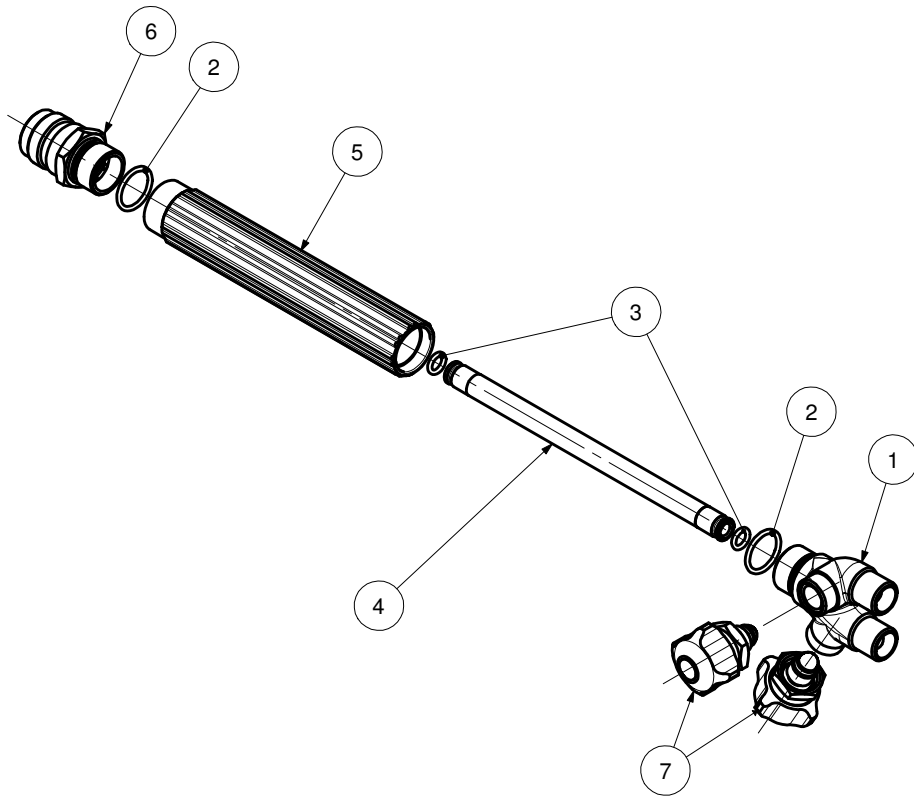


HARRIS

WELDING TORCH
MODEL 432
I432



PART NUMBER/DESCRIPTION

Item	1	6
MODEL No.	TAIL	BLOCK
432	4388	4309
432GB	4388E	4309
I432	4388	I4309
I432GB	4388E	I4309

SERVICE NOTES

ITEM No.	TORQUE SPECIFICATION	SERVICE TOOL OR NOTES
1		12T4 - 7/16"-27-UNS-3B-RH - Tap For Needle Valve Threads
		43T3 - 5/8"-27-UNS-3A-RH - Die For Needle Valve Threads
		43T1 - To Reseat Needle Valve Seat
		56T8 - 3/4"-27-UNS-3A-RH - Die For Tail Handle Threads
		52T2R - To Reseat Oxygen Hose Connection For Tail 4388
		52T2L - To Reseat Fuel Hose Connection For Tail 4388
		52T3R - 9/16"-18-UNF-3A-RH - Die Oxygen Hose Threads For Tail 4388
		52T3L - 9/16"-18-UNF-3A-LH - Die Fuel Hose For Tail 4388
		T43ER - To Reseat Oxygen Hose Connection For Tail 4388E
		T43EL - To Reseat Fuel Hose Connection For Tail 4388E
	43ETR - G 3/8" A-RH - Die Oxygen Hose Threads For Tail 4388E	
	43ETL - G 3/8" A-LH - Die Fuel Hose Threads For Tail 4388E	
2 - 3		Use Molykote M-55
5	550-620 kgcm	42T1 - Special Handle Wrench
6		28T5 - 7/8"-18-UNS-2A-RH - Die For Mixer Threads For Block I4309
		63T1 - To Reseat Conical Seat For Block I4309
7	62 kgcm	19mm Open end Wrench - Use Molykote M-55

ITEM	PART.No.	Qty	DESCRIPTION	ITEM	PART. No.	Qty	DESCRIPTION
1	See Table	1	Tail	5	4343	1	Handle
2	215X7116B	2	O-Ring	6	See Table	1	Block
3	215X7110A	2	O-Ring	7	VA43GBPS	2	Valve
4	4392	1	Tube				

IMPORTANT: All repairs or conversions should be carried out by a qualified repairer, with genuine HARRIS parts, to HARRIS repair specifications, and in accordance with local laws or regulations. No contaminant (grease, oil, others) to come in contact with oxygen.