

# FLARE FITTING Procedure



NYS Clean Heat  
Supported



**Step 1:** Measure the cut locations using the insulation and copper tubing of the section with the flare nut attached to ensure the lengths match.



**Step 2:** Cut away the insulation section avoiding contact with the copper.



**Step 3:** Cut the excess copper perpendicular to the tubing.



**Step 4:** Softly remove sharp edges and burrs while keeping the tubing pointed down and avoiding scarring the inside of the tubing.



**Step 5:** Insert flare nut onto the cut end.



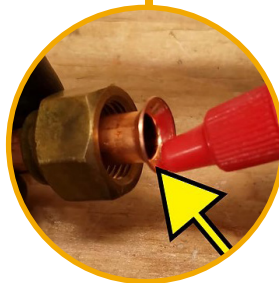
**Step 6:** Insert the tubing into the flaring tool ensuring the length protruding meets the manufacturer recommended length for the tool used.



**Step 7:** Tighten the flaring tool until the clutch engages. Do not over tighten. Doing so can scar or warp the flare.



**Step 8:** Repeat Steps 3 - 7 if the flare has any imperfections.



**Step 9:** Apply an oil that is compatible with the refrigerant being used. Only apply the oil to the face of the flare nut.



**Step 10:** Assemble the flare nut and tighten with a torque wrench to the manufacturer specified torque.



**Step 11:** Cover and seal the section to protect from moisture infiltration.

[Watch our Installation Tip video here »](#)

