



For your safety please follow this operation guidelines for your BeePro very carefully. Take care - Working directly at the breaking system must be done by professional experts or trained people only. For damages or harm resulted by insufficient usage we do neither accept any liability nor guarantee. Also ensure a closed film of spindle grease at all parts of the thread drivetrain.

Operating instructions



Flaring types

Type	Operation-guidelines	Processing steps	
		1	2
D	Clutching parts DIN, drill of tube chamfered, 90° Ram, mainly for copper tubes		
E	Clutching parts DIN, drill of tube chamfered, Step 1: DIN Ram, Step 2: 90° Ram		
F	Clutching parts DIN, drill of tube chamfered, DIN Ram		
F180	Clutching parts DIN, drill of tube NOT chamfered, DIN Ram		
CIT	Ram CIT, Clutching parts CIT		

Preparation



Remove all burrs from cutting edge of the tube very carefully.



Install the required Ram and washer bearing (or optional axial roller bearing) in the Ram receiver. Tighten the front screw using 4mm-Allen key moderately.



Adjust the extension of the tube by turning the cover bush with the applied ruler. Follow the given dimension in the table beside. The above picture shows exemplar a setting of 16,5 mm.

Stamping part	Dimension of tube [mm]	Setup tool [Scale]
Citroen	3,5	17,5 mm
Citroen	4,5	17,5 mm
Citroen	6,35 1/4"	16,5 mm
DIN/SAE E, F, F180	4,75 3/16" 5 6	5 mm

Please note: Depending on the material of tube, design and operational tolerances deviations of the given setup parameters for overlapping might be necessary. The given parameters should be handled as proposals only. Please adjust them case by case to cover your individual requirements for perfect results.

Procedure (Exemplary shown by CIT-flaring)



Move locking ring and new connection screw over the tube. Right hander people should take the BeePro in their right hand – left hander people in their left.



Bring the lower half rounded clutching part in its position. Take care about correct installation position. Means the counter-bore should show in front direction as shown in the above picture.



Now place the setup tool and ensure pressing the lower clutching part at the limit stop of the BeePro body.



Insert flaring tube up to the limit stop of setup tool.



Now, bring the upper square clutching part in its position. Ensure its good contact to the lower part. Working head up you can still lock its position while pressing on the setup tool.



Move locking ring over BeePro body. Before adjusting please ensure the right installing position of the tube again.



Turn the locking screw of the locking ring by hand first and afterwards by using socket- or ring wrench. Important: Tube must not to be moved.



Put setup tool besides and install pre-installed ram receiver into BeePro plate.



Turn ram receiver steady going up to limit stop. After reaching the final position please rewind ram receiver.



Open locking ring and put out the clutching parts including the already flared tube.



If some friction is shown on the tube it can be removed with fine sandpaper. Finished.

Assembling guidelines and Spareparts



BeePro was designed for professional users and allows usage of all standard socket wrenches or ring wrenches. Take care and avoid improper application of force because of risking to damage the thread drivetrain.



For perfect flaring results it is necessary to remove all burrs from cutting edge of the tube.



Operating instruction

please turn



Preassembling of Ram receiver (shown for CIT and with optional roller bearing) supports flaring workflow.



Handle can be installed individually to fit best for right handed people (RH) and left handed people.



Axial correlation between center of plate and clutching parts can be fine tuned by opening the three erection screws.



Please ensure usage of new rubber seal after removal of a CIT-tubing

Basic tool parts



Body



Plate



Handle



Ram receiver



Locking ring



Setup tool

Adapter



Adapter Type 1
For all original Ram of the BeePro



Adapter Type 2
For all Ram with thread M10x1 like e.g. Flaremaster, Facom DF.475, KS-Tools or others



Adapter Type 3
For all Ram with flat backside like Dako, Hazet 2191 or others



Adapter Type 4
For all Ram with 8 mm cylinder like e.g. Rothenberger DB10, Stahlwille No165, Facom 243 or others

Clutching and stamping parts



CIT Ram parts and clutching parts
In dimension 3,5 mm, 4,5 mm, 6,35 mm (1/4")



DIN / SAE Ram parts and clutching parts
In dimension 4,75 mm (3/16"), 5 mm, 6 mm, 8 mm (5/16"), 9 mm, 10 mm, 90° (please contact in case of add. request)

Bearing parts



Bearing washer



Roller bearing



Grease