SPRAYING TABLE – US SYSTEM
PPS5K - Acetylene Hardware

METAL	Recommended Hardware (Note 1)			Lighting Pressure Settings (psi)			Flowmeter reading			Consumption per hour (Note 4)			Lbs/ wire Req. per Cu In of coating	Deposited coating build-up speed (Cu In/Hr) Notes 4 & 5
	Noz. Wire Size	Air cap size	Gears	Oxy note 2	Acet note 2	Air Notes 2 & 3	Oxy note 2 (2GF)	Acet note 2 (2GF)	Air Notes 2 & 3 (3AF)	Lbs. Wire	Cu. Ft. Oxy	Cu. Ft. Acet		
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
Aluminum (note 7)	3/16	EA	Std	33	15	65	48	48	20.5	16	95	50	.10	160
	1/8	EC		30	15	65	40	40	20	12	83	40		120
	11	J		25	15	55	33	30	18	5.5	60	30		55
	15	M		25	15	55	24	24	17	2	42	22		20
Aluminum Bronze	3/16	EA	Std	33	15	65	48	48	20.5	19	95	50	.35	55
	1/8	EC		30	15	65	44	40	20	15	86	40		43
	11	J		30	15	55	38	28	18	7.5	60	30		21
Babbitt (note 9)	3/16	EA	Std	30	15	65	38	48	20.5	95	65	40	.35	270
	1/8	EC		30	15	60	29	29	20	40	44	25		115
	3/16	EA	High	35	15	65	43	55	20.5	185	85	60		530
	1/8	EC		35	15	60	28	41	20	90	48	40		255
Bond Wire	1/8	C	Std	30	15	65	44	39	22	5	86	48	.30	16
Copper	3/16	EA	Std	33	15	65	48	48	20.5	30	95	50	.35	85
	1/8	EC		30	15	65	44	40	20	24	86	40		70
	11	J		25	15	55	33	30	18	10	60	30		29
	15	M		25	15	55	24	24	17	6	42	22		17
Stainless (1 thru 5)	3/16	EA	Std	33	15	65	48	45	20.5	16	98	46	.32	50
	1/8	EC		30	15	65	44	40	20	13	84	40		40
	11	J		25	15	55	33	30	18	7.5	60	30		25
Zinc	3/16	EA	Std	33	15	65	48	45	20.5	65	97	47	.35	185
	1/8	EC		30	15	65	45	40	20	45	86	40		130
	11	J	High	25	15	55	33	30	18	20	55	30		55
	15	M		25	15	55	24	24	17	12	42	22		35

Notes:

Hardware

1. Refer to the Gas Head Hardware selection chart for additional hardware recommendations before spraying.

Operating Parameters:

2. After lighting, adjust flowmeter settings to flows listed in columns 8, 9 & 10.
3. Adjust the Air PRESSURE for lighting and running to column 7 psi. At this PRESSURE, the FLOW reading should be adjusted to column 10 reading.

Performance:

4. The figures in columns 11, 12, 13 and 15 are optimum. They can be achieved by skilled operators with all equipment in excellent condition.
5. One cubic inch of deposited coating covers 100 square inches of surface @ .010" thick or 7 feet of surface area @ .001" thick
6. Fan spray air cap spray rates will be lower than charted
7. Use non-loading nozzles and air caps when spraying Babbit A, tin, zinc or aluminum alloys in start/stop operation
8. When using type AF or GF flowmeters, reduce pressures shown as necessary to obtain flowmeter readings shown.
9. When spraying Babbitt: With non-loading hardware in start/stop operation, lower air flow 5-10 points and adjust Oxygen flow to provide the same relationship to acetylene as shown in the table above. Increase air flow if loading occurs.

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SPRAYING TABLE – METRIC SYSTEM

PPS5K - Acetylene Hardware

METAL	Recommended Hardware (Note 1)			Lighting Pressure Settings (bar)			Flowmeter reading			Consumption per hour (Note 4)			Kgs/ wire Req. per CM_3 of coating	Deposited coating build-up speed (CM_3 /Hr) Notes 4 & 5
	Noz. Wire Size	Air cap size	Gears	Oxy note 2	Acet note 2	Air Notes 2 & 3	Oxy note 2 (2GF)	Acet note 2 (2GF)	Air Notes 2 & 3 (3AF)	Kg.. Wire	M_3 Oxy	M_3 Acet		
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
Aluminum (note 7)	3/16	EA	Std	2.27	1.03	4.48	48	48	20.5	7.3	2.7	1.4	.0028	2622
	1/8	EC		2.07	1.03	4.48	43	40	20	5.4	2.3	1.1		1966
	11	J		1.72	1.03	3.79	33	30	18	2.5	1.7	.85		901
	15	M		1.72	1.03	3.79	24	24	17	0.9	1.2	.62		328
Aluminum Bronze	3/16	EA	Std	2.27	1.03	4.48	48	48	20.5	8.5	2.7	1.4	.0097	901
	1/8	EC		2.07	1.03	4.48	44	40	22.5	6.8	2.4	1.1		705
	11	J		2.07	1.03	3.79	38	28	18	3.4	1.7	.85		344
Babbitt	3/16	EA	Std	2.07	1.03	4.48	38	48	20.5	43.0	1.8	1.1	.0097	4425
	1/8	EC		2.07	1.03	3.45	29	29	20	18.0	1.2	.71		1885
	3/16	EA	High	2.41	1.03	4.48	43	55	20.5	84.0	2.4	1.7		8685
	1/8	EC		2.41	1.03	4.14	28	41	20	41.0	1.4	1.1		4179
Bond Wire	1/8	C	Std	2.07	1.03	4.48	44	39	22	2.3	2.4	1.4	.0083	262
Copper	3/16	EA	Std	2.27	1.03	4.48	48	48	20.5	13.6	2.7	1.4	.0097	1393
	1/8	EC		2.07	1.03	4.48	44	40	20	10.9	2.4	1.1		1147
	11	J		1.72	1.03	3.79	33	30	18	4.5	1.7	.85		475
	15	M		1.72	1.03	3.79	24	24	17	2.7	1.2	.62		279
Stainless (1 thru 5)	3/16	EA	Std	2.27	1.03	4.48	48	45	20.5	7.3	2.8	1.3	.0089	819
	1/8	EC		2.07	1.03	4.48	44	40	20	5.9	2.4	1.1		656
	11	J		1.72	1.03	3.79	33	30	18	3.4	1.7	.85		410
Zinc	3/16	EA	Std	2.27	1.03	4.48	48	45	20.5	29.5	2.7	1.3	.0097	3032
	1/8	EC		2.07	1.03	4.48	45	40	20	14.5	2.4	1.1		1475
	11	J	High	1.72	1.03	3.79	33	30	18	9.1	1.6	.85		902
	15	M		1.72	1.03	3.79	24	24	17	5.4	1.2	.62		574

Notes:

Hardware

1. Refer to the Gas Head Hardware selection chart for additional hardware recommendations before spraying.

Operating Parameters:

2. After lighting, adjust flowmeter settings to flows listed in columns 8, 9 & 10.
3. Adjust the Air PRESSURE for lighting and running to column 7 psi. At this PRESSURE, the FLOW reading should be adjusted to column 10 reading.

Performance:

4. The figures in columns 11, 12, 13 and 15 are optimum. They can be achieved by skilled operators with all equipment in excellent condition.
5. One cubic centimeter of deposited coating covers 100 square centimeters of surface @ .01 mm thick or 1 square meter of surface area @ .0001mm thick
6. Fan spray air cap spray rates will be lower than charted
7. Use non-loading nozzles and air caps when spraying Babbit A, tin, zinc or aluminum alloys in start/stop operation
8. When using type AF or GF flowmeters, reduce pressures shown as necessary to obtain flowmeter readings shown.
9. When spraying Babbitt: With non-loading hardware in start/stop operation, lower air flow 5-10 points and adjust Oxygen flow to provide the same relationship to acetylene as shown in the table above. Increase air flow if loading occurs.

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SPRAYING TABLE – US SYSTEM

PPS5K - Propane Jetted Hardware

METAL	Recommended Hardware (Note 1)			Lighting Pressure Settings (psi)			Flowmeter reading			Consumption per hour (Note 4)			Lbs/ wire Req. per Cu In of coating	Deposited coating build-up speed (Cu In/Hr) Notes 4 & 5
	Noz. Wire Size	Air cap size	Gears	Oxy note 2	Prop note 2	Air Notes 2 & 3	Oxy note 2 (2GF)	Prop note 2 (2GF)	Air Notes 2 & 3 (3AF)	Lbs. Wire	Cu. Ft. Oxy	Cu. Ft. Prop		
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
Aluminum (note 7)	3/16	EA	Std	45	40	75	69	35	20.5	16	172	34	.10	160
	1/8	EC		50	40	75	72	33	20	12	194	33		120
	11	J		40	35	75	54	24	18	5.5	120	23		55
	15	M		35	35	75	46	18	18	2	95	15		20
Aluminum Bronze	3/16	EA	Std	50	40	75	70	35	20.5	21	180	35	.35	58
	1/8	EC		50	40	75	68	33	20	18	175	35		51
	11	J		40	35	75	54	24	18	8	120	23		23
Babbitt	3/16	EA	Std	30	30	75	60	26	20.5	95	130	20	.35	270
	1/8	EC		25	25	75	45	17	20	40	80	12		115
	3/16	EA	High	45	35	75	72	35	20.5	185	185	35		530
	1/8	EC		25	20	75	50	22	20	90	90	17		255
Bond Wire	1/8	C	Std	50	45	65	68	35	22	5	176	38	.30	16
Copper	3/16	EA	Std	50	40	75	70	35	20.5	33	180	35	.35	95
	1/8	EC		50	40	75	68	33	20	25	175	35		75
	11	J		40	35	75	54	24	18	14	120	23		40
	15	M		35	35	75	46	18	17	8	95	15		23
Stainless (1 thru 5)	3/16	EA	Std	55	50	75	68	38	20.5	20	180	42	.32	60
	1/8	EC		55	50	75	68	36	20	15	181	40		48
	11	J		45	35	75	50	25	18	8	97	22		26
Zinc	3/16	AH	Std	45	35	65	68	32	20.5	60	161	30	.35	162
	1/8	CH		50	40	65	68	34	20	45	175	35		130
	11	J	High	40	35	55	54	24	18	20	120	23		55
	15	M		35	35	55	46	18	17	12	95	15		35

Notes:

Hardware

1. Refer to the Gas Head Hardware selection chart for additional hardware recommendations before spraying.

Operating Parameters:

2. After lighting, adjust flowmeter settings to flows listed in columns 8, 9 & 10.
3. Adjust the Air PRESSURE for lighting and running to column 7 values. At this PRESSURE, the FLOW reading should be adjusted to column 10 reading.

Performance:

4. The figures in columns 11, 12, 13 and 15 are optimum. They can be achieved by skilled operators with all equipment in excellent condition.
5. One cubic inch of deposited coating covers 100 square inches of surface @ .010" thick or 7 feet of surface area @ .001" thick
6. Fan spray air cap spray rates will be lower than charted
7. Use non-loading nozzles and air caps when spraying Babbit A, tin, zinc or aluminum alloys in start/stop operation
8. When using type AF or GF flowmeters, reduce pressures shown as necessary to obtain flowmeter readings shown.
9. When spraying Babbitt: With non-loading hardware in start/stop operation, lower air flow 5-10 points and adjust Oxygen flow to provide the same relationship to acetylene as shown in the table above. Increase air flow if loading occurs.

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SPRAYING TABLE – METRIC SYSTEM
PPS5K - Propane Jetted Hardware

METAL	Recommended Hardware (Note 1)			Lighting Pressure Settings (bar)			Flowmeter reading			Consumption per hour (Note 4)			Kgs/ wire Req. per CM_3 of coating	Deposited coating build-up speed (CM_3 /Hr) Notes 4 & 5
	Noz. Wire Size	Air cap size	Gears	Oxy note 2	Prop note 2	Air Notes 2 & 3	Oxy note 2 (2GF)	Prop note 2 (2GF)	Air Notes 2 & 3 (3AF)	Kg.. Wire	M_3 Oxy	M_3 Prop		
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
Aluminum (note 7)	3/16	EA	Std	3.10	2.76	4.48	69	35	20.5	7.3	4.9	0.96	.0028	2622
	1/8	EC		3.45	2.76	4.48	72	33	20	5.4	5.5	0.93		1966
	11	J		2.76	2.41	3.79	54	24	18	2.5	3.4	0.65		901
	15	M		2.41	2.41	3.79	46	18	18	.91	2.7	0.42		328
Aluminum Bronze	3/16	EA	Std	3.45	2.76	4.48	70	35	20.5	9.5	5.1	0.99	.0097	951
	1/8	EC		3.45	2.76	3.79	68	33	20	8.2	5.0	0.99		836
	11	J		2.76	2.41	3.79	54	24	18	3.6	3.4	0.65		377
Babbitt	3/16	EA	Std	2.07	2.07	4.48	50	26	20.5	43.1	3.7	0.57	.0097	4425
	1/8	EC		1.72	1.72	4.48	45	17	20	18.1	2.3	0.34		1885
	3/16	EA	High	3.10	2.41	4.48	72	35	20.5	83.9	5.2	0.99		8687
	1/8	EC		1.72	1.38	4.48	50	22	20	40.8	2.5	0.48		4179
Bond Wire	1/8	C	Std	3.79	3.10	4.83	68	35	22	2.3	5.0	1.1	.0083	262
Copper	3/16	EA	Std	3.45	2.76	4.48	70	35	20.5	15.0	5.1	0.99	.0097	1557
	1/8	EC		3.45	2.76	4.48	68	33	20	11.3	5.0	0.99		1229
	11	J		2.76	2.07	3.79	54	24	18	6.4	3.4	0.65		656
	15	M		2.41	2.07	3.79	46	18	17	3.6	2.7	0.42		377
Stainless (1 thru 5)	3/16	EA	Std	3.79	3.45	4.48	68	38	20.5	9.1	5.1	1.2	.0089	983
	1/8	EC		3.79	3.45	4.48	68	36	20	6.8	5.1	1.1		787
	11	J		3.10	2.41	4.48	50	25	18	3.6	2.8	0.63		426
Zinc	3/16	AH	Std	3.10	2.41	4.48	68	32	20.5	27.2	4.6	0.85	.0097	2655
	1/8	CH		3.45	2.76	4.48	68	34	20	20.4	5.0	0.99		2131
	11	J	High	2.76	2.41	3.79	54	24	18	9.1	3.4	0.65		901
	15	M		2.41	2.41	3.79	46	18	17	5.4	2.7	0.42		574

Notes:

Hardware

1. Refer to the Gas Head Hardware selection chart for additional hardware recommendations before spraying.

Operating Parameters:

2. After lighting, adjust flowmeter settings to flows listed in columns 8, 9 & 10.
3. Adjust the Air PRESSURE for lighting and running to column 7 psi. At this PRESSURE, the FLOW reading should be adjusted to column 10 reading.

Performance:

4. The figures in columns 11, 12, 13 and 15 are optimum. They can be achieved by skilled operators with all equipment in excellent condition.
5. One cubic centimeter of deposited coating covers 100 square centimeters of surface @ .01 mm thick or 1 square meter of surface area @ .0001mm thick
6. Fan spray air cap spray rates will be lower than charted
7. Use non-loading nozzles and air caps when spraying Babbit A, tin, zinc or aluminum alloys in start/stop operation
8. When using type AF or GF flowmeters, reduce pressures shown as necessary to obtain flowmeter readings shown.
9. When spraying Babbitt: With non-loading hardware in start/stop operation, lower air flow 5-10 points and adjust Oxygen flow to provide the same relationship to acetylene as shown in the table above. Increase air flow if loading occurs.

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