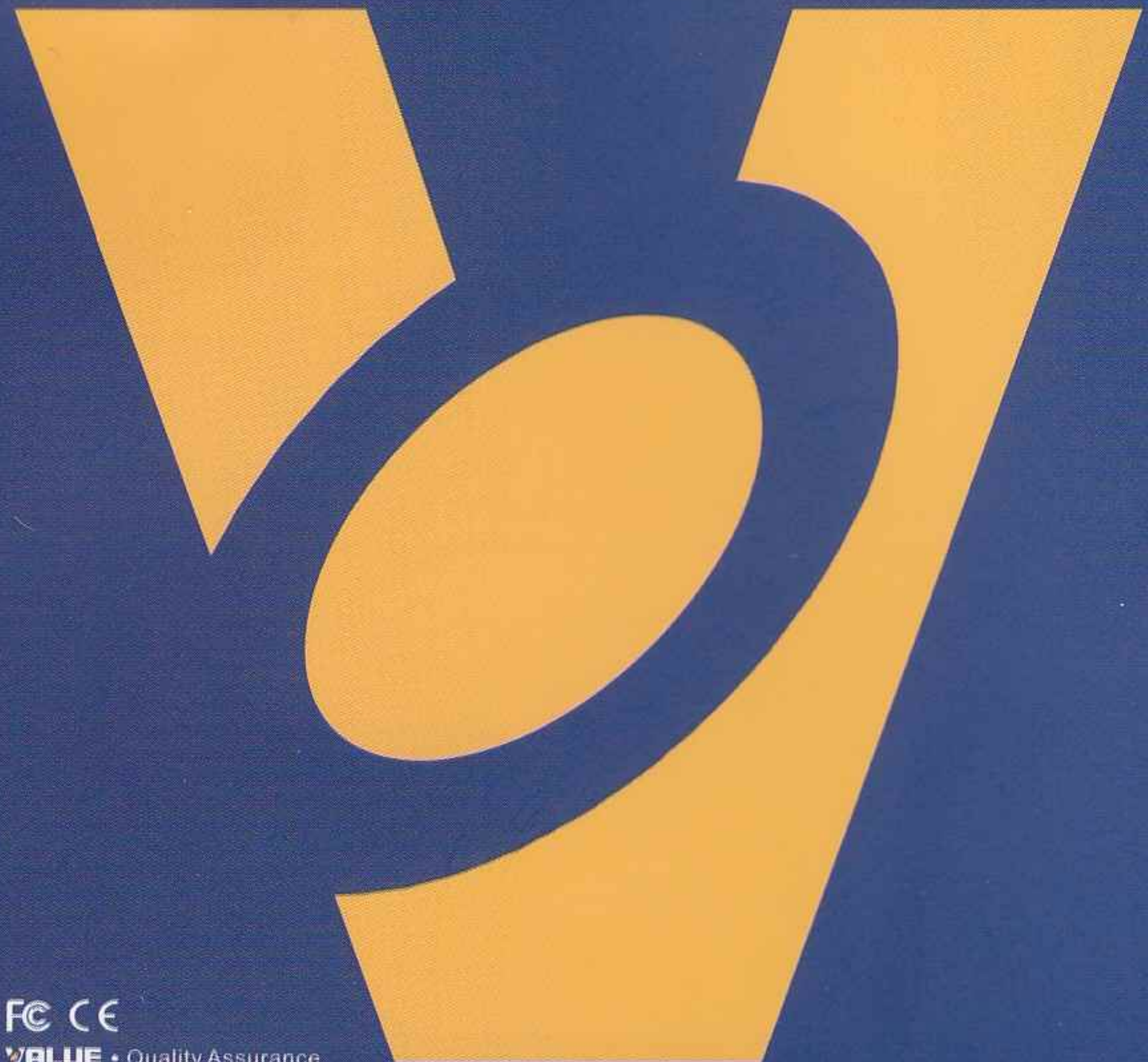




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**VET-19Li Li-Battery Flaring Tool
Operation Manual**



I .Safety guide

Warning

For safety and correct operation, please read the manual carefully before use.

1. Work area safety

- 1.1 Keep work area clean and well lit. Cluttered or dark areas invite accidents.
- 1.2 Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust. Power tools create sparks which may ignite the dust or fumes.
- 1.3 Keep children and bystanders away while operating a power tool. Distractions can cause you to lose control.

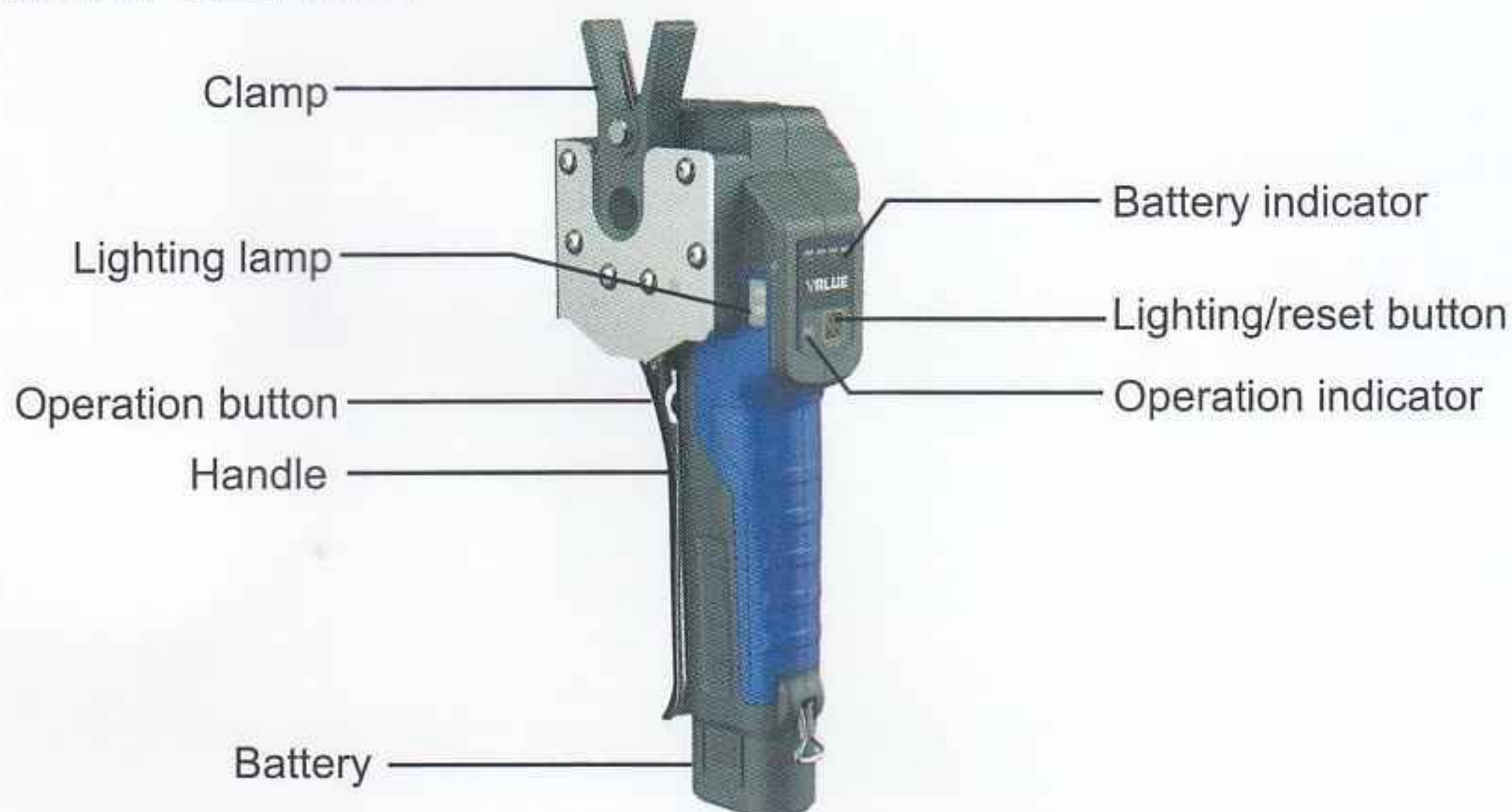
2. Electrical safety

- 2.1 Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools. Unmodified plugs and matching outlets will reduce risk of electric shock.
- 2.2 Do not expose power tools to rain or wet conditions. Water entering a power tool will increase the risk of electric shock.

3. Personal safety

- 3.1 Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication. A moment of inattention while operating power tools may result in serious personal injury.
- 3.2 Use personal protective equipment. Always wear eye protection. Protective equipment such as dust mask, non-skid safety shoes, hard hat, or hearing protection used for appropriate conditions will reduce personal injuries.
- 3.3 Prevent unintentional starting. Ensure the switch is in the off-position before connecting to power source and/or battery pack, picking up or carrying the tool. Carrying power tools with your finger on the switch or energising power tools that have the switch on invites accidents.
- 3.4 Remove any adjusting key or wrench before turning the power tool on. A wrench or a key left attached to a rotating part of the power tool may result in personal injury.
- 3.5 Do not overreach. Keep proper footing and balance at all times. This enables better control of the power tool in unexpected situations.
- 3.6 Dress properly. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewellery or long hair can be caught in moving parts.

II .Exterior structure



III .Technical parameters

Model	VET-19Li
Applicable Pipe/Tube	Copper tube
Applicable Pipe/Tube Size	1/4", 3/8", 1/2", 5/8", 3/4"
Flaring Shape	JIS B 8607
Processing Method	Eccentric cone
Power	DC motor
Cone Speed(rpm)	120rpm
Flaring times	Approximately 90 times for 3/8" copper pipes (full battery)
Expanding time	15-20s depends on different size
Exterior Dimensions	256x101x100mm

Battery pack

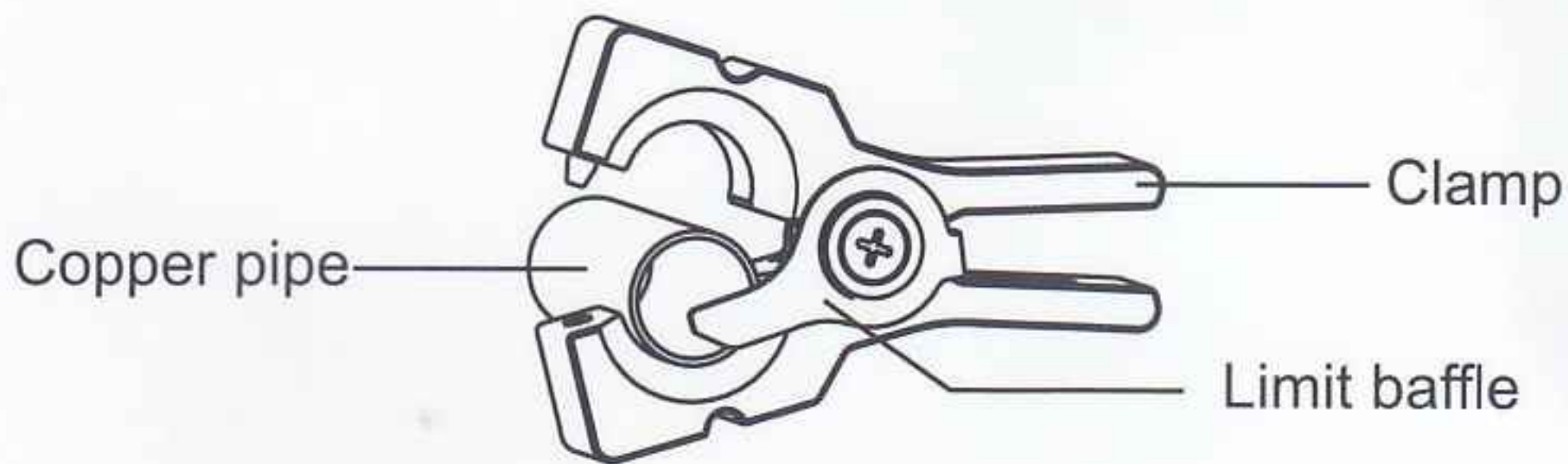
Battery	7.4V Li-Battery 2.0Ah
Charging time	around 30 min
Operating temperature	5°C-40°C

Charger

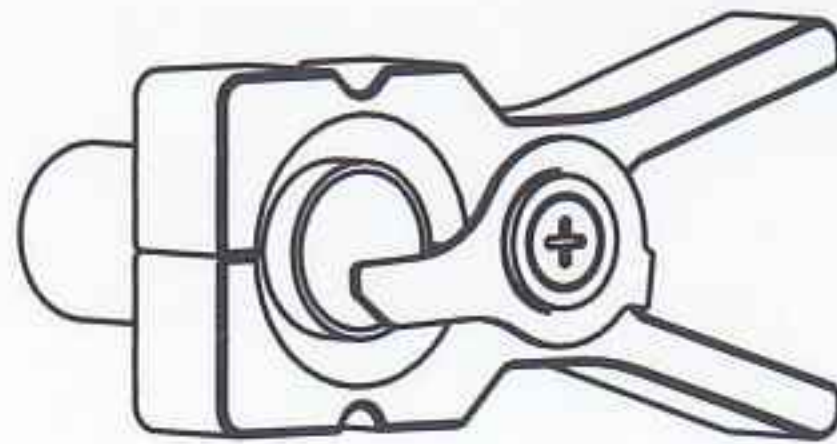
Power Supply	AC 100-240V (50/60Hz)
Charging Voltage	8.4V
Charging Current	3.5A
Operating temperature	5°C-40°C

IV. Operation

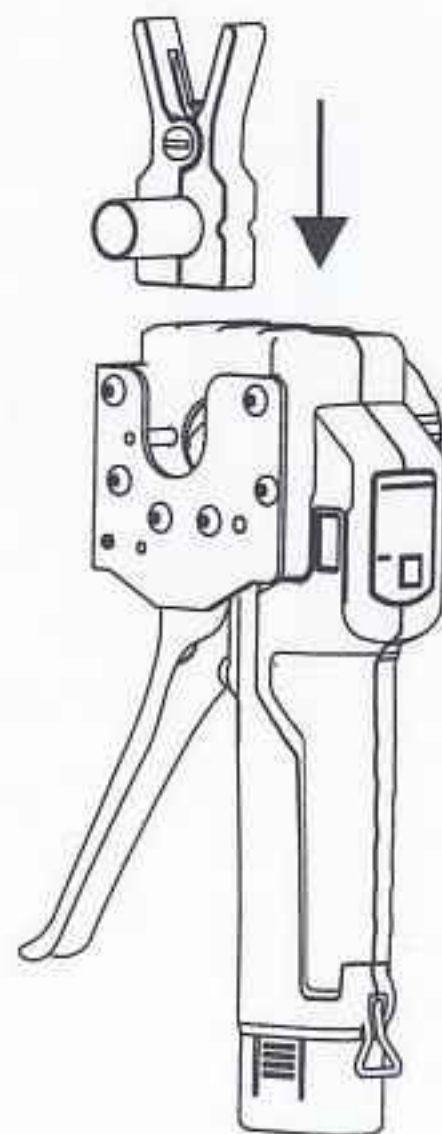
1. Open the clamp, insert the copper pipe, align the copper pipe end to the limit baffle.



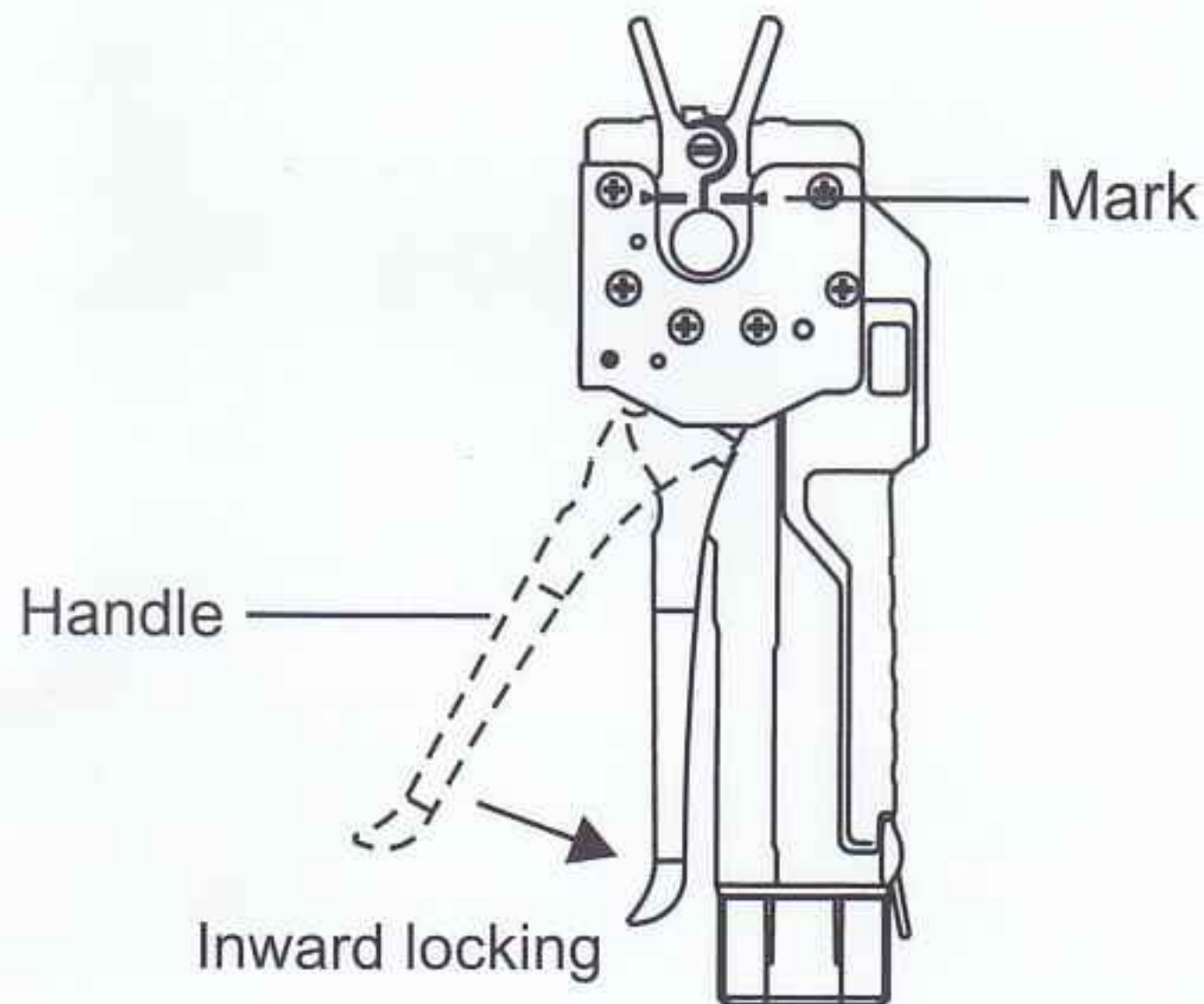
2. Close the clamp, to hold the copper pipe.



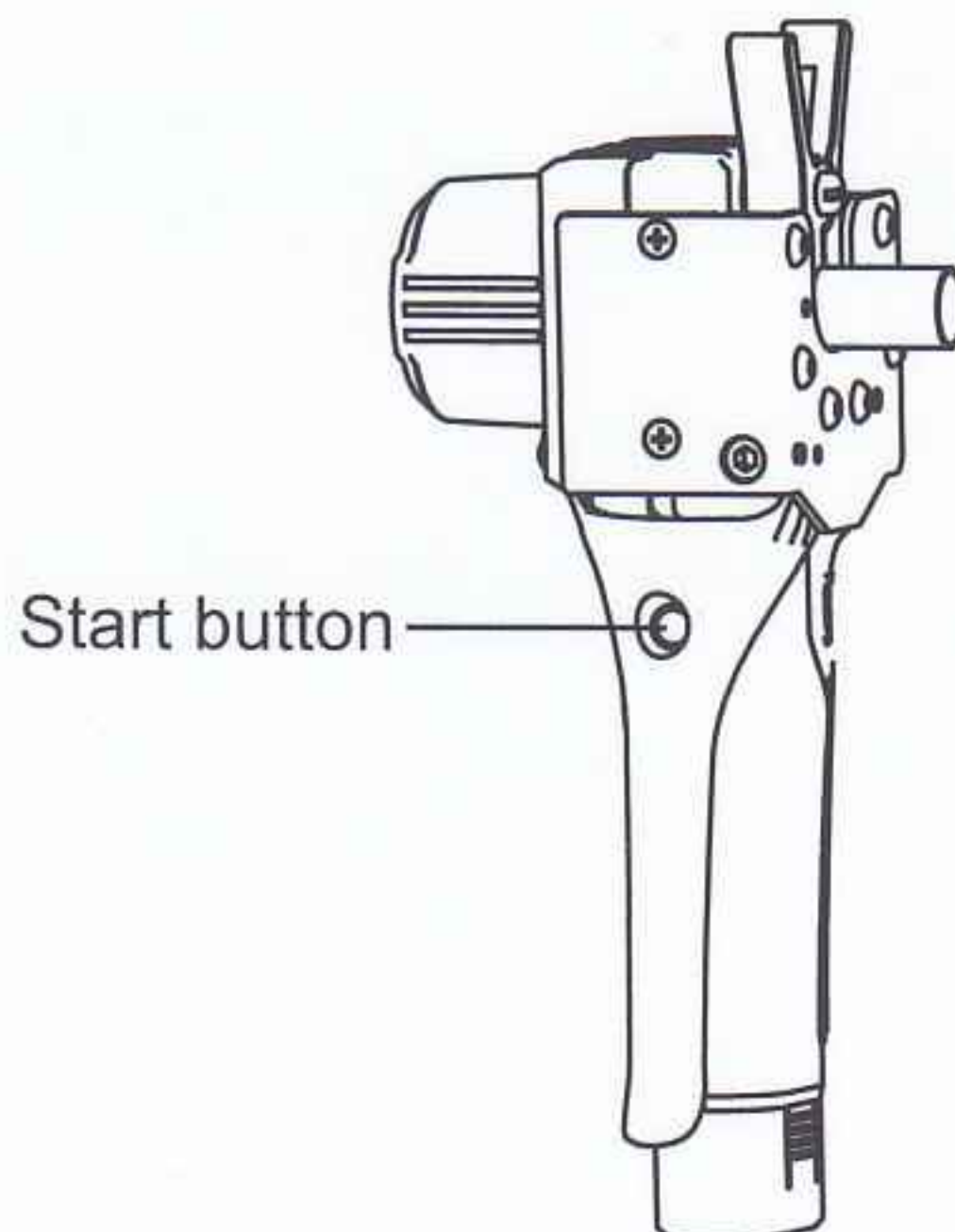
3. Put the clamp with the copper pipe into the flaring tool.



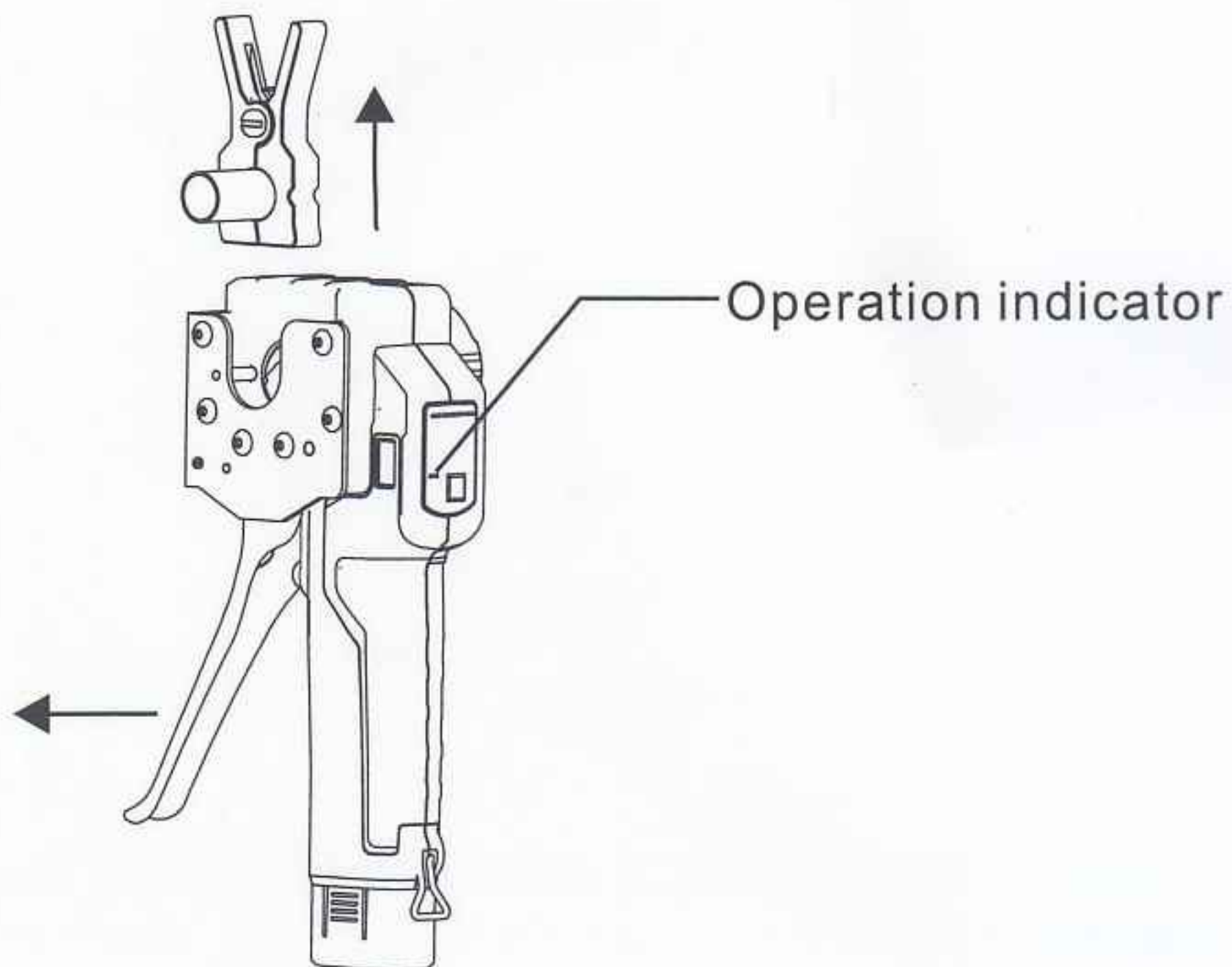
4. Make sure the clamp mark is aligned with the flaring tool, then lock the handle.



5. Press the start button and release it, then the product starts to flare the pipe, during which the handle shall not be pulled open.

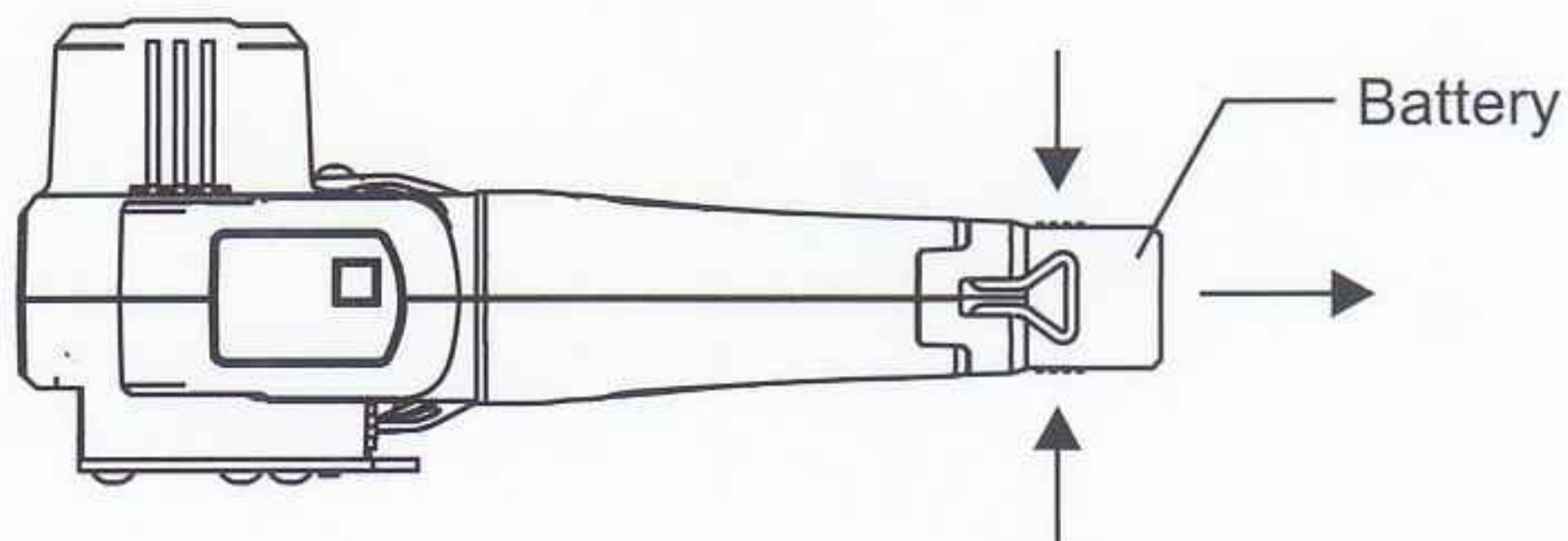


6. When the flaring tool completes operation (operation indicator goes off), open the handle, take out the clamp and copper pipe.

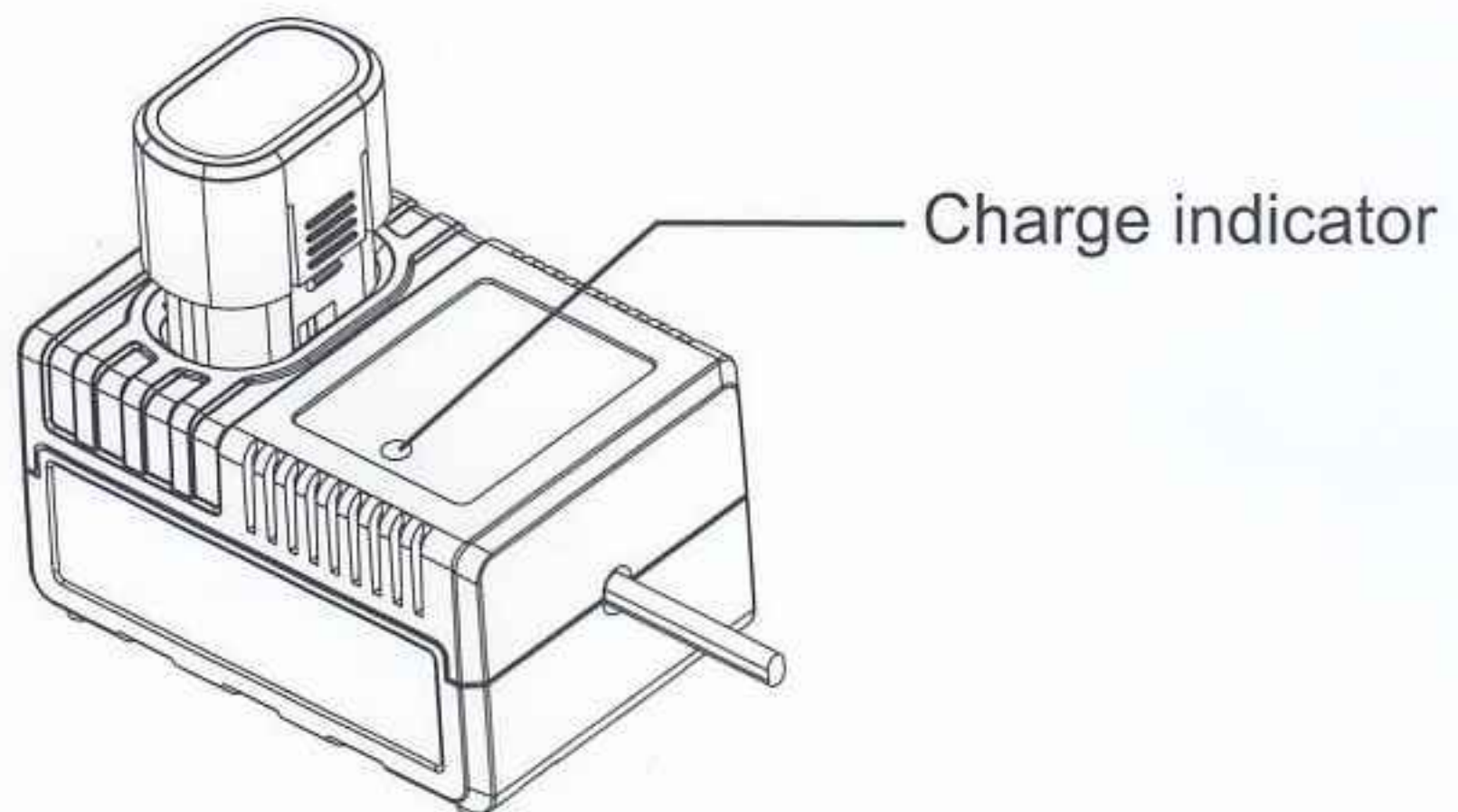


V. Charge

1. Take out the battery.



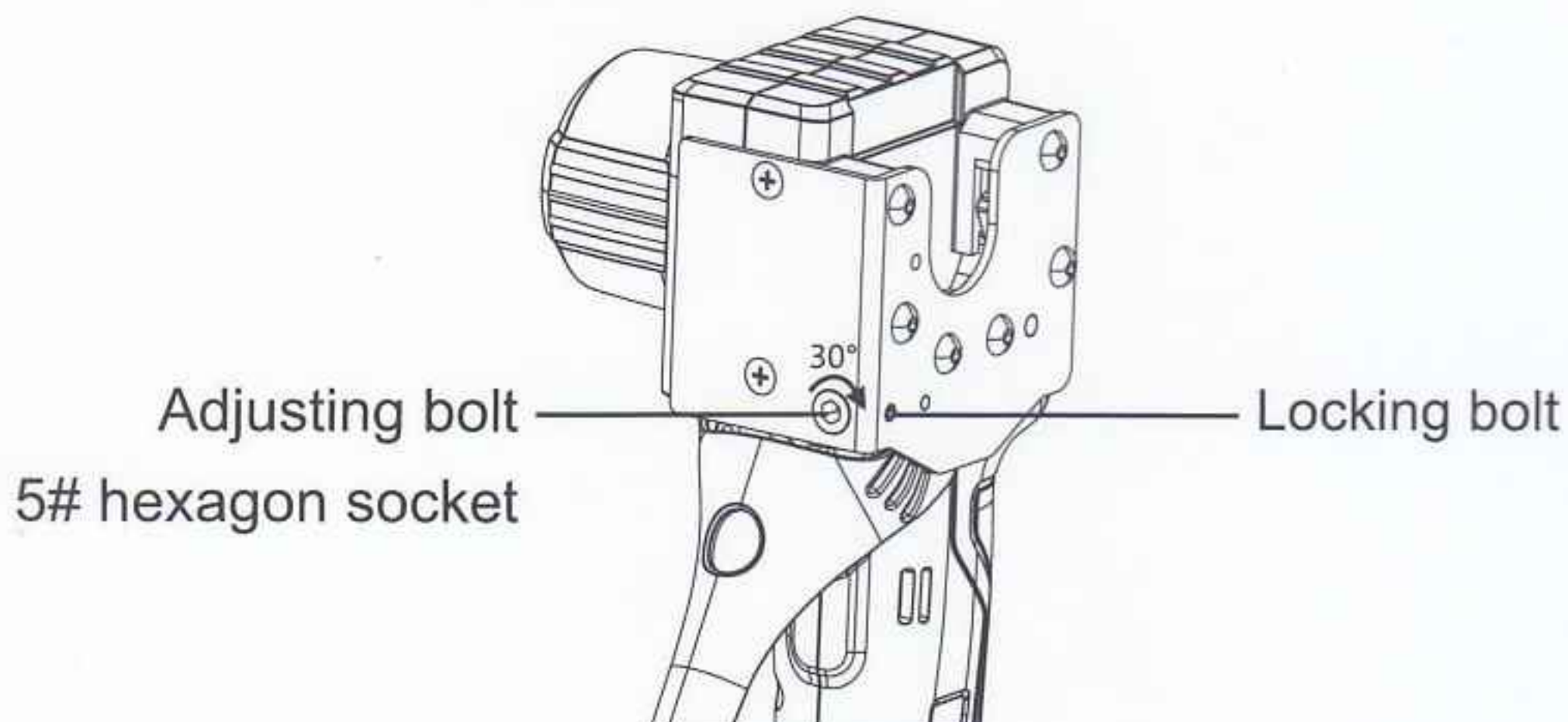
2. Put the battery into the charger's slot.



Normal charging: The indicator flashes slowly
Fully charged: The indicator stays on

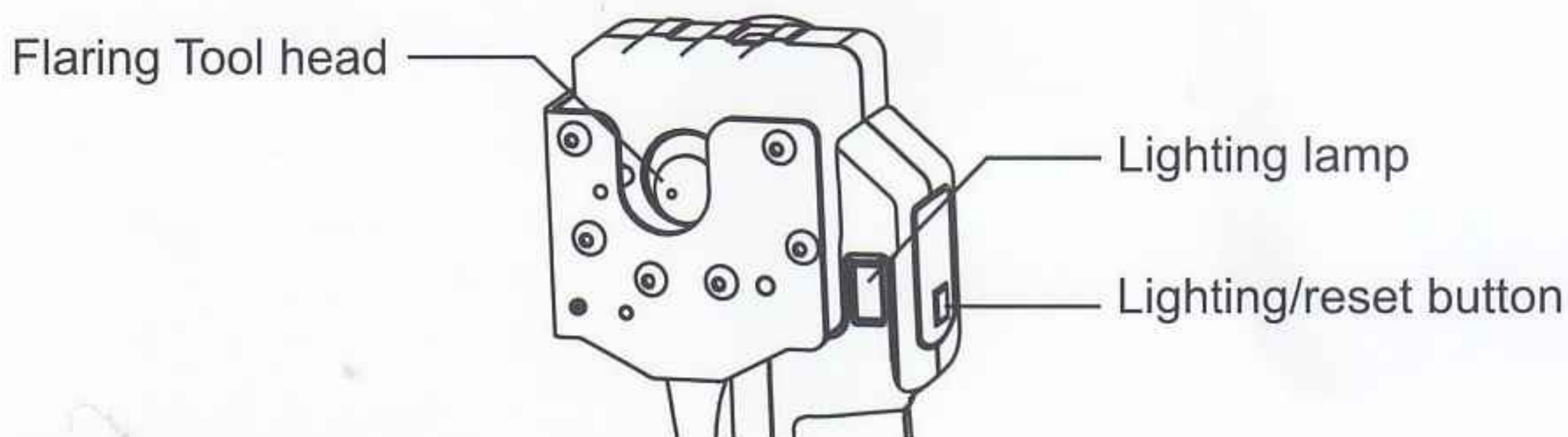
VI. Adjust the locking mechanism

1. Insufficient clamping force of handle will lead to smaller bell-mouth of the copper pipe, in this case, please turn the adjusting bolt clockwise to make adjustment.



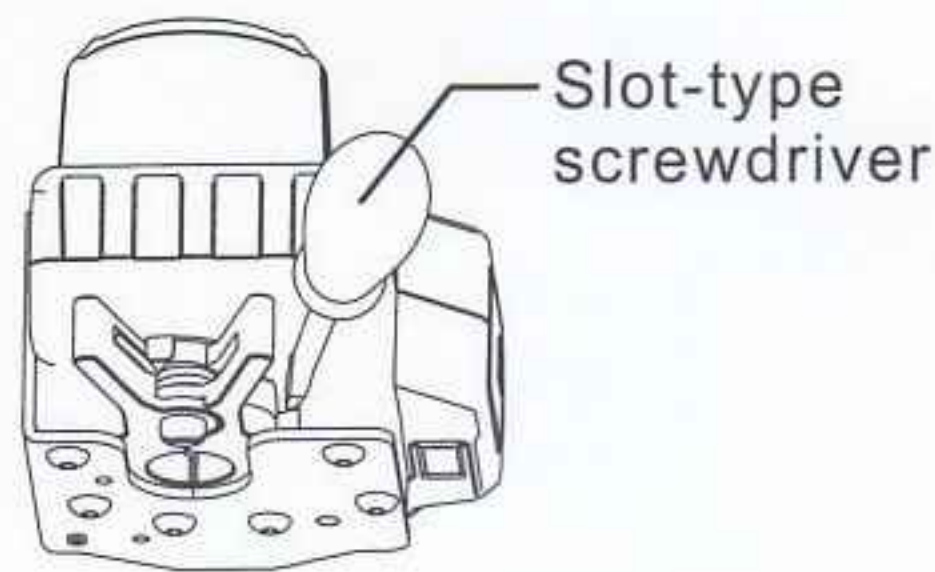
VII. Lighting/reset

1. Lighting: Press the lighting button when necessary.
2. Flaring Tool head resetting: Press and hold the reset button for at least 2s



Precautions

- I. Any clamp failing to hold copper pipe should not be put into the product, otherwise, it the clamp and the product may be damaged;
- II. Don't release the handle during product operation, in order to prevent struck failure of the product.
- III. If the start switch is accidentally activated in the non-operating state (with no clamp in), please pull open the handle to shut down the product, then press and hold the "lighting/reset" button for 2s to reset the product.
- IV. If the handle is accidentally released during the pipe flaring, please first press and hold the "lighting/reset" button for 2s, to retract the flaing tool head. If the Flaring Tool head can't be retracted, please insert a slot-type screwdriver into the clamp side beside the indicator, and gently knock the screwdriver handle downwards, then press and hold the "lightning/reset" button for 2s to simply retract the Flaring Tool head.
- V. If it is difficult to secure the handle after adjusting the locking mechanism, it implies excessive adjustment, please rotate the adjusting bolt anti-clockwise until the handle can be secured normally.
- VI. After the clamp is put into the product, the clamp mark must be aligned with the Flaring Tool mark; if they are not aligned, please do not lock the handle or start the product.
- VII. The product indicator will automatically be powered off after 20s not in use. manual shutdown is not required.



VIII. Troubleshooting guide

Electrical fault		
Warning signal	Possible cause	Solution
Operation indicator: flashes once and goes off	Shortcircuit	Contact the manufacturer or the distributor for repair
Operation indicator: flashes twice and goes off	Id detection failure	Operate the battery pack originally provided by the manufacturer
Operation indicator: flashes three times and goes off	Overheat/undercooling protection of the battery pack	Wait for temperature drop or rise of the battery pack
Operation indicator: flashes four times and goes off	Overload	Contact the manufacturer or the distributor for repair
Fast flashes of the charger indicator	Battery pack circuit failure or battery pack damage	Replace with a new battery pack
Other failure		
Problem	Possible cause	Solution
No operation when the operation button is pressed, or product shutdown during operation	1. Low power of battery pack	Charge the battery
	2. Circuit or motor failure	Contact the manufacturer or the distributor for repair
	3. The contact copper is contaminated by foreign matters or dust	Clear the foreign matters and dust
The bell-mouth of the pipe end is too small	1. The locking force of the handle is insufficient	Loosen the locking bolt, adjust the locking bolt clockwise by 30° each time, measure the appropriately upon each adjustment, then lock the bolt if it is appropriate (see the attached Figure I)
	2. There is evident clearance between the pipe end and the baffle	Fit the pipe end to the baffle when clamping the copper pipe
	3. Pipe burrs disallow fitting to the baffle	Remove the burrs by a scraper blade
Abnormal scratch on the inner wall of the bell-mouth (other than annular fine marks)	Metal scrap or dust is attached to the pipe end or the pipe inner wall	Remove the metal scraps or dust
Severe material accumulation on the outer wall of bell-mouth (ignorable if minor)	Metal scrap or dust is attached to the clamp	Remove the metal scraps or dust
	Severe wear of the clamp head	Purchase and replace with a new clamp

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