulder with knurled edge comes in contact with tubing.

5. While still holding tool, rotate feed screw and swage adapter counterclockwise to back it out of the tubing. The swage is complete.

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O.D. Tubing	Swaging Kit		
	60440	60453	60455
3/16			
1/4			
5/16			
3/8			
1/2			
5/8			
3/4			
7/8			
1-1/8			



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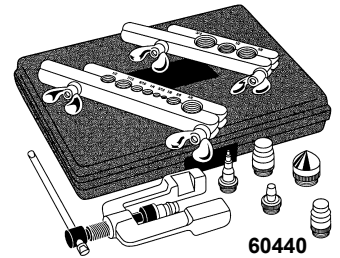
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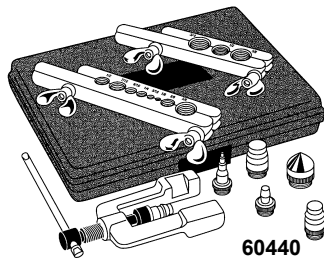
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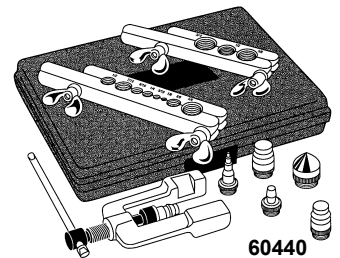
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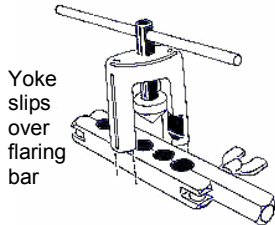
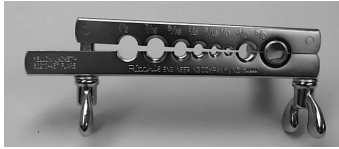


## INSTRUCTIONS FOR FLARING

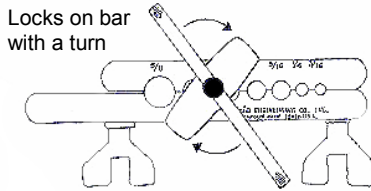
### YELLOW JACKET® KITS 60440, 60453 & 60455

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1. Attach flare cone to the feed screw nut then use as any other two piece flare tool.
2. Prepare the tubing by cutting off squarely with a YELLOW JACKET® cutter. Remove any internal burrs or rolled-in edges from end of tubing.
3. Insert tubing into flaring bars locating the tubing end slightly above bars. Tighten the bar's wing nut closest to the tubing first and then tighten the other wing nut. This method of tightening can be done by hand and prevents tubing slippage.
4. Slip yoke over flaring bar and rotate so yoke "locks" on to bar. Hold yoke and bar in place as flare is formed.



Yoke slips over flaring bar



Locks on bar with a turn

Ritchie Engineering Company, Inc.  
YELLOW JACKET Products Division  
10950 Hampshire Avenue South  
Bloomington, MN 55438  
Phone: 800-769-8370 or 952-943-1333  
Fax: 800-322-8684 or 952-943-1605  
E-mail: [custserv@yellowjacket.com](mailto:custserv@yellowjacket.com)



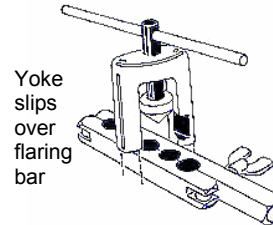
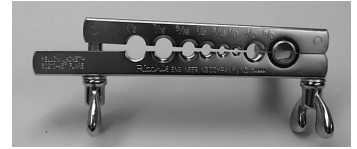
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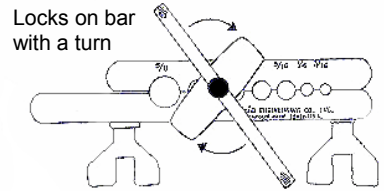
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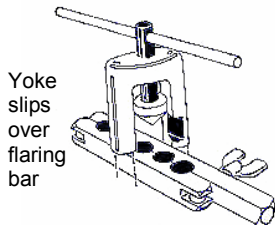
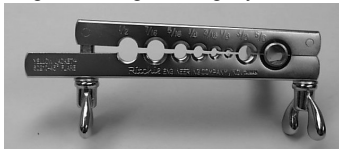
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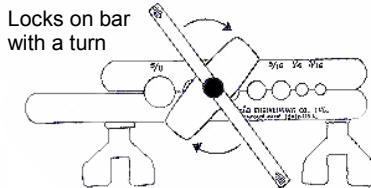
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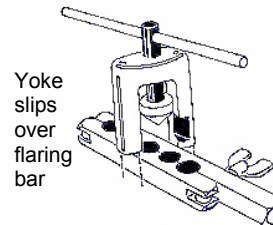
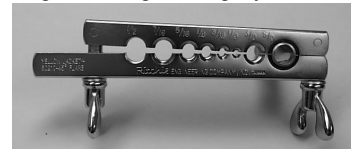
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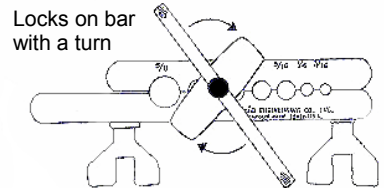
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