

SPRAYING TABLE – US SYSTEM
Acetylene Hardware

METAL	Noz. Wire Size	Air Cap Size	Lighting Pressure Settings (psi)			Flowmeter reading			Consumption per hour			Speed Sq. Ft. Per Hr. .001" Thick	Wire Weight .001" Thick 1 Sq. Ft.
			Oxy.	Acet.	Air	Oxy. (2GF)	Acet. (2GF)	Air (3AF)	Oxy. Ft ³	Acet. Ft ³	Wire Lbs.		
1	2	3	4	5	6	7	8	9	10	11	12	13	14
Aluminum	3/16	AH	38	15	75	48	48	24	105	50	15	1070	.014
	1/8	CH	35	15	75	45	42	24	100	45	11	790	.014
Babbitt	3/16	AH	30	15	75	35	59	24	60	65	96	1750	.055
	1/8	CH	25	15	75	24	35	24	34	31	50	960	.052
Tin	1/8	CH	25	15	75	24	35	24	34	31	50	1000	.050
Zinc	3/16	AH	38	15	75	48	48	24	105	50	65	1250	.052
	1/8	CH	35	15	75	45	42	24	100	45	48	980	.049

Note: For **Babbitt** and **Tin**, Non-loading hardware is recommended. If excessive loading occurs when spraying **Zinc** and **Aluminum** in frequent start/stop applications, replace standard hardware with non-loading hardware. Oxygen and Acetylene flowmeter readings for non-loading hardware are as follows:

3/16" wire Oxy. = 43 Acet. = 43

1/8" wire Oxy. = 34 Acet. = 34

SPRAYING TABLE – METRIC SYSTEM
Acetylene Hardware

METAL	Noz. Wire Size	Air Cap Size	Lighting Pressure Settings (bar)			Flowmeter reading			Consumption per hour			Speed m ² Per Hr. 0.1mm Thick	Wire Weight Kg/m ² 0.1mm Thick
			Oxy.	Acet.	Air	Oxy. (2GF)	Acet. (2GF)	Air (3AF)	Oxy. m ³	Acet. m ³	Wire Kg.		
1	2	3	4	5	6	7	8	9	10	11	12	13	14
Aluminum	3/16	AH	2.62	1.03	5.17	48	48	24	3.0	1.4	6.8	25.3	0.27
	1/8	CH	2.41	1.03	5.17	45	42	24	2.8	1.3	5.0	18.6	0.27
Babbitt	3/16	AH	2.07	1.03	5.17	35	59	24	1.7	1.8	43.5	41.3	1.06
	1/8	CH	1.72	1.03	5.17	24	35	24	0.96	0.88	22.7	22.7	1.00
Tin	1/8	CH	1.72	1.03	5.17	24	35	24	0.96	0.88	22.7	23.6	0.96
Zinc	3/16	AH	2.62	1.03	5.17	48	48	24	3.0	1.4	29.5	29.5	1.00
	1/8	CH	2.41	1.03	5.17	45	42	24	2.8	1.3	21.8	23.1	0.94

Note: For **Babbitt** and **Tin**, Non-loading hardware is recommended. If excessive loading occurs when spraying **Zinc** and **Aluminum** in frequent start/stop applications, replace standard hardware with non-loading hardware. Oxygen and Acetylene flowmeter readings for non-loading hardware are as follows:

3/16" wire Oxy. = 43 Acet. = 43

1/8" wire Oxy. = 34 Acet. = 34

SPRAYING TABLE – US SYSTEM

Propane Hardware

METAL	Noz. Wire Size	Air Cap Size	Lighting Pressure Settings (psi)			Flowmeter reading			Consumption per hour			Speed Sq. Ft. Per Hr. .001" Thick	Wire Weight .001" Thick 1 Sq. Ft.
			Oxy.	Prop.	Air	Oxy. (2GF)	Prop. (2GF)	Air (3AF)	Oxy. Ft ₃	Prop. Ft ₃	Wire Lbs.		
1	2	3	4	5	6	7	8	9	10	11	12	13	14
Aluminum	3/16	AH	50	50	75	68	34	24	165	35	15	1070	.014
	1/8	CH	55	50	75	68	34	24	165	35	11	790	.014
Babbitt	3/16	AH	35	40	75	52	32	24	100	30	96	1750	.055
	1/8	CH	35	35	75	53	30	24	100	25	50	960	.052
Tin	1/8	CH	35	35	75	53	30	24	100	25	50	1000	.050
Zinc	3/16	AH	50	50	75	68	34	24	165	35	65	1250	.052
	1/8	CH	55	50	75	68	34	24	165	35	48	980	.049

Note: For **Babbitt** and **Tin**, Non-loading hardware is recommended. If excessive loading occurs when spraying **Zinc** and **Aluminum** in frequent start/stop applications, replace standard hardware with non-loading hardware. There will be a reduction in spraying speed.

SPRAYING TABLE – METRIC SYSTEM

Propane Hardware

METAL	Noz. Wire Size	Air Cap Size	Lighting Pressure Settings (bar)			Flowmeter reading			Consumption per hour			Speed m ₂ Per Hr. 0.1mm Thick	Wire Weight Kg/m ₂ 0.1mm Thick
			Oxy.	Prop.	Air	Oxy. (2GF)	Prop. (2GF)	Air (3AF)	Oxy. m ₃	Prop. m ₃	Wire Kg.		
1	2	3	4	5	6	7	8	9	10	11	12	13	14
Aluminum	3/16	AH	3.45	3.45	5.17	68	34	24	4.7	1.00	6.8	25.3	0.27
	1/8	CH	3.79	3.45	5.17	68	34	24	4.7	1.00	5.0	18.6	0.27
Babbitt	3/16	AH	2.41	2.76	5.17	52	32	24	2.8	0.85	43.5	41.3	1.06
	1/8	CH	2.41	2.41	5.17	53	30	24	2.8	0.70	22.7	22.7	1.00
Tin	1/8	CH	2.41	2.41	5.17	53	30	24	2.8	0.70	22.7	23.6	0.96
Zinc	3/16	AH	3.45	3.45	5.17	68	34	24	4.7	1.00	29.5	29.5	1.00
	1/8	CH	3.79	3.45	5.17	68	34	24	4.7	1.00	21.8	23.1	0.94

Note: For **Babbitt** and **Tin**, Non-loading hardware is recommended. If excessive loading occurs when spraying **Zinc** and **Aluminum** in frequent start/stop applications, replace standard hardware with non-loading hardware. There will be a reduction in spraying speed.