



PROFESSIONAL PRODUCTS...
SUPERIOR RESULTS™

THE HARRIS PRODUCTS GROUP
1390N—BRAZING TIP FLOW CHART
PROPANE
F43 MIXER & 43-2 HANDLE

TIP SIZE	NORMAL BRAZING				MAX HEATING			
	Oxygen		Propane		Oxygen		Propane	
	Press PSI	Flow CFH	Press PSI	Flow CFH	Press PSI	Flow CFH	Press PSI	Flow CFH
20N	10	200	2	50	20	350	5	88
30N	15	300	4	75	30	475	8	120
80N	25	400	6	100	50	700	12	175

NOTES:

Use 3/8 I.D. Hose

Pressures shown are suitable for lengths up to 25 feet.

Increase pressures for longer lengths.

Normal brazing settings are for soft flames.

Max heating settings are for strong, forcing flames.

Flow rates are shown for 4:1 ratio carburizing. For 5:1 ratio oxidizing, multiply propane flow by 0.8 oxygen flow unchanged.

High purity propane grade HD-5 should be used with this equipment.

Propylene based fuels use ratios from 2:5:1 to 4:1 with the same oxygen flow rates as propane.

Total heat output (BTU/Hr) = Fuel Gas Flow x 2563 (Propane).

Total heat output (BTU/Hr) = Fuel Gas Flow x 2370 (Propylene).