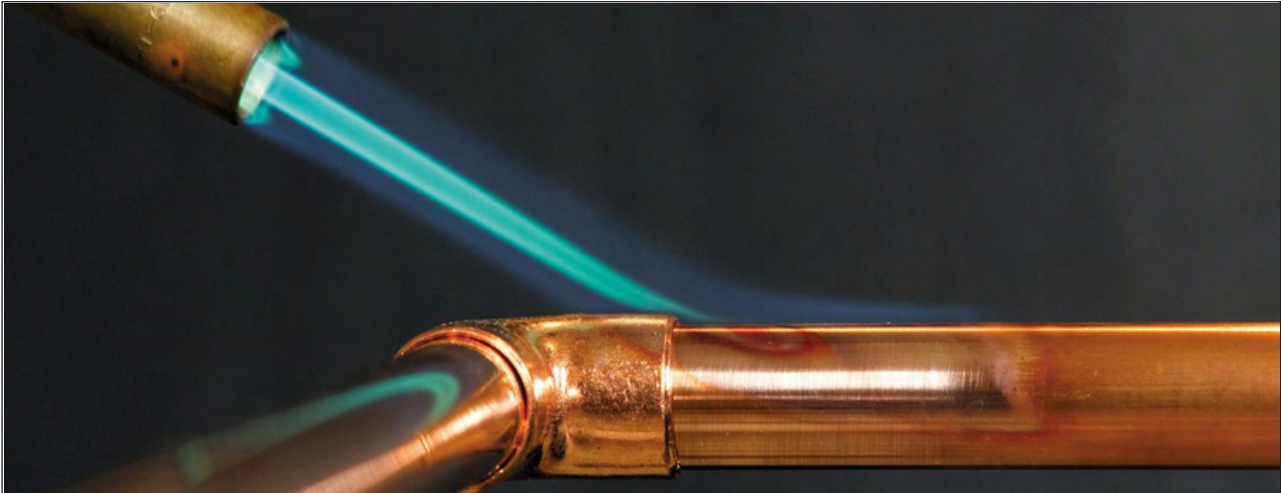




Core values, quality products

Copper tube and solder type fittings Data Sheet



1. Cut tube square with the cutter or fine hack saw (32-tooth the blade is recommended). Remove Burr.

2. Clean the outside end of the copper tube thoroughly with sand cloth or sandpaper at an equal depth of the fitting. Leave no dark spots.

3. Clean the inside of the fitting carefully to the tube stop with a wire brush.
Note: Sand cloth or sandpaper may also be used.

4. Apply heat uniformly around the fitting with a torch. When the brazing rod melts upon contact with the heated fitting, the proper brazing temperature has been reached. Remove the flame and feed the brazing rod slightly off-centre at the bottom of the joint. Proceed across the bottom of the fitting and up to the top centre position. Return to the starting point, and then proceed up the incomplete side to the top, again overlapping the filler metal. Wipe off surplus brazing alloy with a piece of cloth.



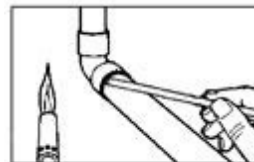
1 Cut tube to length & remove burr with file or scraper.



2 Clean outside of tube with sandpaper or sand cloth.



3 Clean inside of fitting with wire brush, sand cloth or sandpaper.



4 Apply heat with torch. When brazing rod melts upon contact with heated fitting, the proper temp for brazing has been reached. Remove flame & feed rod to the joint at one or two points until a ring of brazing appears at the end of the fitting.