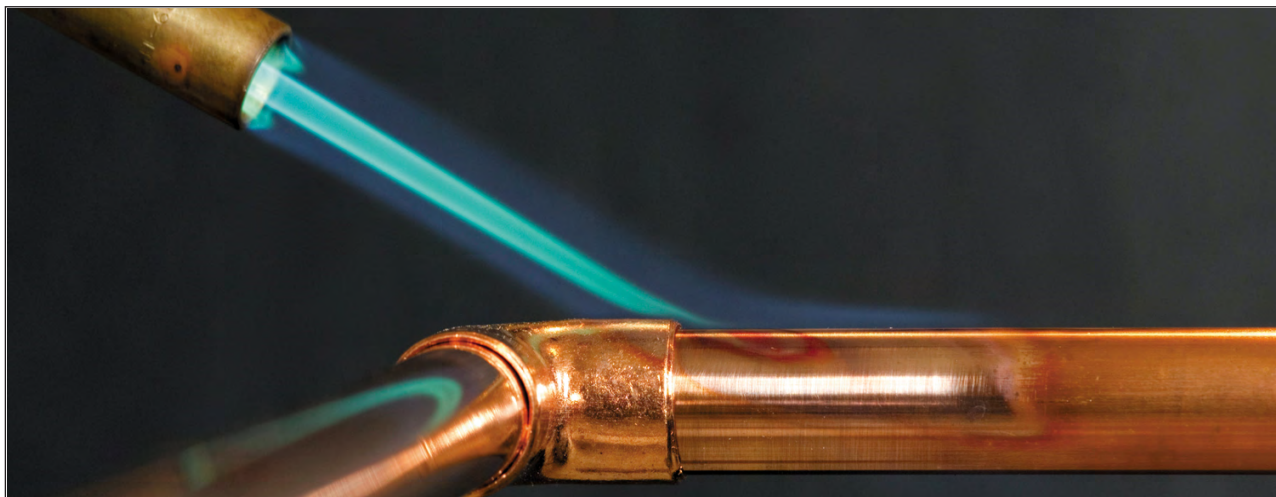


Copper tube and solder type fittings Data Sheet



1. Cut tube square with the cutter or fine hack saw (32 tooth blade is recommended). Remove Burr.
2. Clean outside end of copper tube thoroughly with sand cloth or sandpaper equal depth of fitting. Leave no dark spots.
3. Clean inside of fitting carefully to tube stop with wire brush. Note: Sand cloth or sandpaper may also be used.
4. Apply heat uniformly around the fitting with torch. When brazing rod melts upon contact with heated fitting, the proper brazing temperature has been reached. Remove flame and feed brazing rod slightly off center at the bottom of the joint. Proceed across the bottom of the fitting and up to the top center 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.



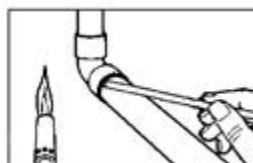
- 1 Cut tube to length & remove burr with file or scraper.



- 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.