

## Model 15-4

### Lightweight Torch Handle



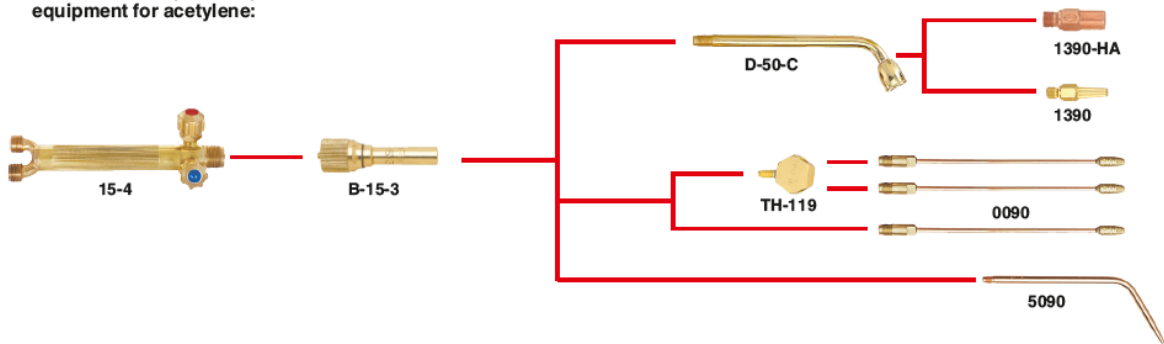
The Model 15 is a lightweight handle with front valves for more convenient adjustment. It is designed to permit changing flame settings with one hand. The Model 15 is compatible with all fuel gases. It can be used for welding, brazing and light heating.

#### Features:

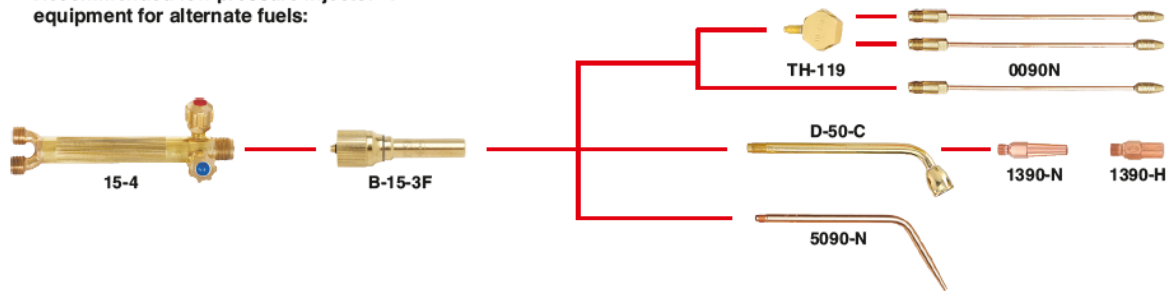
- G 1" or 3/8" - 24 - UNF hose connections.
- Capacity: welds up to 7,9 mm.
- Length: 146 mm.
- Weight: 227 g.

MODEL NUMBER	LENGTH (mm)	WEIGHT (g)	FUEL GAS	MIXER	MIXING SYSTEM	INLET	WELDING/ BRAZING TIPS	HEATING TIPS	ACCESSORIES
15-4	146	227	Oxy-acetylene/ hydrogen	B 15-3, B 15-3-F	E & F	3/8" - 24 - UNF	5090 1390 0090	1390-HA 1390-H	D-50-C Tip Tube TH-119 Twin Tip Holder
15-4GB			Oxy-propane/ butane Oxy-natural gas/ Methane			G 1/4"	5090-N 1390-N 0090-N		

Recommended positive pressure "E" equipment for acetylene:



Recommended low pressure injector "F" equipment for alternate fuels:



### Acetylene welding and brazing tips

WELDING / BRAZING					EQUAL PRESSURE		LOW PRESSURE	
TIPS 5090	TIPS 1390	FLEXIBLE TIPS 0090	FLOW (l/h)	THICKNESS (mm)	OXYGEN (bar)	ACETYLENE (bar)	OXYGEN (bar)	ACETYLENE (bar)
-	1390-00	-	25	-				
5090-0	1390-0	-	45	0,2 - 0,5				
5090-1	1390-1	0090-1	65	0,5 - 1,0				
5090-2	1390-2	-	100	-				
5090-3	1390-3	0090-3	160	1,0 - 2,0	0,3 - 0,8	0,3 - 0,8	2,5	0,015 - 0,2
5090-4	1390-4	-	250	-				
5090-5	1390-5	0090-5	350	2,0 - 4,0				
5090-6	1390-6	0090-6	500	4,0 - 6,0				
5090-7	1390-7	-	700	-				
5090-8	1390-8	0090-8	1000	6,0 - 9,0				

### Heating Tips data chart

TIPS	PRESSURE		FLOW	
	OXYGEN (bar)	ACETYLENE (bar)	OXYGEN (l/h)	ACETYLENE (l/h)
1390-HA	0,35	0,35	1100	1000

### Alternative Fuel Tips

			LOW PRESSURE		EQUAL PRESSURE		FLOW	
TIPS 1390-N	TIPS 0090-N	TIPS 5090-N	OXYGEN (bar)	FUEL GAS (bar)	OXYGEN (bar)	FUEL GAS (bar)	OXYGEN (l/h)	FUEL GAS (l/h)
1390-2N	0090-2N	-	1,0				300	75
1390-3N	-	5090-3N	1,0				550	140
1390-4N	0090-4N	-	1,4				700	175
1390-5N	-	5090-5N	1,8	0,015 - 0,2	0,3 - 1,0	0,3 - 1,0	900	225
1390-6N	0090-6N	-	1,8				1100	275
1390-7N	-	-	2,1				1350	345
1390-8N	0090-8N	5090-8N	2,1				1500	375
1390-9N	-	-	2,5				1650	415
1390-H	-	-	3,5	0,5	3,5	1,0 - 0,5	4200	1050