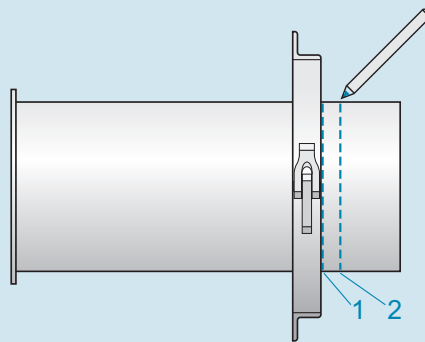


# JACOB FLANGING TOOL

## Operating instructions

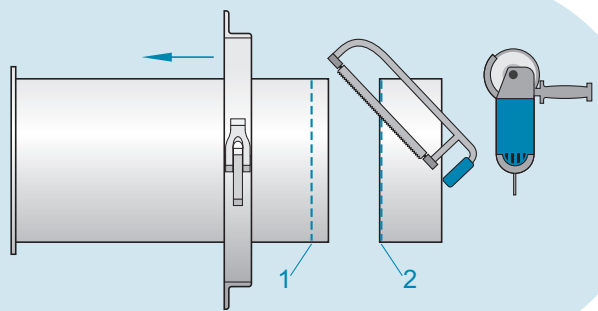
1

First of all, measure the exact length (1) to be cut on site and transfer this measurement to the pipe. Add an additional 7 mm to the length you have measured and marked, so that there is also sufficient length for the lip (2) as well. Next, place the flanging tool with its edge along the length mark (fitting length + 7 mm) and secure it in this position. The angle pieces on the flanging tool should face away from the edge to be flanged. Then mark a straight cutting line along the flanging tool and around the entire circumference of the pipe.



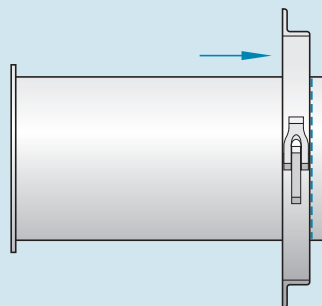
2

Slide the flanging tool back a little and then shorten the piece of pipe to the appropriate length (fitting length + 7 mm) by cutting along the cutting line (2) using a cut-off wheel or a suitable saw.



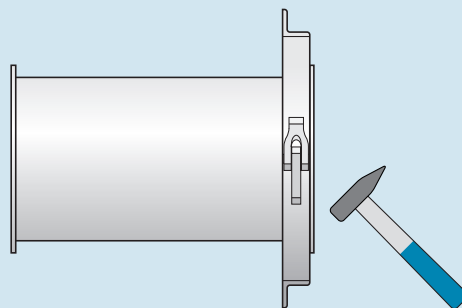
3

After cutting the pipe to size, clamp the pipe in the flanging tool so that the pipe protrudes 7 mm beyond it at the end to be flanged.



4

Turn the edge of the protruding pipe over by hand using a hammer until an even and sharp flanging edge is created.



After the pipe has been flanged in this way, slide the flanging tool off the pipe over the flanges for re-use. Longer pipes should be supported during the flanging process. The flanging tool is suitable for forming pipe ends made of 2mm-thick steel at most. For thicknesses of 3 mm or more, welding ends should be used to connect the pipe.