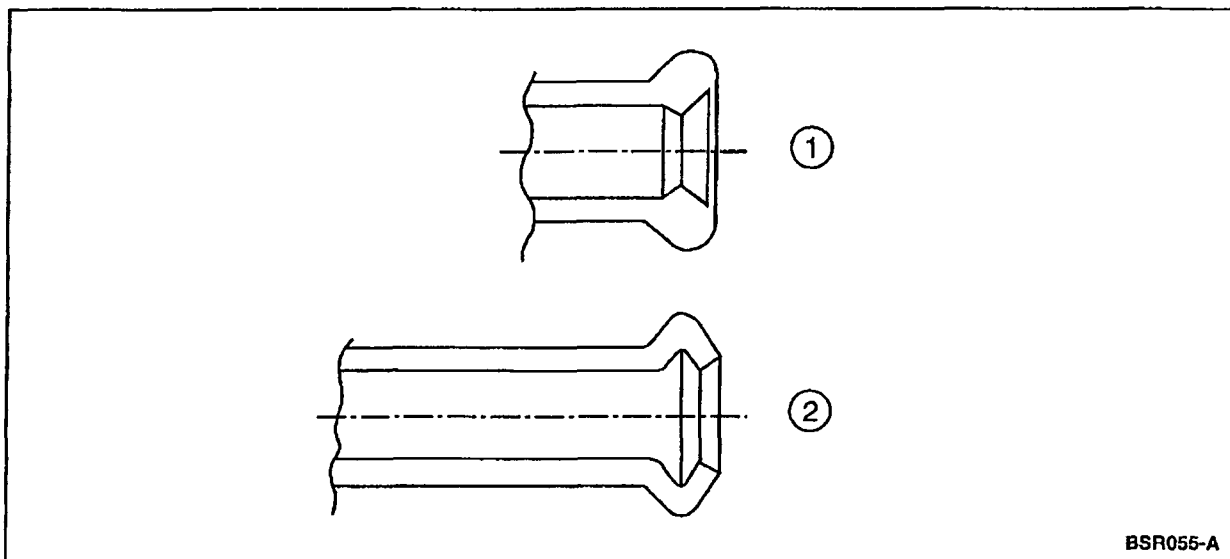


Metal Brake Lines



BSR055-A

Brake Line Flares

Item	Description	Item	Description
1	Double Flare	2	ISO Flare

Whenever possible, replace the line with pre-manufactured brake line. However, when pre-manufactured line is not available you will have to bend and flare the line as required.



WARNING: NEVER SPLICE INTO BRAKE LINES. NEVER USE COPPER TUBE OR RUBBER HOSE TO REPAIR OR REPLACE METAL BRAKE LINES. USE ONLY DOUBLE-WALLED STEEL TUBING.

See the vehicle's service manual for specific replacement instructions. However, the general procedure for replacing metal brake line is outlined as follows:

- Obtain the recommended size double-walled brake line and the required fittings.

NOTE: Double flaring or ISO flaring tools must be used, because single flaring tools cannot produce a flare strong enough to hold the necessary pressure.

- Cut the tubing to length. Correct length may be determined by measuring the old brake line and then adding 3.175 mm (1/8 in) for each double flare or ISO flare.
- Install the brake fittings in the correct direction, then double flare or ISO flare the line at each connection point using Rotunda Brake Flaring Tool D81L-2268-A, or equivalent. Follow the instructions in the double flare tool kit.

NOTE: Use an appropriate tube bender whenever bending brake lines. Bending brake lines without a tube bender will result in the line being pinched, which will restrict brake pressure.

- Bend the brake line to match the old brake line, using a tube bender. Clearance of 6 mm (3/4 in) must be maintained at all moving or vibrating parts.