



PROFESSIONAL PRODUCTS...
SUPERIOR RESULTS™

THE HARRIS PRODUCTS GROUP

1390N BRAZING TIP FLOW CHART

PROPANE

TIP SIZE	NORMAL BRAZING				MAX HEATING				RECOMENDED HOSE ID Inches
	Oxygen		Propane		Oxygen		Propane		
	Press. PSI	Flow PSI	Press. PSI	Flow SCFH	Press. PSI	Flow CFH	Press. PSI	Flow CFH	
4N	2	20	1	5	3	30	2	7.5	3/16"
5N	2	22	1	5.5	4	35	3	7.8	3/16"
6N	2	25	2	6.3	5	45	3	11.2	3/16"
7N	3	30	2	7.5	6	55	4	13.8	3/16"
8N	3	35	2	7.8	8	70	6	17.5	1/4"
9N	4	40	3	10	10	85	7	21.3	1/4"
10N	4	45	3	11.2	12	100	8	25	1/4"
13N	7	100	4	25	12	150	8	38	1/4"
15N	12	150	8	38	15	200	12	50	3/8"
20N	15	200	12	50	20	250	16	63	3/8"
30N	18	225	14	56	25	300	20	75	3/8"
80N	20	250	16	63	30	325	24	81	3/8"

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6N	3	25	2	6.3	6	45	4	11.2	3/16"
7N	3	30	2	7.5	9	55	5	13.8	1/4"
8N	4	35	2	7.8	13	70	6	17.5	1/4"
9N	5	40	3	10	16	85	7	21.3	1/4"
10N	6	45	4	11.2	20	100	8	25	1/4"

NOTES:

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.

Hose sizes are suitable for lengths up to 25 feet. Increase the pressures for longer lengths.