



PROFESSIONAL PRODUCTS...
SUPERIOR RESULTS™

THE HARRIS PRODUCTS GROUP

1390N BRAZING TIP FLOW CHART

FOUR OUNCES OF NATURAL GAS

TIP SIZE	MIXERS	NORMAL BRAZING			MAX HEATING			Recommended Hose I.D.
		Oxygen Press PSI	Oxygen Flow CFH	Nat. Gas Flow CFH	Oxygen Press PSI	Oxygen Flow CFH	Nat. Gas Flow CFH	
4N	B-43-4	20	12	6	40	20	10	1/4"
5N	B-43-5	25	13	6.5	50	25	12.5	1/4"
6N	B-43-6	25	15	7.5	50	30	15	1/4"
7N	B-43-7	30	20	10.5	50	35	17.5	1/4"
8N	B-43-8	30	25	12.5	60	40	20	1/4"
9N	B-43-9	30	30	15	60	55	27.5	3/8"
10N	B-43-10	35	35	17.5	65	60	30	3/8"
13N	B-43-15	40	60	30	65	85	42.5	3/8"
15N	B-43-15	45	65	32.5	75	100	50	3/8"
20N	B-43-N	50	185	92.5	70	250	125	3/8"
30N	B-43-N	55	200	100	80	275	137.5	3/8"
80N	B-43-N	60	215	107.5	90	300	150	3/8"
4N	H-16-S	15	15	7.5	30	30	15	1/4"
5N	H-16-S	15	15	7.5	35	33	16.5	1/4"
6N	H-16-S	20	22	11	40	37	18.5	1/4"
7N	H-16-S	25	26	13	50	44	22	1/4"
8N	H-16-S	30	30	15	60	52	26	3/8"
9N	H-16-S	35	33	16.5	70	60	30	3/8"
10N	H-16-S	40	37	18.5	80	66	33	3/8"

NOTES:

Total heat output (BTU/Hr.) = Natural Gas Flow x 1000 (BTU/Cu.Ft.).

Flow rates based on methane (CH₄) fuel gas.

Normal (brazing) settings are for soft flames.

Max (heating) settings are for strong, forcing flames.

Gas valve must be throttled to set neutral flame.

At 2:1 oxygen/natural gas ration, oxygen valve is wide open.

These settings allow flame adjustments from carburizing (fuel rich) through neutral to oxidizing flames used for max heat output.

Hose sizes are suitable for lengths up to 25 feet. Increase oxygen pressure for longer lengths.