

## Style and Description

As with other variations of flared fittings, Inverted Flare fittings require preparation of the tube prior to assembly.

Because of its compact design, suitability for applications involving high levels of vibration and excellent performance under high pressure, Inverted Flare can be found extensively in the Automotive Industry.

## Working Pressure

0-23700kPa depending upon tube size and media.

## Construction

- Inverted Flare Nut
- Inverted Flare Body
- Compression body
- Material: 352 DZR Alloy
- Pipe Thread BSP: AS1722.1 Tapered Male (R Series)

## Media / Application

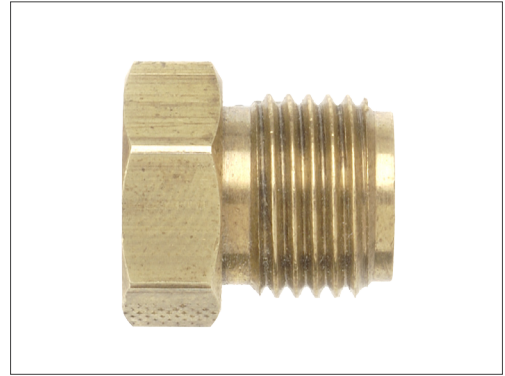
- ✓ LPG (Auto, domestic and commercial)
- ✓ Fuel and brake lines
- ✓ Refrigeration lines
- ✓ Hydraulics
- ✓ Pneumatics
- ✓ Plumbing (gas / water)

## Tube

- ✓ Copper - Annealed and hard drawn
- ✓ Brass
- ✓ Aluminium
- ✓ Steel Bundy
- ✗ Stainless Steel
- ✗ Nylon
- ✗ Poly tube

## Assembly & Installation

1. Cut the tube square, clean and remove any burrs or loose cuttings.
2. Slide tube nut over the tubing.
3. Using a 45° flaring tool, flare the end of the tube (as per tool instructions).
4. Assemble the tube nut onto fitting and tighten until 'spanner firm' (**Caution: do not over-tighten**).
5. If used in a pneumatic application, apply a soapy solution to the joint to be certain a positive seal has been made. Visually inspect for leaks if used in an hydraulic application.



## Maximum Working Pressure Tables for Tube Connection Fittings (kPa)

All working pressures are calculated at an ambient temperature using a safety factor of 4:1. Generally, working pressure is dependent upon the type of tubing used and not the fitting. Consequently the tables shown below should be used as a guide only.

### Hydraulic Applications Only

Tube O.D	Standard Compression	Internal Compression	SAE 45° Flare	SAE 45° Inverted Flare	Fleetfit Air Brake	Pneufit
1/8	23700	23700	23700	23700	n/r	n/r
3/16	15300	15300	22150	22150	n/r	n/r
1/4	12080	12080	16200	16200	n/r	n/r
5/16	9380	9380	12600	12600	n/r	n/r
3/8	7680	7680	10200	10200	n/r	n/r
1/2	5630	5630	7450	7450	n/r	n/r
5/8	n/a	3500	6090	n/a	n/r	n/r
3/4	n/a	3500	4850	n/a	n/r	n/r
4mm	15300	n/a	n/a	n/a	n/r	n/r
6mm	12080	n/a	n/a	n/a	n/r	n/r
8mm	9380	n/a	n/a	n/a	n/r	n/r
10mm	7680	n/a	n/a	n/a	n/r	n/r
12mm	5630	n/a	n/a	n/a	n/r	n/r

n/a = Not Available      n/r = Not Recommended for Hydraulic Applications

### Pneumatic Applications

Tube O.D	Standard Compression	Internal Compression	SAE 45° Flare	SAE 45° Inverted Flare	Fleetfit Air Brake	Pneufit Brass
1/8	17775	17775	17775	17775	1050	1800
3/16	11475	11475	11475	11475	1050	1800
1/4	9060	9060	9060	9060	1050	1800
5/16	7035	7035	7035	7035	1050	1800
3/8	5760	5760	5760	5760	1050	1800
1/2	4370	4370	4370	4370	1050	1800
5/8	n/a	2625	2625	n/a	1050	n/a
3/4	n/a	2625	2625	n/a	1050	n/a
4mm	11475	n/a	n/a	n/a	1050	1800
6mm	9060	n/a	n/a	n/a	1050	1800
8mm	7035	n/a	n/a	n/a	1050	1800
10mm	5760	n/a	n/a	n/a	1050	1800
12mm	4370	n/a	n/a	n/a	1050	1800

n/a = Not Available