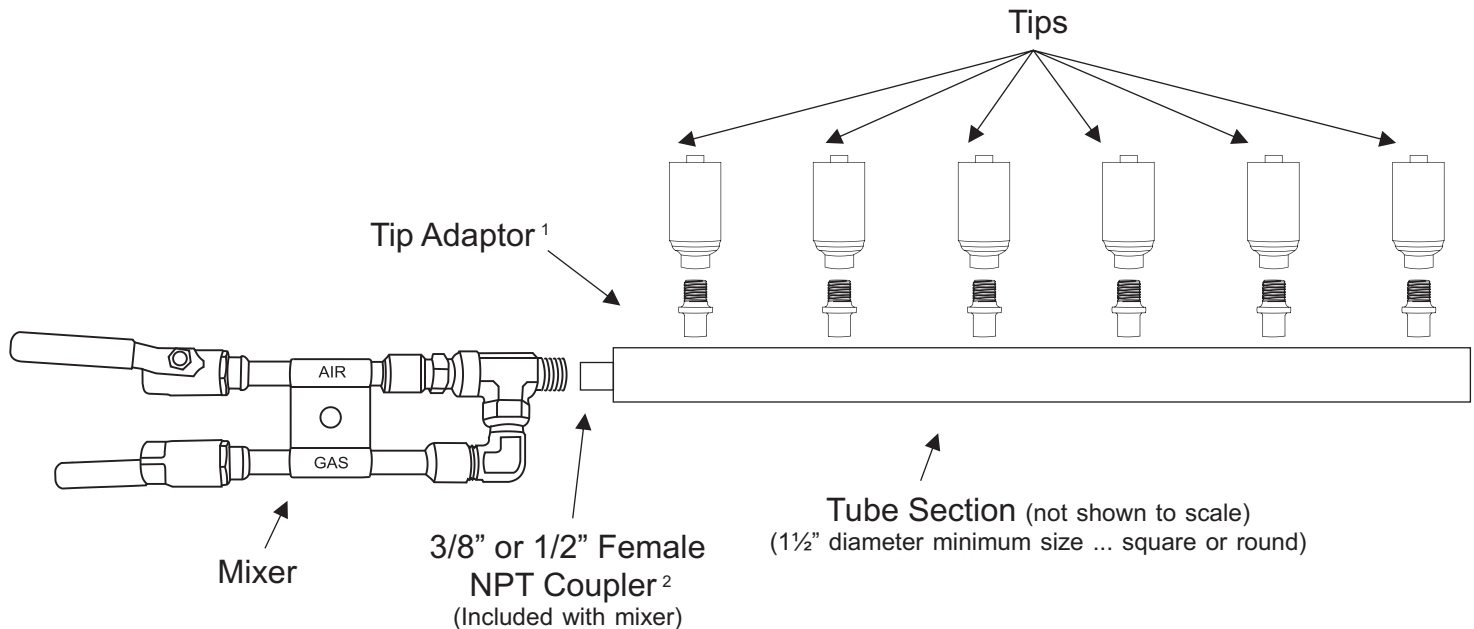


# BELCHFIRE<sup>®</sup>

## Tube Burner Assembly Instructions

Natural Gas or Propane and Compressed Air



<sup>1</sup> Drill 1/2" hole for tip adaptor and then weld in place

<sup>2</sup> Mount 3/8" or 1/2" coupler on end or middle of tube for best results

The Belchfire Tube Burner now allows a user to heat long sections of material with a single mixer. Belchfire supplies the mixer, tips and tip adaptors. The user supplies the tube section. The tube section, square or round, should have a minimum size of 1 1/2", and for welding the top adaptors to the tube, a minimum wall thickness of 1/8". Weight and ease of handling must be considered when deciding on the tube size. After the tube is cut to desired heating length, drill 1/2" holes at each tip location. Place the tip adaptors in the hole and weld them to the tube. The tip adaptors allow the tips to be threaded on to the tube. The mixer requires a 3/8" or 1/2" NPT female fitting. A hole must be drilled in the end cap or the middle of the tube section to accommodate the fitting. Place the fitting in the hole and weld. For longer tube sections the mixer can be mounted in the middle for a more even distribution of air-gas mixture. The mixer uses Belchfires unique technology to increase gas flow to maximize BTU output. End caps now can be welded to the tube. Once all parts are welded to the tube, the mixer and tips can be installed by threading them on. All normal safety precautions associated with this type of equipment should be observed. In addition, check all welding joints for leaks.

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# OPERATING INSTRUCTIONS

# **BELCHFIRE**®

## TUBE BURNER

The Belchfire tube burner is designed to operate with propane or natural gas plus air supplied by shop air compressor systems.

**WARNING:** Do not use acetylene or oxygen with these or any other Belchfire torches.

Maximum efficiency will be obtained if air and gas lines are at least 3/8" I.D.

Gas and air fittings are 3/8" NPT (Female). Gas line pressure can be 1-15 psi. If regulator is required, use one that is designed for type of fuel being used. Air pressure should be 50-120 psi.

As with all fuel-burning torches, there is a certain amount of hazard involved with the operator and his use of the torch. All normal safety precautions associated with this type of equipment should be observed.

When lighting the tube burner, each tip has to be lit individually. Open gas valve slowly 1/3 turn counter-clockwise. Light the tip closest to mixer first and proceed lighting the next one until all tips have a flame. Once all tips are lit, slowly open air valve counter-clockwise 1/3 turn.

The Belchfire tube burner has a completely flexible flame and can be adjusted to suit any purpose. The size and type of flame is controlled by adjusting the valves.

To shut down – turn gas valve clockwise to stop. Allow air to flow long enough to cool tips. Turn valve clockwise to stop. Shut off fuel and air supply at the source and disconnect the torch.

Should any questions arise about the Belchfire tube burner, feel free to call us at any time.

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