



## Sizing Recipe

Mixing of sizing used in the organ pipe soldering process is an imprecise science. What follows are generally accepted guidelines for the mixing of ingredients.

### **Gum Arabic Solution**

Fill a suitable mixing container half full with powdered Gum Arabic. Slowly stir in hot tap water by hand until the solution is of a thick, smooth consistency similar to honey. Stir well every hour or so over a 6-8 hour period. Let the solution stand overnight to allow air bubbles to rise to the top. Remove foam from the top of gum solution. Solution is now ready to use.

### **Sizing**

Place six parts of powdered Whiting in a suitable mixing container. Slowly stir in five parts Gum Arabic Solution. Slowly stir in enough room temperature water to thin this mixture to a paint-like consistency. An electric hand drill with mixing attachment works well. Solution is now ready to use.

### **Application**

#### Zinc Pipes

Dilute Gum Arabic Solution by one-half with water. Rub on evenly. Let dry. Zinc is now ready to seam and solder.

#### Spotted Metal Pipes

Paint mixed Sizing solution on tin/lead pipe surface with paint brush. Rub the Sizing into the surface with hand until the Sizing turns dark. Apply second coat with brush and let dry. Metal is ready to seam and solder.

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