



Reliable Connections™

H-18000, H-18005 &
H-18007 Flaring Tools

Operating Instructions

Necessary Tools and Equipment

1. Safety Goggles, gloves and protective clothing
2. H-18010 Reamer and a file
3. Proper size H-18000, H-18005 or H-18007 Flaring Tool
4. Brass hammer
5. Necessary wrenches
6. Hacksaw and H-18035 Miter Box or suitable tubing cutter

WARNING: SERIOUS PERSONAL INJURY MAY RESULT FROM FAILURE TO FOLLOW THE PROCEDURES BELOW.

Before doing any work, all instructions listed in this form must be read, understood and followed.

SAFETY GOGGLES AND OTHER PROTECTIVE CLOTHING AND EQUIPMENT MUST BE WORN DURING ALL WORK: SERIOUS PERSONAL INJURY MAY RESULT FROM FAILURE TO USE SAFETY GOGGLES AND OTHER PROTECTIVE CLOTHING AND EQUIPMENT.

Tools that receive a striking force must only be struck with a soft-faced hammer to help avoid flying chips.

The H-18000, H-18005 and H-18007 are intended for use with type "K" copper tubing only. Use proper size flaring tool. For example: 3/4" H-18000 used with 3/4" "K" copper tubing. The H-18000, H-18005, H-18007 flaring tools are to be used only for flaring operations to make a service connection.

Procedures for Use of Flaring Tool

1. Follow O.S.H.A., state and local safety regulations.
2. Using either Miter Box (H-18035) and a hacksaw or suitable tubing cutter, cut copper tubing to desired length. Be sure cut is perpendicular to axis of tubing.
3. Using reamer (H-18010) or rat-tail file, remove all burrs from inside the pipe which were produced by the hacksaw or tubing cutter. Burrs on tubing could cause leakage.
4. Using a flat file, remove all burrs from the outside of the tubing which were produced by the hacksaw or tubing cutter. Burrs on tubing could cause leakage.

5. Place coupling nut on tubing.
6. Inspect flaring tool per instructions and replace before use if it is damaged (see below).
7. Place a few drop of oil on shank and shoulder of flaring tool to lubricate tubing during flaring procedure.
8. Insert flaring tool in end of tubing.
9. Hold coupling nut close to end of tubing to be flared allowing only enough tubing to protrude to permit a proper flare to be made.
10. Using a soft-faced brass hammer (DO NOT USE A HARDENED STEEL HAMMER) strike the flaring tool a few light blows, rotating the tool a small amount after each blow until the end of the tubing touches the recessed shoulder of the flaring tool.
11. Remove the flaring tool and inspect the joint surfaces of the tubing to be sure the joint surfaces are clean and that scratches or blemishes are not present that could cause a leak. If scratches or blemishes are present repeat steps 1-11.
12. Place flared tubing end against the joint surface of the fitting and slip coupling nut forward and firmly tighten coupling nut to fitting threads.
13. Test for leakage.
14. Inspect flaring tool and hammer per instructions below and repair or replace if necessary.

Proper Care and Maintenance of H-18000, H-18005 and H-18007 Flaring Tools

The Mueller H-18000, H-18005 and H-18007 flaring tools have been hardened and tempered to resist wear and deformation. Even so, numerous blows or misapplied blows may cause "mushrooming" of the striking surface. **WHEN THE STRIKING SURFACE BEGINS TO MUSHROOM, THE TOOL SHOULD BE REMOVED FROM SERVICE AND REPLACED.** The H-18000, H-18005 and H-18007 should be inspected after each use and not used if damaged.

The brass hammer should be inspected after each use and if the striking surface is mushroomed, the deformed metal should be removed. The brass hammer should not be used if head is loose.

Phone: (800) 423-1323

By deviating from the above listed instructions, you will void any product warranty and release Mueller Co. and its affiliated entities from any and all liability associated with the installation or use of this product. For details on the product's warranty, terms, and conditions, please visit www.muellercompany.com.

© 2016 Mueller Co., LLC. All rights reserved.

Form 10774 07/16