



A Complete Line of High Quality Refrigerant Recovery and Recycling Equipment, Products, & Accesories

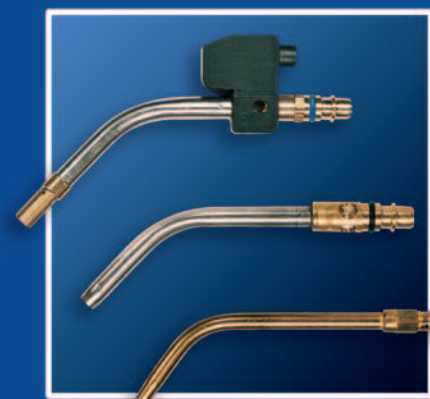


www.nrproducts.com

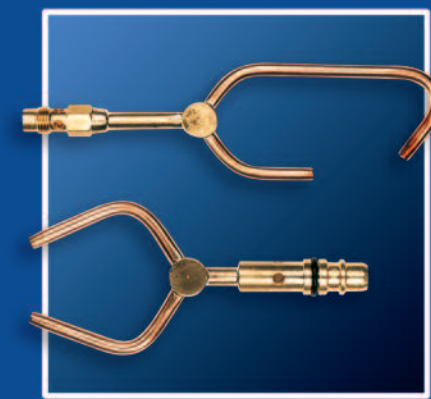
985 Wheeler Way, Langhorne, PA 19047
Phone: 215-638-8909 * Fax 215-638-9270



PROFESSIONAL TORCH EQUIPMENT



*America's Best
Value*





NKA125M12P (shown)

125 SERIES WELDING • BRAZING KITS

The ideal kit for all your light duty welding/brazing needs. This outfit compatible for cutting by adding the NTCA10 cutting attachment.

- Welds to 3/16", brazes to 1-1/2"
- Torch, regulators and hose have size “A” fittings
- Durable construction
- UL listed components

Available with or without cart or stand.

KIT NO.	CYLINDER CONNECTION STAND OR CART	CONTENT FOR ALL 125 KITS
NKA125M	MC Acet. Regulator	1 - NTW141TA Torch Handle 1 - N30331 Weld Tip
NKA125M12	MC Acet. Regulator & Steel Stand NC1200	1 - N30333 Weld Tip 1 - NSW12A Hose
NKA125M12P	MC Acet. Regulator & Plastic Stand NC1200P	1 - NMP35 Goggles 1 - NMP1 Lighter
NKA125B	B Acet. Regulator	1 - NEO25FA Oxy Regulator 1 - NEA25MA Regulator
NKA125B13	B Acet. Regulator & Steel NC1300 Cart	or 1 - NEA25BA Regulator



NKA325M12P (shown)

325 SERIES WELDING • BRAZING • CUTTING KITS

This unique kit has a special adaptor which converts the welding torch to use lower temperature air/gas soldering and brazing tips.

- Special adaptor added to convert welding torch to use high temperature air/gas mix target tip
- Welds to 3/16", brazes to 1-1/2", cuts to 3/4"
- Torch, regulators and hose have size “A” fittings
- UL Listed components

Available with or without cart or stand.

KIT NO.	CYLINDER CONNECTION STAND OR CART	CONTENT FOR ALL 325 KITS
NKA325M	MC Acet. Regulator	1 - NTW141TA Torch Handle 1 - NTCA10 Cutting Attach.
NKA325M12	MC Acet. Regulator & Steel Stand NC1200	1 - N30333 Weld Tip 1 - N23411 Cutting Tip
NKA325M12P	MC Acet. Regulator & Plastic Stand NC1200P	1 - NBA10A Solder Tip 1 - NSW12A Hose
NKA325B	B Acet. Regulator	1 - NMP35 Goggles 1 - NMP1 Lighter
NKA325B13	B Acet. Regulator & Steel NC1300 Cart	1 - NBRS700 Adaptor 1 - NEO25FA Oxy Regulator 1 - NEA25MA Regulator or 1 - NEA25BA Regulator



NKA425M12P (shown)

425 SERIES WELDING • BRAZING • CUTTING KITS

The best selection for the professional who needs both cutting and welding capabilities.

- Welding, brazing and cutting kits
- Welds to 3/16", brazes to 1-1/2", cuts to 3/4"
- Torch, regulators and hose have size “A” fittings
- UL Listed components

Available with or without cart or stand.

KIT NO.	CYLINDER CONNECTION STAND OR CART	CONTENT FOR ALL 425 KITS
NKA425M	MC Acet. Regulator	1 - NTW141TA Torch Handle 1 - NTCA10 Cutting Attach.
NKA425M12	MC Acet. Regulator & Steel Stand NC1200	1 - N2341 Cutting Tip 1 - N30331 Weld Tip
NKA425M12P	MC Acet. Regulator & Plastic Stand NC1200P	1 - N30333 Weld Tip 1 - NSW12A Hose
NKA425B	B Acet. Regulator	1 - NMP35 Goggles 1 - NMP1 Lighter
NKA425B13	B Acet. Regulator & Steel NC1300 Cart	1 - NEO25FA Oxy Regulator 1 - NEA25MA Regulator or 1 - NEA25BA Regulator

525 SERIES WELDING • BRAZING • HEATING KITS

Kit includes a wide variety of tips for a range of applications.

- Welding, brazing, heating kits
- Welds/brazes to 3-5/8"
- Torch, regulators and hose have size “A” fittings
- These kits include a heating tip for larger requirements
- UL Listed components

Available with or without cart or stand.

KIT NO.	CYLINDER CONNECTION STAND OR CART	CONTENT FOR ALL 525 KITS
NKA525M	MC Acet. Regulator	1 - NTW141TA Torch Handle 1 - N30331 Weld Tip
NKA525M12	MC Acet. Regulator & Steel Stand NC1200	1 - N3033H15 Heating Tip 1 - NSW12A Hose
NKA525M12P	MC Acet. Regulator & Plastic Stand NC1200P	1 - NMP35 Goggles 1 - NMP1 Lighter
NKA525B	B Acet. Regulator	1 - NEO25FA Oxy Regulator 1 - NEA25MA Regulator or 1 - NEA25BA Regulator
NKA525B13	B Acet. Regulator & Steel NC1300 Cart	



NKA525M12P (shown)



NATIONAL
REFRIGERATION
PRODUCTS

OXY-FUEL EQUIPMENT

Front Valve Torch Kits with Stubby®-Style Tips, “A” Fittings



NKA700M (shown)

700 SERIES WELDING • BRAZING KITS

Stubby-Style Tips have a short, heavy duty design and give the user close up control while maximizing movement in tight area. Kits have many UL listed accessories and are prematched to different tank sizes.

Available with or without cart or stand.

KIT NO.	CYLINDER CONNECTION STAND OR CART	CONTENT FOR ALL 700 KITS
NKA700M	MC Acet. Regulator	1 - NTW5A Torch Handle 1 - N20331 Weld Tip 1 - N20333 Weld Tip 1 - NSW12A Hose 1 - NMP35 Goggles 1 - NMP1 Lighter
NKA700M12	MC Acet. Regulator & Steel Stand NC1200	1 - NEO25FA Oxy Regulator 1 - NEA25MA Regulator
NKA700M12P	MC Acet. Regulator & Plastic Stand NC1200P	or 1 - NEA25BA Regulator
NKA700B	B Acet. Regulator	
NKA700B13	B Acet. Regulator & Steel NC1300 Cart	

Front Valve Torch Kits with Standard-Style Tips, “A” Fittings

725 SERIES WELDING • BRAZING KITS

- Front valve handle featured with standard size tips
- Kits are prematched to different tank sizes
- Rugged commercial design
- Weld to 3/16", braze to 1-1/2"
- UL listed accessories

Available with or without cart or stand.

KIT NO.	CYLINDER CONNECTION STAND OR CART	CONTENT FOR ALL 725 KITS
NKA725M	MC Acet. Regulator	1 - NTW5A Torch Handle 1 - N30331 Weld Tip 1 - N30333 Weld Tip 1 - NSW12A Hose 1 - NMP35 Goggles 1 - NMP1 Lighter
NKA725M12	MC Acet. Regulator & Steel Stand NC1200	1 - NEO25FA Oxy Regulator 1 - NEA25MA Regulator
NKA725M12P	MC Acet. Regulator & Plastic Stand NC1200P	or 1 - NEA25BA Regulator
NKA725B	B Acet. Regulator	
NKA725B13	B Acet. Regulator & Steel NC1300 Cart	

825 SERIES WELDING • BRAZING • CUTTING KITS

- Added cutting capacity in a compact design
- Tips included weld to 3/16", braze to 1-1/2", and cut to 3/4"
- Versatility that other torches can't match
- Kits are prematched to different tank sizes
- UL listed accessories

Available with or without cart or stand.

KIT NO.	CYLINDER CONNECTION STAND OR CART	CONTENT FOR ALL 825 KITS
NKA825M	MC Acet. Regulator	1 - NTW5A Torch Handle 1 - NTCA10 Cutting Attach. 1 - N23411 Cutting Tip 1 - N30331 Weld Tip 1 - N30333 Weld Tip 1 - NSW12A Hose 1 - NMP35 Goggles 1 - NMP1 Lighter
NKA825M12	MC Acet. Regulator & Steel Stand NC1200	1 - NEO25FA Oxy Regulator 1 - NEA25MA Regulator
NKA825M12P	MC Acet. Regulator & Plastic Stand NC1200P	or 1 - NEA25BA Regulator
NKA825B	B Acet. Regulator	
NKA825B13	B Acet. Regulator & Steel NC1300 Cart	



NKA725B (shown)



NKA825B (shown)



NATIONAL
REFRIGERATION
PRODUCTS

OXY-FUEL EQUIPMENT

Combination Torches

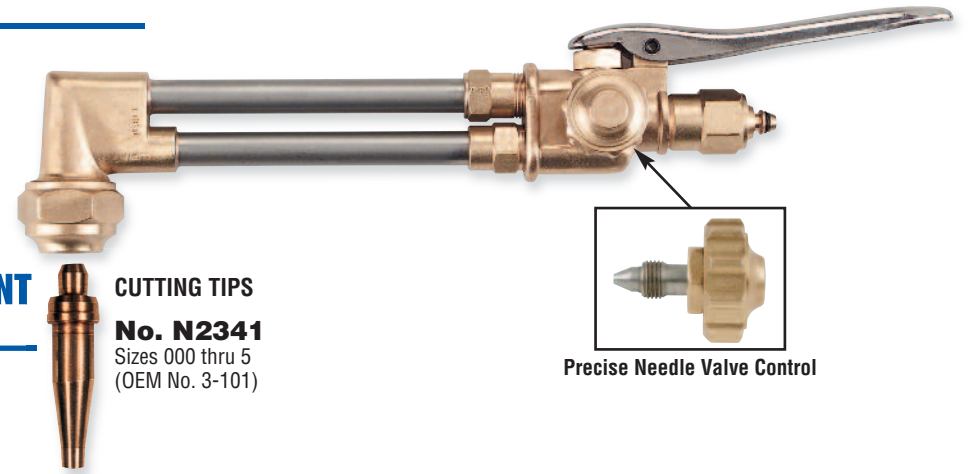
COMMON FEATURES

- Used by heating, cooling, refrigeration, repair shops and industry contractors
- Forged heads for durability
- Numerous tip sizes and styles available
- UL listed components

NTC141CAT CUTTING ATTACHMENT

Fits NTW10A and NTW5A

- 8" Long
- Uses 2341 Cutting Tips



CUTTING TIPS

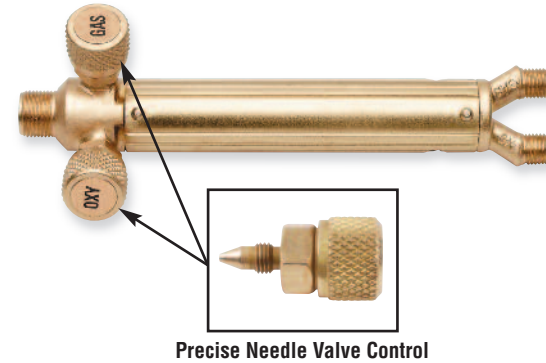
No. N2341
Sizes 000 thru 5
(OEM No. 3-101)

Precise Needle Valve Control

NTW5A FRONT VALVE TORCH

“A” Hose Inlets

- 6" Long
- Uses N3033 Series and Stubby-Style Tips

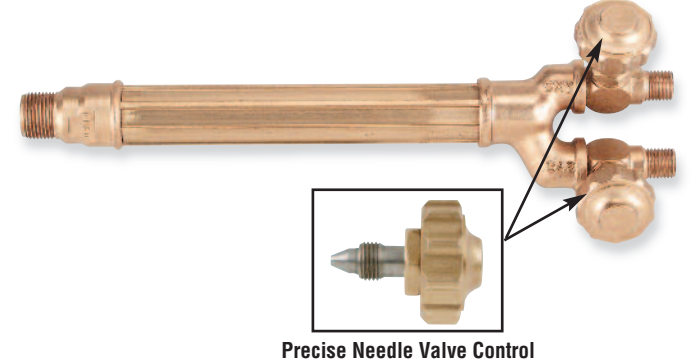


Precise Needle Valve Control

NTW141TA REAR VALVE TORCH

“A” Hose Inlets

- 7-3/4" Long
- Uses N3033 Series and Stubby-Style Tips



Precise Needle Valve Control

TIPS FOR NTW141TA, NTW10A AND NTW5A TORCHES

Standard Style Tips that provide extra reach and heat protection

WELDING/BRAZING TIPS



From 4" to 8" Long

No. N3033
Sizes 000 thru 7

HEATING/ROSEBUD TIPS



7" Long

No. N3033H
Sizes 15, 30

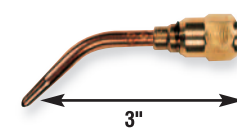
WELDING/BRAZING TIPS



No. N3033J
Sizes 1, 3

Stubby-Style Tips have a short heavy-duty design for applications needing a short profile

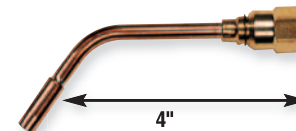
WELDING/BRAZING TIPS



3"

No. N2033
Sizes 000 thru 7

HEATING TIPS



4"

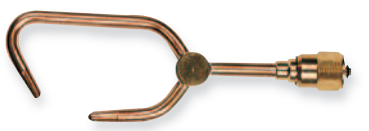
No. N2033H
Size 15

TWIN TIPS



No. N2066T
Sizes 00, 0, 1

G-TIPS



No. N2077G
Sizes 00-3



FUEL GAS REGULATORS

MODELS	DESCRIPTION
NEA25B	B Acet. (CGA 520) B Hose Fitting
NEA25BA	B Acet. (CGA 520) A Hose Fitting
NEA25M	MC Acet. (CGA 200) B Hose Fitting
NEA25MA	MC Acet. (CGA 200) A Hose Fitting
NEA25CA	Comm. Acet. (CGA 300) A Hose Fitting
NEP25A	POL LP/ Acet. (CGA 510) A Hose Fitting

OXYGEN REGULATORS

MODELS	DESCRIPTION
NEO25FA	Oxygen (CGA 540) A Hose Fitting
NEO25F	Oxygen (CGA 540) B Hose Fitting

NRP REGULATORS

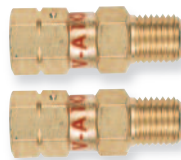
These UL listed regulators are manufactured from durable brass and include easy to read gauges, sintered inlet filters and replaceable inlet and outlet fittings. NRP regulators give the constant and accurate gas flow needed by professionals.

NEO25FA (shown)

REVERSE FLOW CHECK VALVES

NJP19	Oxy Fuel Set, "A" Fittings
NJP25	Oxy Fuel Set, "B" Fittings

- Prevents the reverse flow of gases
- Connect directly to torch inlets
- Available with "A" or "B" fittings



TWIN HOSE

ACETYLENE, GRADE "R" HOSE	
NSW8A	8' (A) Fittings 3/16" ID
NSW12A	12' (A) Fittings 3/16" ID
NSW25A	25' (A) Fittings 3/16" ID

LP AND ACETYLENE, GRADE "T" HOSE	
NSWT12A	12' (A) Fittings 3/16" ID
NSWT12B	12' (B) Fittings 3/16" ID
NSWT25A	25' (A) Fittings 3/16" ID
NSWT25B	25' (B) Fittings 3/16" ID



CARTS & STANDS

- 1200 series is available in either Steel or Plastic



NC1200P
Heavy Duty
Plastic Stand for
20 cu. ft. Oxy. &
10 cu. ft. MC Acet.



NC1300
Steel Cart for
40 cu. ft. Oxy. &
40 cu. ft. B Acet.



NKA1H (shown)

KIT NO.	TIP NO.	REG. FTG
NKA1H	NBA3	"B" Cylinder
NKA2H	NBA3	"MC" Cylinder
NKA31*	NBA2, NBA3, NBA4	"B" Cylinder
NKA32*	NBA2, NBA3, NBA4	"MC" Cylinder
NKA37H*	NBA4	"B" Cylinder
NKA38H*	NBA4	"MC" Cylinder

Contents: NHA312 hose, regulator, NAA1 handle, NMP1 lighter and NMA2 wrench.
*These kits DO NOT include lighter.

FEATHER FLAME® KITS & TIPS

"Screw-in Style"

These kits include our most economically priced air-acetylene tips. Their design makes them inexpensive while still producing excellent flame characteristics.



- Pencil Point/Feather Flame
- Adjustable flame feature
- Tips have a filter and removeable orifice
- Heavy-duty UL listed regulator

TIP NO.	TIP SIZE	SOFT SOLDER
NBA1	1/16"	1/16" - 1/8"
NBA2	1/8"	1/8" - 1/4"
NBA3	3/16"	1/4" - 1/2"
NBA4	1/4"	1/2" - 1"
NBA5	5/16"	1" - 1-1/2"
NBA6	7/16"	2" - 4"

TARGET® KITS & TIPS

"Screw-in Style"

Kits feature the adjustable Target Tips for professional soldering and brazing applications. These tips are very hot and have a compact flame. Kits also include a screw-in handle, 12 ft. hose and UL listed regulator.



- **MaXPerformance** Turbine Flame
- Adjustable flame feature
- Unique mixer design reduces brazing time over conventional tips
- Tips have a filter and removeable orifice
- Interchangeable with other screw-in style tips and equipment
- Made of heavy gauge stainless steel and brass

TIP NO.	TIP SIZE	SOFT SOLDER	SILVER BRAZE
NBA9A	1/4"	Up to 1"	1/8" - 1/2"
NBA10A	3/8"	Up to 2"	1/2" - 1"
NBA12A	1/2"	Up to 4"	1" - 2"



NKA3H (shown)

KIT NO.	TIP NO.	REG. FTG
NKA3H	NBA10A	"B" Cylinder
NKA4H	NBA10A	"MC" Cylinder
NKA7H*	NBA9A, NBA12A	"B" Cylinder
NKA8H*	NBA9A, NBA12A	"MC" Cylinder

Contents: NHA312 hose, regulator, NAA1 handle, NMP1 lighter and NMA2 wrench.
*These kits DO NOT include lighter. All kits are currently blister packed.

AIR-ACETYLENE EQUIPMENT

"Snap-in Style"



NKX3B (shown)

TARGET® KITS & TIPS

"Snap-in Style"

Kits feature the adjustable Target Tips for professional soldering and brazing applications. These tips are very hot and have a compact flame. Kits also include a quick disconnect handle, 12 ft. hose and UL listed regulator.

Choose from a wide selection of kits below.



- **MaX Performance** Turbine Flame
- Adjustable flame feature
- Unique mixer design reduces brazing time over conventional tips
- Tips have a filter and removeable orifice
- Interchangeable with other quick disconnect style tips and equipment
- Made of heavy gauge stainless steel and brass

KIT NO.	TIP NO.	REG. FTG
NKX3B	NGA3, NGA11	"B" Cylinder
NKX4B	NGA5, NGA14	"B" Cylinder
NKX5B	NGA5	"B" Cylinder
NKX5MC	NGA5	"MC" Cylinder
NKX6MC	NGA3, NGA8	"MC" Cylinder
NKX7B	NGA8	"B" Cylinder

Contents: NHA312 hose, NGG4 handle, tip(s), NMA2 wrench and regulator.



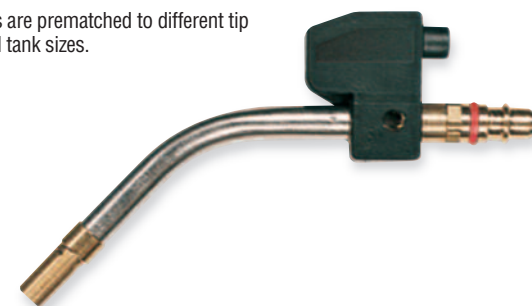
NKX10B (shown)

EZE-LITE™ INSTANT IGNITION KITS & TIPS

"Snap-in Style"

Kits feature EZE-Lite push button ignition tips with a turbine swirl action flame. Also featured is the quick disconnect handle, 12 ft. hose and UL listed regulator.

Kits are prematched to different tip and tank sizes.



- **MaX Performance** Turbine Flame
- Tip ignites with the push of a button
- Tips have a filter and removeable orifice
- Interchangeable with other quick disconnect style tips and equipment

KIT NO.	TIP NO.	REG. FTG
NKX10B	NGA5L	"B" Cylinder
NKX10MC	NGA5L	"MC" Cylinder
NKX15B	NGA8L	"B" Cylinder
NKX15MC	NGA8L	"MC" Cylinder
NKX20B	NGA14L	"B" Cylinder
NKX20MC	NGA14L	"MC" Cylinder

Contents: NHA312 hose, NGG4 handle, tip, NMA2 wrench and regulator.

AIR-ACETYLENE EQUIPMENT



SIDEWINDER™ KITS WITH WHEELED CARTS

Fits "B" Acetylene Cylinders (Cylinders not included)

Part No. NKX3BCW (shown)

Cart/Kit Combo
NC850CW Cart for "B" Cylinder
Heavy-duty NGG4 Torch Snap-in
Max Performance NGA3 & NGA11 Tips
"B" Regulator, 12' Hose & Wrench

Part No. NKX10BCW

Cart/Kit Combo
NC850CW Cart for "B" Cylinder
Heavy-duty NGG4 Torch Snap-in
Piezo Ignition NGA5L EZE-LITE Tip
"B" Regulator, 12' Hose & Wrench

SIDEWINDER™ KITS WITH STANDS

Fits "B" or "MC" Acetylene Cylinders (Cylinders not included)

Part No. NKX3BS

Carry/Kit Combo
NC850 Stand for "B" Cylinder
Heavy-duty NGG4 Torch Snap-in
Max Performance NGA3 & NGA11 Tips
"B" Regulator, 12' Hose & Wrench

Part No. NKX5BS

Carry/Kit Combo
NC850 Stand for "B" Cylinder
Heavy-duty NGG4 Torch Snap-in
Max Performance NGA5 Tip
"B" Regulator, 12' Hose & Wrench

Part No. NKX10BS

Carry/Kit Combo
NC850 Stand for "B" Cylinder
Heavy-duty NGG4 Torch Snap-in
Piezo Ignition NGA5L EZE-LITE Tip
"B" Regulator, 12' Hose & Wrench

Part No. NKX5BCW

Cart/Kit Combo
NC850CW Cart for "B" Cylinder
Heavy-duty NGG4 Torch Snap-in
Max Performance NGA5 Tip
"B" Regulator, 12' Hose & Wrench

Part No. NKA37HCW

Cart/Kit Combo
NC850CW Cart for "B" Cylinder
Heavy-duty NAA1 Torch Screw-in
Feather Flame NBA4 Tip
"B" Regulator, 12' Hose & Wrench

Part No. NKX2003MCS

Carry/Kit Combo
NC800 Stand for "MC" Cylinder
Heavy-duty NGG4 Torch Snap-in
Max Performance NGA5L & NGA8 Tips
"MC" Regulator, 12' Hose & Wrench

Part No. NKX2003BS

Carry/Kit Combo
NC850 Stand for "B" Cylinder
Heavy-duty NGG4 Torch Snap-in
Max Performance NGA5L & NGA8 Tips
"B" Regulator, 12' Hose & Wrench

Part No. NKA37HS (shown)

Carry/Kit Combo
NC850 Stand for "B" Cylinder
Heavy-duty NAA1 Torch Screw-in
Feather Flame NBA4 Tip
"B" Regulator, 12' Hose & Wrench



INDIVIDUAL SIDEWINDER™ CARTS AND STANDS

Fits "B" or "MC" Acetylene Cylinders

Part No. NC850CW

"B" Acetylene Cart
Made of Heavy-duty Steel
Hose Rack & Torch/Tip Holder
Detachable Handle
Steel Wheels

Part No. NC850 "B" Acetylene Stand Part No. NC800 "MC" Acetylene Stand

Made of Heavy-duty Steel
Hose Rack & Torch/Tip Holder





ACET-O-LITE® "Screw-in Style"

NAA1 has the adjustment valve in the front for single hand operation, the NAA3 has the valve in the rear for fingertip control. Needle valve design enables very fine flame adjustments. *These torches will keep your tips burning efficiently in drafts, winds, and adverse conditions.* Both torches are made with quality brass, have very durable handles and use standard 3/8-24 LH "A" size hose fittings.

NRP Acet-O-Lite torches work with all "BA" style tips listed on page 7.

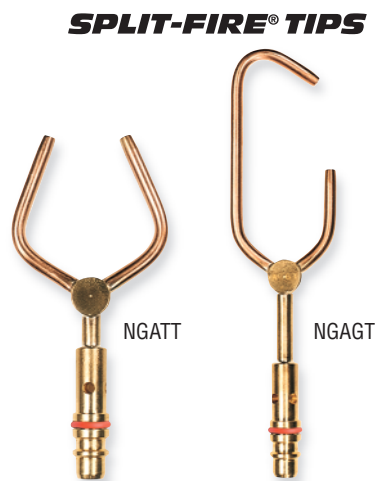
TARGET TORCH® "Snap-in Style"

This handle has a quick disconnect fitting to rapidly change tips. Comfortable grooved handle is made of very durable materials. Uses 3/8-24 LH "A" hose fittings.

NRP Target Torch handle will work with all "GA" style tips listed on page 8.

SPECIALTY TIPS "Snap-in Style"

SNAP-IN design used with NGG4 handle. Duel feather flame design for special applications. Also available with screw-in style: NBATT and NBAGT.



TIP NUMBER	FLAME DIAMETER	SOFT SOLDER	SILVER BRAZING
NBATT	(2) 1/4"	3/4"	3/4"
NBAGT	(2) 1/4"	3/4"	3/4"
NGATT	(2) 1/4"	3/4"	3/4"
NGAGT	(2) 1/4"	3/4"	3/4"
NGA3J	1/4"	1/4" to 1"	1/8" to 1/2"
NGA8J	3/8"	1" to 2"	1/2" to 1"

 **COLOR-CODED "O" RINGS**
Red for Acetylene

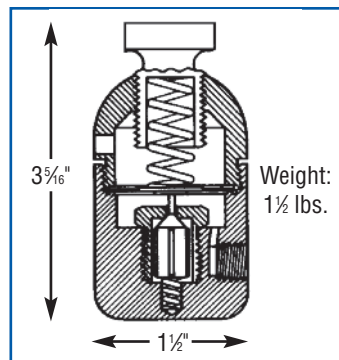
ACETYLENE REGULATORS

These UL LISTED regulators, manufactured from solid brass, are made for rugged use. *They have a specially designed conical seat and diaphragm.* The inlets have filters to prevent dirt from entering the regulator.

NEA1G B cyl. connection; "A" Hose fitting 3/8 - 24 L.H.

NEA2G MC cyl. connection; "A" Hose fitting 3/8 - 24 L.H.

GAUGE ONLY
Part No.
NMA8016



ACETYLENE HOSE

Hose assemblies are made of quality 7/16" OD x 3/16" ID single ply fabric reinforced Grade R hose.

It has a 200 PSI working pressure.

NHA36 Hose 6 feet long with "A" (3/8 - 24) connections

NHA312 Hose 12 feet long with "A" (3/8 - 24) connections

NHA325 Hose 25 feet long with "A" (3/8 - 24) connections



"Snap-in Style"

The J-Tip design allows you to solder or braze in hard-to-reach areas while safely pointing the flame away from flammable surfaces.

J-Tips



NKP102 (shown)



NKP115 (shown)



NKLP4 (shown)

PROPANE KITS WITH PENCIL AND BRUSH TIPS

Kits contain a complete selection of high quality soldering and heating equipment.

KIT NO.	TIP NO.
NKP102	NBP2
NKP105	NBP5

Kits include: NAP1 handle, NEP70G regulator, NMP1 lighter and NHEF10 hose and tip listed.

TIP NO.	FLAME	DIAMETER	SOFT SOLDER	BTU's @ 40 psi
NBP1	Pencil	5/8"	To 1/2"	6,000
NBP2	Pencil	1"	To 1-1/2"	11,000N
NBP3	Brush	7/8"	To 2"	14,000
NBP4	Brush	1-1/8"	To 3"	43,000
NBP5	Brush	1-3/8"	To 4"	57,000
NBP6	Brush	2"	To 6"	300,000



- Quiet, adjustable brush flame
- Fits NAP1 handle

TARGET® PROPANE/PROPYLENE KITS AND TIPS "Screw-in Style"

Screw-in style kits feature the very hot, compact Target Tips. Kits also include a handle, UL listed regulator and accessories.

KIT NO.	TIP NO.
NKP115	NBP15PM
NKP115L*	NBP15PML*
NKP117	NBP17PM

Kits include: NAP1 handle, NEP45G regulator, NMP1 lighter and NHP312 hose and tip listed.

**Instant Igniter*

TIP NO.	FLAME DIAMETER	SOFT SOLDER	SILVER BRAZE
NBP13PM	7/16"	To 1"	1/2"
NBP15PM	1/2"	To 1-1/2"	3/4"
NBP15PML*	1/2"	To 1-1/2"	3/4"
NBP17PM	3/4"	To 2-1/2"	1-1/2"



- **MaXPerformance** Turbine Flame
- Screw-in design
- Fits NAP1 handle

TARGET® PROPANE/PROPYLENE KITS AND TIPS "Snap-in Style"

Snap-in style its feature the very hot, compact Target Tips for professional soldering and brazing applications. Kits also include a quick disconnect handle, UL listed regulator and accessories.

KIT NO.	TIP NO.
NKLP2	NGT3, NGT5
NKLP4	NGT4
NKLP4L*	NGT4L*

Kits include: NGH4 handle, NHP312 hose, NEP45G regulator and torch tip(s).

**Instant Igniter*

TIP NO.	FLAME DIAMETER	SOFT SOLDER	SILVER BRAZE
NGT2	5/16"	Up to 1/2"	Up to 1/4"
NGT2J	5/16"	Up to 1/2"	Up to 1/4"
NGT3	7/16"	Up to 1"	Up to 1/2"
NGT4	1/2"	Up to 1-1/2"	Up to 3/4"
NGT4L*	1/2"	Up to 1-1/2"	Up to 3/4"
NGT5	3/4"	Up to 2-1/2"	Up to 1-1/4"



- **MaXPerformance** Turbine Flame
- Tips have a filter and removeable orifice
- Interchangeable with other quick disconnect style tips and equipment
- Tips fit NGH4 handle
- Color-coded O-rings

TORCH HANDLE "Screw-in Style"

Comfortable handle design reduces operator fatigue. Up front valve offers single-handed operation.

This handle accepts all screw-in tips shown on page 11.

Uses NHEF hose shown below. 9/16–L.H., "B" hose fitting.

TORCH HANDLE "Snap-in Style"

Curved handle provides positive grip. Precision machined needle valve allows greater range of flame control. Utilizes quick disconnect for fast tip change over.

This handle accepts all snap-in tips shown on page 11 & 12.

Uses NHEF hose shown below. 9/16–L.H., "B" hose fitting.



NAP1



NGH4

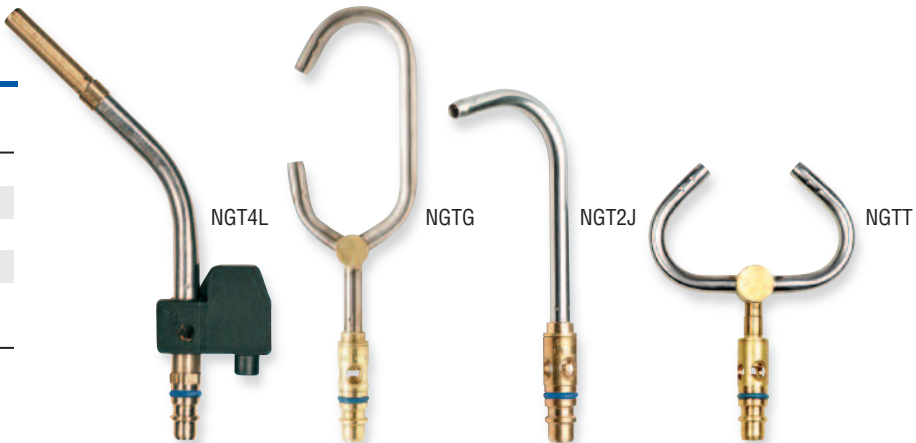
SPECIALTY TIPS "Snap-in Style"

TIP NUMBER	FLAME DIAMETER	SOFT SOLDER	SILVER BRAZING
NGT4L*	1/2"	1-1/2"	3/4"
NGTG	(2) 3/8"	3/4"	3/4"
NGT2J	5/16"	3/4"	3/8"
NGTT	3/8"	3/4"	1/2"



COLOR-CODED "O" RINGS
Blue for Propane

*Instant Igniter



HOSE

VAPOR PROPANE GAS HOSE

Quality flexible hose utilizes the standard 9/16–18 LH hose fittings.

Working pressure: 350 PSI.
Outside diameter: 9/16"
Inside diameter: 1/4"

HOSE NO. LENGTH (ft.)

NHEF6	6
NHEF10	10
NHEF12	12
NHEF20	20
NHEF25	25
NHEF35	35
NHEF50	50



Not for use with Natural Gas.

VAPOR PROPANE / MAP-Pro™ / NATURAL GAS HOSE

Quality flexible hose for use with multiple gases 9/16–18 LH hose fittings.

Working pressure: 200 PSI.
Outside diameter: 7/16"
Inside diameter: 3/16"

HOSE NO. LENGTH (ft.)

NHP312	12
--------	----



Grade "T" hose.

PROPANE REGULATORS

HIGH PRESSURE

Use only with vapor withdrawal cylinders.

All brass regulators used with propane torches and furnaces.

Adjustable pressure from 5 to 60 PSI. UL Listed with POL inlet spud and nut, 1/4" NPT openings, and 9/16–18 LH hose outlet.

NEP70G

Has 0 to 60 PSI outlet pressure gauge for propane gas.

NEP80G

Has 0 to 70 PSI outlet pressure without gauge for propane gas.

NXP234

Regulator with dust cap and heavy duty inlet nut for propane gas.



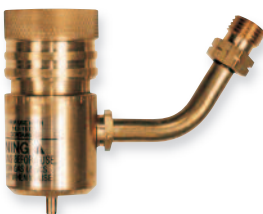
NGP360 TORCH ACCESSORIES

NEP20BR

Regulator for disposable cylinder with (B) hose outlet connection.

NEP20R

(Not pictured)
Regulator body with Swivel Stem for the NGP360 Series torch.



LOW PRESSURE

For vapor withdrawal cylinders. Up to 200,000 BTUs.

This regulator has approx. 6-7 oz. or 11" water column outlet pressure and is for applications requiring low gas pressure. UL LISTED with 1/4" NPT inlet and 3/8" NPT outlet. Do not use with any NRP LP torch or furnace equipment.

NEP600

Body only, no fittings

NEP601

POL inlet, 3/8" flare outlet

NEP602

POL inlet, 1/4" flare outlet

NEP603

POL inlet, LH hose outlet

NEP604

T-Block inlet, 3/8" flare outlet

NEP605

POL inlet less outlet



LOW PRESSURE WITH OPD TANK CONNECTION

For vapor withdrawal cylinders. Same features as the NEP60 regulators except it utilizes an OPD cylinder connection. Up to 200,000 BTUs.

NEP901

Type 1 inlet, 3/8" flare outlet

NEP902

Type 1 inlet, 1/4" flare outlet

NEP903

Type 1 inlet, LH hose outlet

NEP904

T-Block inlet, 3/8" flare outlet

NEP905

Type 1 inlet, less outlet



All Tips Swivel 360°

Available with Push Button Piezo Lighter

NGHT100

Standard Torch with NGHTT1 Single Tip

NGHT100L

Piezo Lighter Torch with NGHTTL Tip








NGHT200

Torch with NGHTT2 Twin Tip

NGHTK12

Torch Kit

REPLACEMENT SWITCHFIRE TIPS & REGULATOR

						
NGHTT1	NGHTTD	NGHTTL	NGHTT2	NGHTTY	NGHTLTE	NGHTR
Standard Single Tip	Small Detail	Push Button Igniter	Twin Tip	Twin Tip	Tip End for NGHTTL	Regulator
TIP NO.	WITH PROPANE		WITH MAP-PRO™ - PROPYLENE			
	SOFT SOLDERS	SILVER BRAZES	SOFT SOLDERS	SILVER BRAZES		
NGHTTD	1/8" - 1/2"	1/8" - 3/8"	1/8" - 3/4"	1/8" - 1/2"		
NGHTT1 & NGHTTL	1/4" - 3"	1/4" - 1"	1/4" - 3-1/2"	1/4" - 1-3/4"		
NGHTT2	3/4" - 4"	1/2" - 2"	1-1/2" - 6"	3/4" - 3"		
NGHTTY	Up to 3/4"	Up to 1/2"	Up to 3/4"	Up to 3/4"		

"SIDEWINDER KITS"

NKP26: (shown) Snap-In Handle

Contents:
NEP20BR Regulator, NGH4 Handle, NGT4 Target Tip, NMP1 Lighter, NHP312 Hose, NC500 Stand.

NKP26L: (shown) Snap-In Handle with Igniter Tip

Contents:
NEP20BR Regulator, NGH4 Handle, NGT4L Target Igniter Tip, NHP312 Hose, NC500 Stand.



Cylinders Not Included

NKP26NS: (shown) Snap-In Handle

Contents:
Same as NKP26 except with NMP100 Stand.

NKP26LNS: (shown) Snap-In Handle with Igniter Tip

Contents:
Same as NKP26L except with NMP100 Stand.



Cylinder Not Included

NGP600 SELF-IGNITING HAND TORCH FOR DISPOSABLE CYLINDERS

- **MaXPerformance** increases flame temperature by 40%
- Very hot turbine flame
- Easily adjustable from a large to small flame
- Replacement tip end
- Durable construction
- Uses MAP-Pro™ or propane fuel

ADJUSTABLE FLAME FEATURE

Instant Ignition TRIGGER TORCH

Professional Duty Torch for Soldering and Brazing

SOFT SOLDER	SILVER BRAZING
1/4" - 3-1/2"	1/4" - 1-1/4"

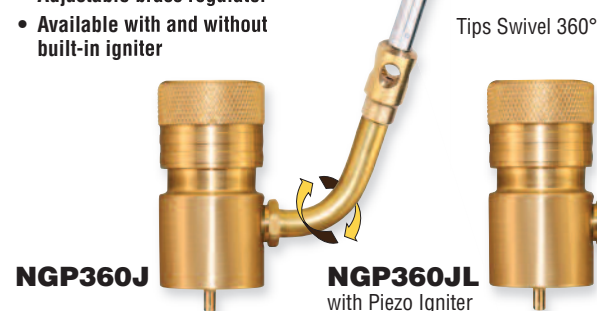
Measured using MAP-Pro™ gas.

NBP22LTE
Replacement Tip End for NGP600

J-STYLE TORCHES

J-Torch design allows you to solder or braze in hard-to-reach areas while safely pointing the flame away from flammable surfaces.

- **MaXPerformance** hot turbine flame
- Adjustable brass regulator
- Available with and without built-in igniter



NGP360J

NGP360JL
with Piezo Igniter

TORCH	FLAME DIAMETER	SOFT SOLDER	SILVER BRAZING
NGP360J	3/8"	1/4" to 3/4"	1/4" to 3/8"
NGP360JL	1/2"	1/4" to 2-1/2"	1/4" to 1-1/4"

Not interchangeable with SwitchFire torches & tips.

HAND TORCHES FOR DISPOSABLE CYLINDERS

NGP6
Economy Torch
Propane only

- Used only with propane gas
- Economically priced and practical for light duty jobs
- Flame control valve gives precise adjustments
- Durable brass construction
- Can be used inverted once tip end becomes warm



NGP6

NGP9
Heavy Duty Torch
Propane / MAP-Pro™

Made of the finest brass materials, this torch has soft soldering capabilities and is a popular choice for plumbing, heating, electrical and many other uses.

- A tip that can be used with propane or MAP-Pro™ gas without changing the orifice
- Easily adjusted to three different flames without changing tip ends
- Attractively packaged for pegboard display
- Can be used inverted once tip end becomes warm



NGP9

LEAK DETECTOR

Use with disposable propane or MAP-Pro™ gas cylinders.

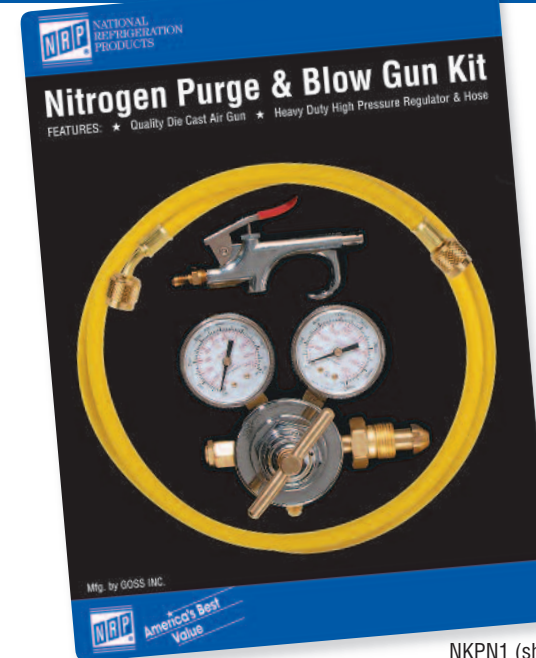
The flame, when adjusted to heat the reactor plate, quickly changes color as the search hose passes a leak of refrigerant gas.

- 24" search hose
- Blackened shell to easily observe flame color
- Replacement parts available



NGP18R

Cylinders Not Included



NKPN1 (shown)

NITROGEN PURGE & BLOW GUN KIT

- 6 ft. / 1/8m Hose
- NEN460F High Pressure Regulator
- Quality Die-cast Blow Gun
- Multiple Uses: Purges, Blow, Leak Tests
- Add Stands to NKPN1 Kit:
 - NKPN20S Includes Blow Gun Kit and Stand for 20 Cubic ft. Cylinders
 - NKPN40S Includes Blow Gun Kit and Stand for 40 Cubic ft. Cylinders



NC940CW (shown)

NITROGEN CYLINDER STAND

Carry cylinders easily. These all steel stands are made for rugged use. Weighs only 4 lbs.

- **NC920 Stand**
Holds 20 cu. ft. nitrogen cylinder.
- **NC940 Stand**
Holds 40 cu. ft. nitrogen cylinder or 10 lb. CO₂ cylinder.
- **NC940CW**
Same as NC940, but with wheels and handle.



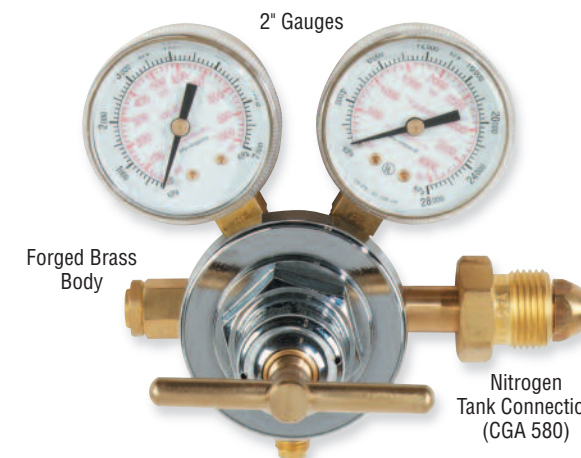
Wide Base



NFM100F (shown)

NITROGEN FLOWMETER

- Visually confirms gas is flowing through system while brazing
- Saves gas by delivering precise flow of nitrogen into system
- Solid brass body and fittings with visible round chromium steel ball
- Inlet and outlet connections use standard 1/4" flare (7/16" – 20) fittings
- Set regulator to 50 PSI and adjust flowmeter range from 0-75 SCFH
- Auto-Reset safety protects from regulator over-pressure delivery



Forged Brass Body

2" Gauges

Nitrogen Tank Connection (CGA 580)

NITROGEN REGULATOR

PART NO.	MAXIMUM OUTLET PRESSURE	OUTLET FITTING
NEN450F	450 PSIG	1/4" Flare Male
NEN700F	700 PSIG	1/4" Flare Male

Heavy duty regulators that deliver the pressure and volume most requested by professionals.

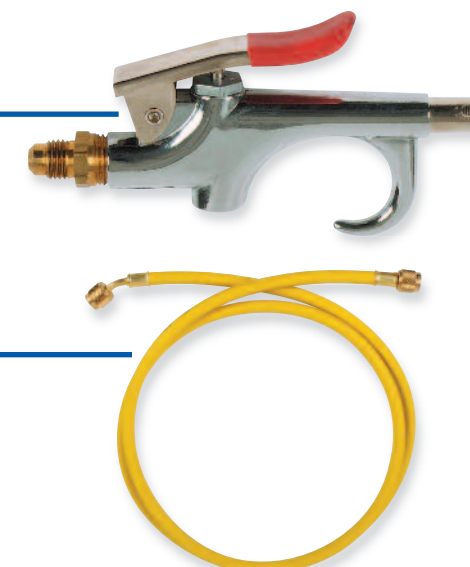
BLOW GUN

- OSHA Approved Nozzle
- Durable Construction
- ON/OFF Lever

NITROGEN HOSE

- Nylon Lined/Low Porosity
- UL Approved
- Suitable for R12, R13A, R22, R500, R502, R410A and HCFC Blends
- 6 ft. Long

N72Y (shown)



KEY: B Refers to 9/16 – 18 Threads
A Refers to 3/8 – 24 Threads

LH Refers to Left Hand Threads
RH Refers To Right Hand Threads

M Refers to Male Threads
F Refers to Female Threads

Oxygen Has Right Hand Threads
Fuel Gas Has Left Hand Threads

PIG TAILS



NIP7 POL by Inverted Flare 20" long
NIP8 POL by Inverted Flare 30" long
NEP34B 1/4" Flare Tee Block only.

Y-OUTLET



NIP3 9/16" – 18 LH fittings.
Connects to outlet of regulator.

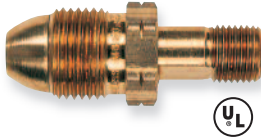
SURE GAUGES



NMP39B for B cylinders
NMP39MC for MC cylinders
NMP39N for nitrogen cylinders
NMP39O for oxygen cylinders
Used to determine tank contents.

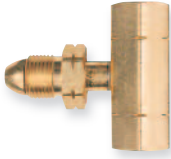
COUPLERS & ADAPTERS

POL cylinder connection x 9/16" – 18
LHM hose fitting



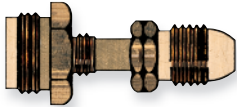
NIP2 Adapter
Propane tank to hose.
Includes built-in excess flow valve.

POL male to 2 POL females



N6001 T-Coupler
Adapts POL cylinder to two POL
regulators or manifolds.

1" - 20m THD x POL



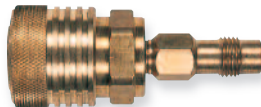
NBRS913 Adapter
Adapts the EP-20 BR to POL fitting
that is used on refillable cylinders.

1" 20m x 9/16" – 18 LHM hose fitting



NBRS461 Adapter
Enables hand torches that connect
to disposable tanks to be connected
to a hose.

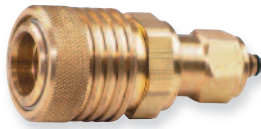
TIP TO HANDLE ADAPTERS



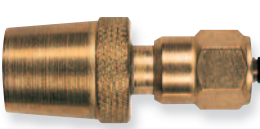
NBRS770
Adapts snap-in tips to torch handles
with screw-in design.



NBRS665
Adapts the Goss variety of
Pencil, Brush or Target® Tips to torch
handles with snap-in design.



NBRS986
Converts NTW5A and NTW10A
oxy/fuel torch to snap-in air/fuel tips.



NBRS700
Converts NTW5A and NTW10A
oxy/fuel torch to screw-in air/fuel tips.

QUICK CONNECT ADAPTER



NBRS776
Snap Together



NBRS776M

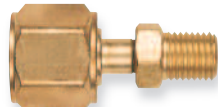


NBRS776F

NBRS776 Quick Change Adapter
• High flow design • Made of brass & aluminum
• UL Listed • Connects torch to hose

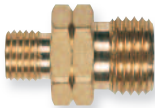
TORCH OR REGULATOR TO HOSE ADAPTERS

NBRS339 (B) LHF to (A) LHM
NBRS340 (B) RHF to (A) RHM
NBRS341 (A) LHF to (B) LHM
NBRS342 (A) RHF to (B) RHM
NBRS707 (B) LHF to 1/4 NPT-F



HOSE TO HOSE ADAPTERS

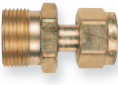
NBRS314 "A" Fitting to "A" Fitting (Oxygen)
NBRS315 "A" Fitting to "B" Fitting (Fuel Gas)
NBRS316 "A" Fitting to "B" Fitting (Oxygen)
NBRS317 "A" Fitting to "A" Fitting (Fuel Gas)
NBRS318 "B" Fitting to "B" Fitting (Oxygen)
NBRS319 "B" Fitting to "B" Fitting (Fuel Gas)



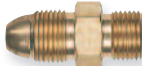
CYLINDER TO REGULATOR ADAPTERS



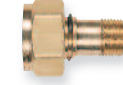
NBRS362
POL Reg. to Comm. Cyl.



NBRS364
B Reg. to MC Cyl.



NBRS363
POL Cyl. to Comm. Reg.



NBRS365
B Cyl. to MC Reg.

HANDLES / TORCHES			
NRP	TURBO	UNIWELD	DESCRIPTION
NAA1		TH-9	Handle acetylene, front valve for screw-in tips
NAA3	WA-400	TH-3	Handle acetylene, rear valve for screw-in tips
NAP1		TH-9B	Handle propane, front valve for screw-in tips
NGG4	G-4	TH-6	Handle for acet. snap-in tips rear valve, A fitting
NGH4	H-4	TH-6B	Handle propane, snap-in tips rear valve, B fitting
NGP6	TP-10		Propane only Economy torch
NGP9		PCV25	Torch soldering for disp. cyl.
NGP600	TX504	PZ-501	Self-igniting hand torch
NGHT100	STK-9	RP3T4	Torch Regular
NGHT100D	STK-1		Torch Detail
NGHT100L	STK-99	RP3T6	Torch Regular with igniter
NGHT200	STK-11	RP3T5	Torch Super Size

TIPS			
NRP	TURBO	UNIWELD	DESCRIPTION
NBA1	S-1	S-21	Tip acetylene, feather frame screw-in, x-fine
NBA2		S-22	Tip acetylene, feather frame screw-in, fine
NBA3	S-3	S-23	Tip acetylene, feather frame screw-in, medium
NBA4	S-4	S-24	Tip acetylene, feather frame screw-in, large
NBA5	S-5	S-25	Tip acetylene, feather frame screw-in, x-large
NBA6	S-6	S-26	Tip acetylene, feather frame screw-in, heavy duty
NBA9A		AS-3	Tip acetylene, target style screw-in, small
NBA10A		AS-8	Tip acetylene, target style screw-in, medium
NBA12A		AS-11	Tip acetylene, target style screw-in, large
NBP1		SM-36	Tip propane, pencil point screw-in, x-fine
NBP2		SM-38	Tip propane, pencil point screw-in, x-fine
NBP3			Tip propane, brush flame screw-in, medium
NBP4		ST06MP	Tip propane, brush flame screw-in, large
NBP5		ST07MP	Tip propane, brush flame screw-in, x-large
NBP6			Tip propane, brush flame screw-in, heavy duty
NGA2	A-2		Tip acet., snap-in, x-fine
NGA3	A-3	A-3	Tip acet., snap-in, fine
NGA5	A-5	A-5	Tip acet., snap-in, small
NGA8	A-8	A-8	Tip acet., snap-in, medium
NGA11	A-11	A-11	Tip acet., snap-in, large
NGA14	A-14		Tip acet., snap-in, x-large
NGA32	A-32		Tip acet., snap-in, heavy duty
NGA3L	PL-3A		Tip acet., Eze-Lite, snap-in, fine
NGA5L	PL-5A		Tip acet., snap-in, small
NGA8L	PL-8A		Tip acet., Eze-Lite, snap-in, med.
NGA14L	PL-12A		Tip acet., Eze-Lite, snap-in, med.
NGT2	T-2	T-2	Tip propane, snap-in, fine
NGT3	T-3	T-3	Tip propane, snap-in, fine
NGT4	T-4	T-4	Tip propane, snap-in, med.
NGT5	T-5	T-5	Tip propane, snap-in, large

REGULATORS			
NRP	TURBO	UNIWELD	DESCRIPTION
NEA1G	AR-B	RB	Regulator B cyl., A outlet
NEA2G	AR-MC	RMC	Regulator MC cyl., A outlet
NEP20B	STK-R	RP-2B	Regulator propane/ disposable cylinder
NEP70G	R-LP	RLPB	Propane regulator gauge
NEP80G			Propane regulator

KITS			
NRP	TURBO	UNIWELD	DESCRIPTION
NKA1H			Kit for B acet., feather flame
NKA37H	WSF-4	K-41	Kit for B acet., screw-in tip
NKA38H	WSF-3	K-40	Kit for MC acet., screw-in tip
NKLP2	LP-2		Kit propane 2-target snap-in tips
NKLP4	LP-3	KLPTQ4	Kit propane 1-target snap-in tips
NKP102			Kit propane #2 pro flame screw-in tip
NKP105			Kit propane #5 pro flame screw-in tip
NKP320A *	Victor HS-101		Kit torch prop.heating with flow adapter
NKP320MA			Kit torch, auto ignition prop. heating, flow adapter
NKX3B	X-3B	89600	Kit acet. B #3, #11 snap-in tip
NKX4B	X-4B		Kit acet. B #5, #14 snap-in tip
NKX5B	X-5B		Kit acet. B #5 snap-in tip
NKX6MC	X-6MC		Kit acet. MC #3, #8 snap-in tips
NKX7B	X-7B		Kit acet. B #8 snap-in tip
NKX10B	PL-5ADLX-B		Kits, B acet., Eze-Lite, small
NKX10MC	PL-5ADLX-MC		Kits, MC acet., Eze-Lite, small
NKX15B	PL-8ADLX-B		Kits, B acet., Eze-Lite, med.
NKX15MC	PL-8ADLX-MC		Kits, MC acet., Eze-Lite, med.
NKX20B	PL-12ADLX-B		Kits, B acet., Eze-Lite, large
NKX20MC	PL-12ADLX-MC		Kits, MC acet., Eze-Lite, large

ADAPTERS			
NRP	TURBO	UNIWELD	DESCRIPTION
NBRS364	MCT	F-41	Cylinder adapter B to MC
NBRS365	BTMCR	F-31	Cylinder adapter MC to B
NBRS665		TUA	Adapter for snap-in torch
NBRS770	SA	UTA	Adapter for screw ftg. torch
NIP2			Flow adapter

MISCELLANEOUS			
NRP	TURBO	UNIWELD	DESCRIPTION
NC800	TTMC	512	Stand for MC cylinder
NC850	TTB	502	Stand for B cylinder
NDA1		SS-38	Soldering iron, pyramid, acet.
NDA2		SS-37	Soldering iron, chisel, acet.
NDA8		LD-32	Leak detector, acetylene
NHA312	AH-12	H-12	Hose acetylene, 12 ft. A conn.
NHA325	AH-24	H-13	Hose acetylene, 25 ft. A conn.
NHEF12	H-12	HLP14B	Hose propane, 12 ft. B conn.
NHEF25	H-24	HLP-13B	Hose propane, 25 ft. B conn.
NMA2	TK	W05	Acetylene tank wrench
NMP1	L-1	FL-34	Striker, single round file
NMP25	F-1	FL-37	Flints for MP-1 striker
NMP37A	255-01P	TCSD	Tip cleaner set (12)

*Western number cross reference WB-101

NRP TIP PERFORMANCE CHARTS

CUTTING TIPS (ACETYLENE) N2341 Series

TIP SIZE	FUEL PSIG	OXYGEN PSIG	CUTTING THICKNESS
000	5	20	1/8"
00	5	25	1/4"
0	10	30	1/2"
1	10	35	3/4"
2	10	40	1-1/4"
3	10	45	2"

BRAZING / WELDING TIPS (ACETYLENE) N3033, N2033 Series

TIP SIZE	FUEL PSIG	OXYGEN PSIG	BRAZING CAPACITY FOR COPPER TUBING	WELDING THICKNESS
00	5	5	1/8" - 3/4" (3 - 19 mm)	1/16" - 3/64"
0	5	5	1/4" - 1" (6 - 25 mm)	1/32" - 5/64"
1	7	7	1/4" - 1-1/4" (6 - 31 mm)	3/64" - 3/32"
2	7	7	1/2" - 1-1/2" (12 - 38 mm)	1/16" - 1/8"
3	7	10	3/4" - 1-1/2" (19 - 38 mm)	1/8" - 3/16"

HEATING / SPECIALTY TIPS (ACETYLENE)

TIP STYLE	FUEL PSIG	OXYGEN PSIG	BRAZING CAPACITY FOR COPPER TUBING
N2033H15 Multiflame	10	20	up to 2-1/2"
N2066T00 Twin Tip	10	15	up to 1/2"
N2066T0 Twin Tip	10	15	up to 1"
N2066T1 Twin Tip	10	15	up to 2"
N2077G00 G-Tip	10	15	up to 1/2"
N2077G0 G-Tip	10	15	up to 1"
N2077G1 G-Tip	10	15	up to 1-1/2"
N2077G2 G-Tip	10	15	up to 2"
N2077G3 G-Tip	10	15	up to 2-1/2"
N3033H15 Multiflame	10	20	up to 2-1/2"
N3033H30 Multiflame*	10	20	up to 4"

**Only use with 40 cu. ft. "B" cylinder.*

WARRANTY

LIMITED WARRANTY:

NRP warrants to the original purchaser that its products shall be free from defects in material and workmanship under normal use and service within one (1) year of purchase. NRP will, at its election, repair, replace or make appropriate price adjustment where any product is found by inspection to be defective.

LIMITATION OF LIABILITY:

It is understood and agreed that NRP's liability, whether in contract, in tort, under any warranty in negligence or otherwise shall not exceed the return of the amount of the purchase price paid by the original purchaser and under no circumstances shall NRP be liable for special, indirect or consequential damages.

The price stated for the equipment is a consideration in limiting NRP's liability. No action, regardless of form, arising out of the transactions under this Agreement may be brought by the purchaser more than one (1) year after the cause of action has accrued.

Some states do not allow limitations on how long an implied warranty lasts, or the exclusion or limitation of incidental or consequential damages, so this limitation and exclusion may not apply to you.

This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

GENERAL SOLDERING AND BRAZING INFORMATION

Soldering and brazing are each a process of joining metals by heating a copper tube to suitable temperatures then applying a filler metal. Then melting points of soldering filler metals is below 840°F, while brazing filler metals have melting points above 840°F.

Soft soldering is used when strength is not as important as sealing or conductivity, such as plumbing or electrical applications.

Silver brazing, sometimes referred to as silver soldering, is higher in strength and is used to seal fittings containing higher pressures and temperatures, such as in heating, air conditioning and refrigeration.

Phos-copper brazing is applied without flux and requires more heating. The application characteristics are like silver brazing.

BASIC STEPS IN MAKING A SOUND JOINT

1. Study the joint to make sure there is proper clearance for the filler metal to flow. This is approximately .003".
2. Clean surfaces free from dirt, grease, oil and oxides with steel wool, wire brushing, sanding, etc.
3. Apply flux to the cleaned area (except when using flux coated or phos-copper rod). Flux prevents further contamination and aids in the flow of the filler metal.
4. When brazing refrigeration systems, have nitrogen flowing through the system to eliminate oxidation and scale.
5. Choose the filler metal and heat the joint until the flux is completely fluid. Now move the direct heat away from the joint and touch it with filler metal. Inspect and if needed, add filler metal and/or heat until the filler metal flows completely through and around the joint.
6. To prevent corrosion, clean the joint area by removing all flux residue and debris.

[illegible]