

Imperial Tools (Category 65)

TUBE CUTTERS

For hard or soft copper, aluminium, brass, thin wall steel, stainless steel and other tubing

65-TC1000 & 65-TC1010 Heavy Duty Tube Cutters For 1/8" to 1-1/8" O.D. Tube

- Enclosed hardened steel thrust bearing feed mechanism for smooth cutting action
- Imperial's unique design eliminates spiraling for clean right angle cuts.
- Nickel plated aluminum body
- Foldaway hardened steel reamer removes inside burrs cleanly. Filing surface removes outside burrs
- Cutter wheels are made of the highest quality wear and abrasion resistant chromium steel and precision machined for accurate cutting and long life
- Includes 2 cutting wheels. One spare is carried under the fold out the retractable reamer

Other models include the:

65-TC1020 - a combination cutter and tube restrictor for soldering.



The **65-TC1010** is specifically designed for the rigours of cutting Stainless Steel, monel and other hard temper tubing.

65-TC1550 Heavy Duty Tube Cutter **NEW!!** For 1/8" to 1-1/8" O.D. Tube

- Imperial's newest tube cutter!
- Lower profile swing radius - 4.1/4"
- Retractable rotary style reamer
- Lightweight die cast aluminum body
- Enclosed hardened steel thrust bearing feed mechanism for smooth cutting action
- Imperial's unique design eliminates spiraling for clean right angle cuts.
- Cutter wheels are made of the highest quality wear and abrasion resistant chromium steel and precision machined for accurate cutting and long life
- Includes 2 cutting wheels



****Available in clamshell packaging****

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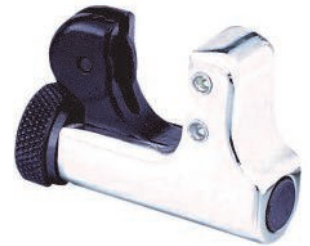
TUBE CUTTERS

For hard or soft copper, aluminium, brass, thin wall steel, stainless steel and other tubing

65-TC1050 Mini Tube Cutter

For 1/8" to 5/8" O.D. Tube

- Designed for use in tight quarters where other tube cutters won't fit
- 1.1/4" swing radius
- Enclosed feed screw minimizes contamination assuring continued smooth operation
- Corrosion resistant steel rollers positioned at bottom of cutter allow for easier cutter engagement on tubing and smoother cutting action



65-TC1050RH Ratcheting Tube Cutter **NEW!!**

For 1/8" to 5/8" O.D. Tube

- Includes the TC1050 mini tube cutter which can easily be removed from the handle
- Six independent drive pawls provide a 15" arc swing
- Lifetime warranty
- Available in clamshell packaging



LARGER CAPACITY TUBE CUTTERS

65-TC174F Tube Cutter

For 3/8" to 1-1/8" O.D. Tube

- Small swing radius - 1.15/16"
- Includes 2 general purpose cutting wheels



65-TC312FC Tube Cutter

For 1/4" to 1-5/8" O.D. Tube

- Larger version of the TC1000 with the same specifications
- Includes 2 general purpose cutting wheels



65-TC206FBP Tube Cutter

For 3/8" to 2-5/8" O.D. Tube

- Ratchet feed mechanism speeds up cutting operation
- Extra wide flare cut off groove in rollers to accommodate flares on larger size tubing
- Includes a spare cutter wheel to cut schedule 40 PVC pipe up to 2"



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TUBE CUTTERS

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DEBURRING TOOLS

65-210F Deburring Tool - The rotary style blade is perfect for removing burs from holes and edges. Internal storage cavity to store spare blades. Supplied with one spare blade. Suitable for copper, steel, aluminum, cast iron, brass and plastic tubing.



65-208F Reaming and Deburring Tool - Reams both inside and outside of tube. Deburrs clockwise and anti clockwise. Suitable for copper, aluminium and brass tube.

65-208FSS Reaming and Deburring Tool - Reamer for stainless steel tubing, hard or soft copper, aluminium, brass and steel tubing. Tungsten hardened steel cutter blades.



SPARE PARTS

Cutting Wheels

65-TC1000B - General purpose cutting wheel
Suits the TC1000, TC1550, TC312FC and the TC174F

65-TC1010B - Wheel for continuous cutting of stainless steel, monel and other hard temper tubing
Suits the TC1010, TC1000, TC1550, TC312FC and the TC174F

65-TC1020B - Constrictor wheel for producing sweat joints
Suits the TC1020

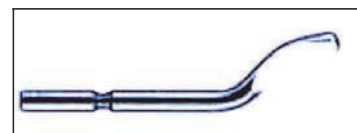
65-TC1050B - General purpose cutting wheel
Suits the TC1050

65-S74761 - General purpose cutting wheel
Suits the TC206FBP

65-S10000770 - Cutting wheel for PVC pipe
Suits the TC206FBP

Deburring Blades

65-S10001087 - Deburring replacement blade



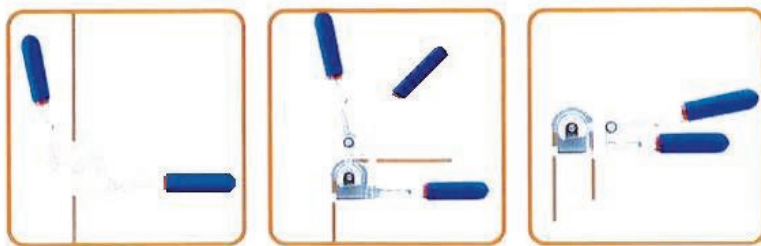
Imperial Tools (Category 65)

TUBE BENDERS

For bending soft copper, aluminum, brass, thin wall steel and thin wall stainless steel

65-470FH Triple Head 180° Tube Bender with Roto-Lok Indexing Handle
 Bends 3/16" to 3/8" O.D. Tube

- Patented quick action indexing lever repositions two-stage handle midway through bend when both handles begin to meet. This feature allows better control and no crossing of hands when fabricating 180° bends.
- Optimum bend radius for each tube size
- Calibrated markings
- Compact design
- Available in clam shell packaging



Bend to 90°

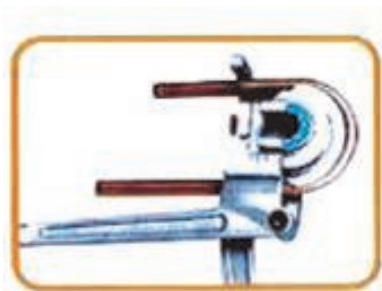
Move handle to start second bend

Lower handle to complete bend

TUBE O.D.	RADIUS
3/16	7/16
1/4	9/16
5/16	11/16
3/8	15/16

65-370FH Triple Head 180° Tube Bender
 Bends 3/16" to 1/2" O.D. Tube

- Makes smooth, tight radius bends
- Calibrated markings
- Available in clam shell packaging



TUBE O.D.	RADIUS
1/4	11/16
3/8	1-1/8
1/2	1-1/2



Easy 180° bends in one swift motion

Imperial Tools (Category 65)

TUBE BENDERS

For bending soft copper, aluminum, brass, thin wall steel and thin wall stainless steel

65-367FH Triple Head Tube Bender

Bends 1/8" to 1/4" O.D. Tube

- For soft copper, aluminium and steel
- Calibrated markings for making accurate left hand, right hand and offset bends
- Ninety degree start requires less effort - making bending fast and easy



65-368FH Triple Head Tube Bender

Bends 3/16" to 3/8" O.D. Tube

- For soft copper, aluminum and steel
- Calibrated markings for making accurate left hand, right hand and offset bends
- Ninety degree start requires less effort - making bending fast and easy



Spring Type Tube Benders

Allow hand bending of soft tubing.

65-101F Set of 6 benders for 1/4", 5/16", 3/8", 7/16", 1/2" and 5/8" O.D. tube. Individual springs also available



SINGLE HEAD TUBE BENDERS

65-364FHA Lever Type Tube Benders

For 1/8" - 1" O.D. Tubing

Also available in metric sizes 6-12 mm

- Each tool bends one size of tube
- Features telescopic handles for increased leverage



65-364FHB Swivel Handle Tube Benders

For 1/4" - 1/2" O.D. Tube

- Each tool bends one size.
- The swivel handle can be repositioned midway through a bend when both handles begin to meet. This feature allows easy fabrication of bends up to 180° with less effort and better control, without the crossing of handles.



Lever type tube bender kits also available. Each tool quickly adapts to all sizes in its range by changing forming wheel and block.

For more information on the complete range of Imperial tube benders available , including gear type benders, please contact our sales staff

Imperial Tools (Category 65)

TUBE BENDERS

For bending soft copper, aluminum, brass, thin wall steel and thin wall stainless steel

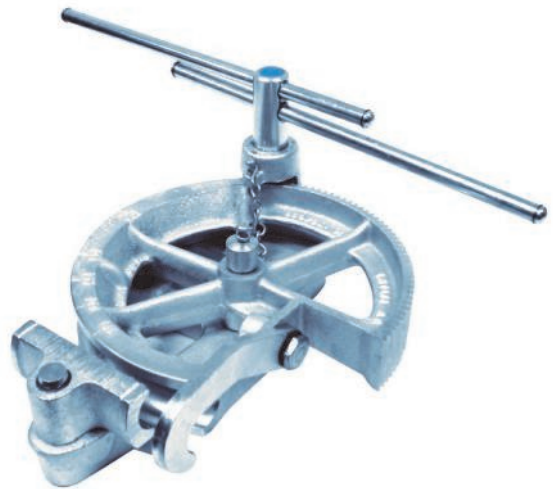
SINGLE HEAD TUBE BENDERS

65-270F Series Benders

Available in sizes for 3/8" to 1-1/8" O.D. tubing.

For all bending work. Spur-gear type with 10-to-1 ratio for easy bending of all tempered tubing. Floating shoe aligns tube perfectly on calibrated forming wheel. Pull-pin on wheel speeds repositioning for bends over 90°. Portable. Can be hand held, clamped in vice or bolted to bench.

Code	Tube OD	Radius. Centre to centre of tube	Min return from ctr to ctr of tube	W/Thickness (in)
65-270F-06	3/8"	1.75"	4.5"	.030 to .060
65-270F-08	1/2"	2.5"	6"	.035 to .065
65-270F-10	5/8"	3"	7.5"	.040 to .072
65-270F-12	3/4"	4"	9.5"	.042 to .083
65-270F-14	7/8"	4"	9.5"	.045 to .083
65-270F-16	1"	4"	9.5"	.065 to .095
65-270F-18	1.1/8"	4"	9.5"	.065 to .095

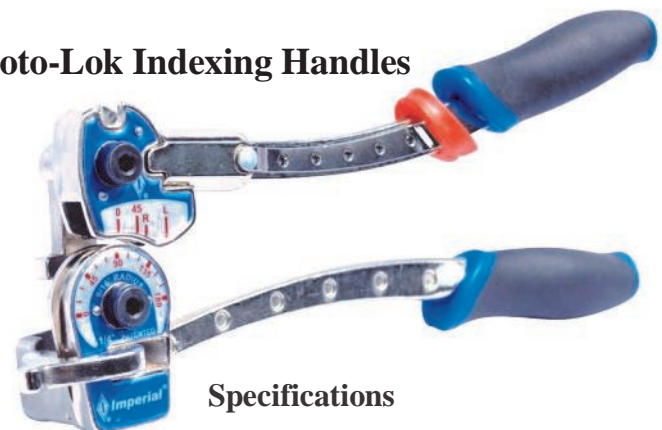


65-664FH Heavy Duty Tube Bender with Roto-Lok Indexing Handles

For 1/4", 3/8" and 1/2" O.D. Tube

Also available for metric sizes 6-12 mm

- New design for accurate and tight bends up to 180° in stainless steel and other tough metals.
- Patented, quick action trigger release repositions two-stage handle midway through a bend when both handles begin to meet. This feature allows easy fabrication of optimised bends up to 180° with reduced effort, better control and no crossing of handles!
- Rollers in bending handle reduce friction and bending effort; eliminate scoring of tubing.
- Comfortable and durable ergonomically moulded cushion grips.
- Vice lug for mounting in vice.
- Each tool bends one size



Specifications

Hydraulic Tubing

High-quality, soft annealed, seamless carbon steel hydraulic tubing ASTM A179 or equivalent. Hardness 72 HRB (130 HV) or less.

Stainless Steel

Fully annealed high-quality (Type 304, 316 etc.) (seamless or welded and drawn) stainless steel hydraulic tubing ASTM A269 or A213, or equivalent. Hardness 90 HRB (200 HV or less)

65-664-FH-04 (664FH6mm) Carbon & Stainless 0.028" to 0.065"

65-664-FH-06 (664FH8mm & 10MM) Carbon 0.035 to 0.065 -
Stainless 0.035" to 0.083"

65-664-FH-08 (664FH12mm) Carbon & Stainless 0.035" to 0.083"

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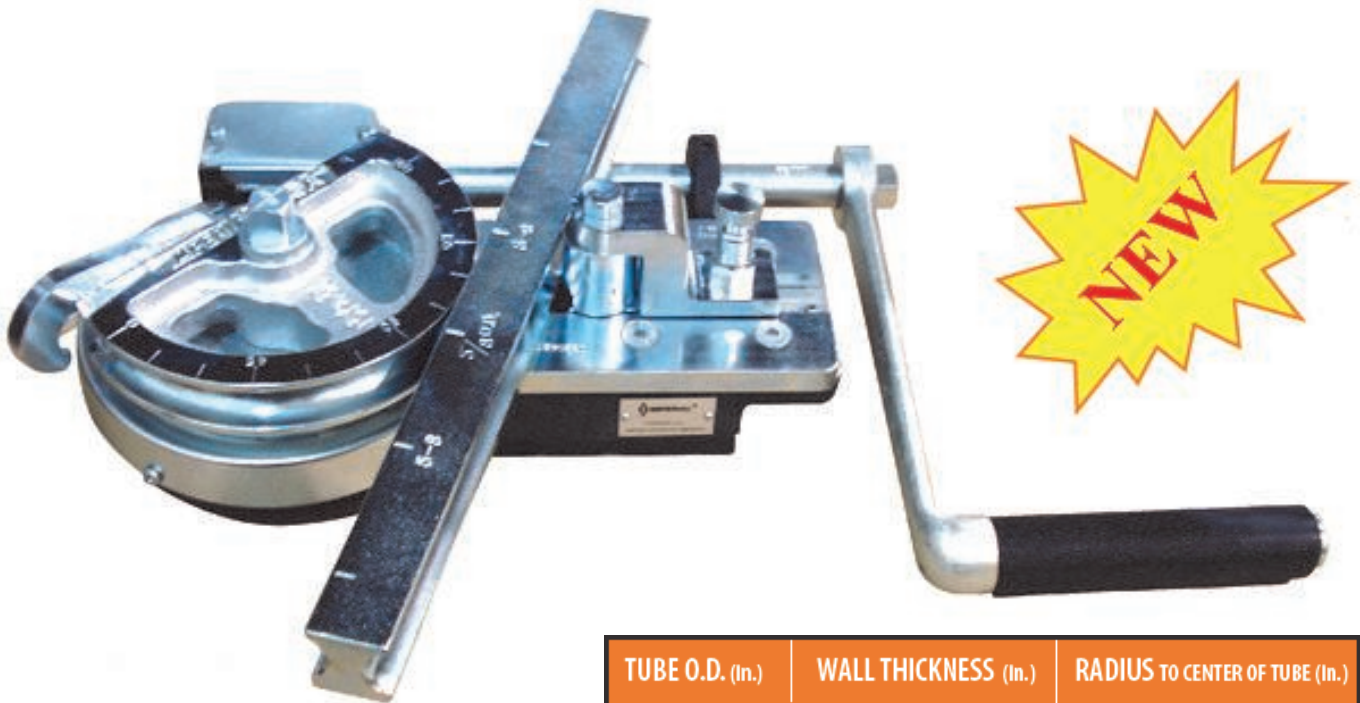
TUBE BENDERS

For bending soft copper, aluminum, brass, steel and stainless steel

WORM GEAR TUBE BENDER

For 1/4", 5/16", 3/8", 1/2", 5/8" and 3/4" O.D. tubing.

65-600F



Bend aluminum, copper, brass, stainless steel and titanium with ease

TUBE O.D. (In.)	WALL THICKNESS (In.)	RADIUS TO CENTER OF TUBE (In.)
1/4	.016 to .049	3/4
5/16	.020 to .065	1
3/8	.028 to .083	1-1/4
1/2	.035 to .083	2
5/8	.042 to .083	2-1/2
3/4	.049 to .083	3



* All material to be bent must be of a bending temper.

- Precision tool for highest quality work.
- Worm gear type with 50-to-1 ratio and crank with revolving hand grip, keeps effort at a minimum and provides maximum accuracy..
- Follow bar eliminates drawing action and keeps the tube virtually perfectly round.
- Adjustable pressure roller positions quickly in index holes.
- Enclosed gears.
- Furnished in steel carrying case. Size of kit: 35 x 23 x

For more information on the complete range of Imperial tube benders available , including gear type benders, please contact our sales staff

Imperial Tools (Category 65)

FLARING TOOLS

For soft tubing only - copper, aluminum and brass

45° FLARING TOOLS

65-195FC 45° FLARING TOOL

For 3/16" to 5/8" O.D. Tube

- Flares 7 sizes of tubing.
- Forged steel slip-on yoke and hardened flaring bar
- Positive clamping action of bars prevents tube slippage



65-103FS 45° LARGE SIZE FLARING TOOL

For 3/4", 7/8" & 1" O.D. Tube

- Forged steel slip-on yoke and hardened flaring bar
- Positive clamping action of bars prevents tube slippage

65-500FC 45° ROL-AIR FLARING TOOL

Flares and Burnishes 3/16" to 5/8" O.D. Tube

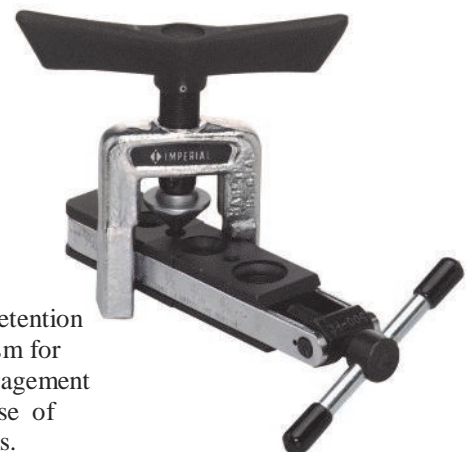
- Faceted, hardened steel chrome finished cone rolls out and burnishes perfect 45° flares above the tube holding mechanism reducing the need for deburring
- Original wall thickness is maintained at base of flare
- Heat treated dies grip tubing without scoring



Flares rolled out above die bar by super smooth faceted cone. Maintains the integrity of the tubing.



Unique detention mechanism for rapid engagement and release of die blocks.



65-525F "GRABBER" 45° ROL-AIR FLARING TOOL

Adjustable opening holds all sizes

Flares and Burnishes 3/16" to 5/8" (and Metric) O.D. Tube

- Unique, self adjusting tube holding mechanism permits flaring any size tubing within the range 3/16" - 5/8" O.D. and 4.75mm to 16mm O.D. tube, Innovative, single opening design is more compact and easier to use than conventional multi opening flaring bars
- Faceted, hardened steel chrome finished cone rolls out and burnishes perfect 45° flares above the tube holding mechanism reducing the need for deburring.



Imperial Tools (Category 65)

FLARING TOOLS

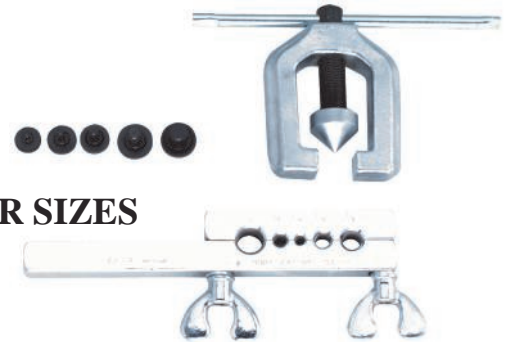
For flaring soft copper, aluminum, brass, steel and stainless steel tube

45° DOUBLE FLARING TOOLS

65-93FB 45° DOUBLE FLARING TOOL

Flares 3/16" to 1/2" O.D. Tube

- Recommended for Bundy and other annealed soft tubing.
- Also makes single and double flares in soft copper or aluminum tube
- Small, lightweight and easy to handle



65-195FB DOUBLE FLARING TOOL FOR LARGER SIZES

Flares 1/4" to 3/4" O.D. Tube

- Designed for the automotive air-conditioning market
- Makes double flares in soft copper or aluminum tube

37° FLARING TOOLS

65-400F 37° ROL-AIR FLARING TOOL

For 3/16" to 5/8" O.D. Tube

- Forms 37° flares to government specifications in steel, stainless steel (including MIL- T-6845), titanium and other metal tubing.
- Positive stop gauge assures correct size of flare.
- Special burnishing action polishes the flare face
- Three rollers in flaring cone roll out 37° flare above the die block.
- Roller action cuts effort required
- Maintains original tube wall thickness - eliminates stress concentration and eliminates the need for deburring.
- Extension on yoke for clamping in vice
- Satin chrome and black finish
- Furnished in sturdy tool case.



Feed, Release and Burnishing Mechanism. Flare Control Gauge



3 Rollers in Flaring Cone. Flare Formed above die block

Imperial Tools (Category 65)

FLARING TOOLS

For soft tubing only - copper, aluminum and brass

37° FLARING TOOLS

65-507FB ROL-AIR 37° FLARING TOOL

For 3/16" to 5/8" O.D. Tube

- For use with copper, aluminum and brass tubing
- Faceted, hardened steel chrome finished cone rolls out and burnishes perfect 37° flares above the tube holding mechanism reducing the need for deburring.
- New slip-on yoke permits use in tight quarters
- Larger handle with better leverage and precision threads on the feed screw make flaring effortless



65-537F LARGE SIZE ROL-AIR 37° FLARING TOOL

For 3/4" to 1-1/4" O.D. Tube

- For use with soft steel, copper, aluminum and fully annealed stainless steel tube
- Three cylinders in the flaring cone roll out and burnishes perfect 37° flares above the tube holding mechanism reducing the need for deburring.



FLARING and SWAGING TOOLS

65-275FS 45° FLARING and SWAGING TOOL

Flares 1/8" to 3/4" O.D. Tube

- Flares and swages. Converts quickly. Swivel type swaging adaptors and flaring cone are hardened steel chrome finished for easy operation
- Supplied in a tool case



Imperial offer a comprehensive range of tube cutters, benders and flaring tools. Many of which are not listed in this catalogue. If you require a product not listed please contact our sales staff for more information

Imperial Tools (Category 65)

TUBING TOOL KITS

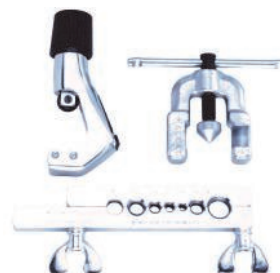
65-120F CUTTING and FLARING KIT

CONTAINS: TC1000 Tube cutter for 1/8" - 1-1/8" O.D. tube
375FC 45° Flaring tool for 1/8" - 3/4" O.D. tube



65-122FA CUTTING and FLARING KIT

CONTAINS: TC1000 Tube cutter for 1/8" - 1-1/8" O.D. tube
437FB 37° Flaring tool for 3/16" - 5/8" O.D. tube



65-275FSC CUTTING, FLARING and SWAGING KIT

CONTAINS: TC1000 Tube cutter for 1/8" - 1-1/8" O.D. tube
275FS Flaring and swaging tool for 1/8" - 3/4" O.D. tube



Miscellaneous Tools (Category 65)

Nylon Tube Cutter.

Cuts tube from 1/8" to 1/2"

Code : 65-NTC08



Spare Blade for Nylon Tube Cutter.

Suits 65-NTC08

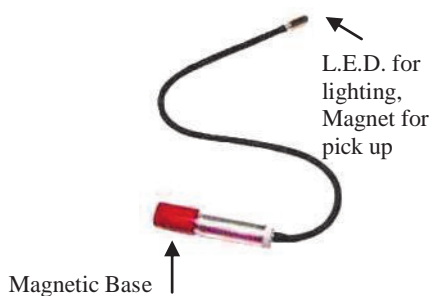
Code : 65-NTC08B



Flexible L.E.D. Flashlight

Long flexible head. Strong magnetic base for positioning light in engine bays etc. Magnetic head for picking up parts.

Code : 65-LED-FF



Plastic Pipe Cutter.

Cuts up to 22mm O.D.

Code : 65-PPC22