Tube Flaring

Facility:	Written By:	Approved By:	Date Created:	Date of Last Revision

Hazards Present:	*PPE or Devices Required:*	*Additional Training Required:*
Pinch Points	Steel toed boots	Operating Training
Lacerations	Eye protection	First Aid
	Hand protection	

Safe Work Procedure:

1) Inspect the work area and be aware of surroundings to prevent injury
2) Cutting the desired length of pipe
3) Unwind the pipe cutter so pipe can be inserted
4) Hold the pipe being cut securely with one hand, keeping fingers clear of cutting wheel, and begin to wind down the pipe cuter so the cutting wheel sits on the pipe being cut
5) Make first revolution around pipe slowly and carefully ensuring cutting wheel makes a complete cut around the circumference of the pipe. Continue tightening after each turn until pipe is cut
6) Flaring the pipe: Keeping fingers clear of blade, insert reamer tool into freshly cut pipe
7) Turn the reamer tool blade in the pipe until there is an inside diameter approximately half way through the tube wall thickness
8) Insert pipe into flaring bar, the tubing is extended beyond surface of flaring bar to proper distance by placing the wrench over the extended end of tubing into the notch of the wrench
9) With the wrench down against the flaring bar, and the tube end up against the top of the notch, tighten the flaring with wing nuts, starting with the wing nut nearest the tubing. Be sure the flaring bar is tight enough that it won't slip
10) Thread the proper adapter into thread hole that is provided in the center screw with the wrench
11) Place assembly with the attached adapter over the flaring bar so that the adapter pilot is in the tubing end to be flared
12) With one hand securely on the sliding handle, turn and force the adapter down over the tube end until the adapter rests flat against the flaring bar
13) Back off the adapter and remove

If an emergency situation occurs while conducting this task, or there is an equipment malfunction, engage the emergency stop and follow the lock out procedure
REPORT ANY HAZARDOUS SITUATIONS TO YOUR SUPERVISOR

Guidance Documents/Standards:	This Safe Work Procedure will be reviewed any time the task, equipment or materials change and at a minimum of every three years
MB Workplace Safety & Health Act & Regulations: 2.1 Safe Work Procedures 6 Personal Protective Equipment 16 Machines Tools and Robots	Reviewed By WSH Committee: Date: