



PROFESSIONAL PRODUCTS...  
SUPERIOR RESULTS™

## THE HARRIS PRODUCTS GROUP

### 8490N TIP FLOW CHART

### FOUR OUNCE NATURAL GAS & PROPANE

TIP SIZE	NORMAL BRAZING			MAX HEATING			Recommended Hose Size I.D.
	Oxygen Press PSI	Flow CFH	Nat. Gas Flow CFH	Oxygen Press PSI	Flow CFH	Nat. Gas Flow CFH	
4N	6	6	2	12	12	6	3/16"
5N	8	8	4	16	16	8	3/16"
6N	10	10	5	20	20	10	3/16"
7N	15	15	7.5	25	24	12	1/4"
8N	18	20	10	30	30	15	1/4"

TIP SIZE	NORMAL BRAZING				MAX HEATING				Recommended Hose I.D.
	Oxygen Press PSI	Flow CFH	Propane Press PSI	Propane Flow CFH	Oxygen Flow PSI	Press PSI	Flow CFH	Propane Press PS I	
4N	2	8	1	2	3	14	1	3.5	3/16"
5N	2	10	1	2.5	4	18	1	4.5	3/16"
6N	3	12	1	3	5	24	2	6	3/16"
7N	4	20	1	4	5	30	2	7.5	1/4"
8N	5	24	2	6	6	36	3	9	1/4"

**NOTES:**

Normal brazing settings are for soft flames.

Max heating settings are for strong, forcing flames.

With oxygen valve wide open, the pressure settings allow carburizing (fuel rich), neutral, or oxidizing flames by adjustments to the fuel gas valve.

Hose sizes are suitable for lengths up to the fuel gas valve.

Increase pressure for longer lengths.

Natural gas flow rates based on methane (CH<sub>4</sub>).

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

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

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