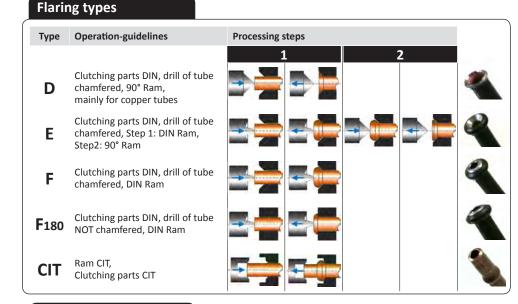
For your safety please follow this operation guidelines for your BeePro very carefully. Take care - Working directly at the breaking system must be done by professional experts or trained people only. For damages or harm resulted by insufficent usage we do neither accept any liability nor guarantee.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

## **Operating instructions**



### **Procedure** (Exemplary shown by CIT-flaring)



### Preparation



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



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 exemplay a setting of 16,5 mm.





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

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.



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.



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



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.



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



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



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



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

If some friction is shown on the tube it can be removed

with fine sandpaper. Finished.





Put setup tool besides and install pre-

installed ram receiver into BeePro

plate.



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.

# Assembling guidelines and Spareparts (BeePro

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

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



## **Operating instruction**

please turn



seal after removal of a CIT-tubing

 Basic tool parts

 Body
 Image: Plate
 Image: Plate

 Image: Plate
 Image: Plate
 Image: Plate
 Image: Plate

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Adapter Type 1 Adapter Type 2
For all original Ram
of the BeePro For all Ram with
of the BeePro 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)





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