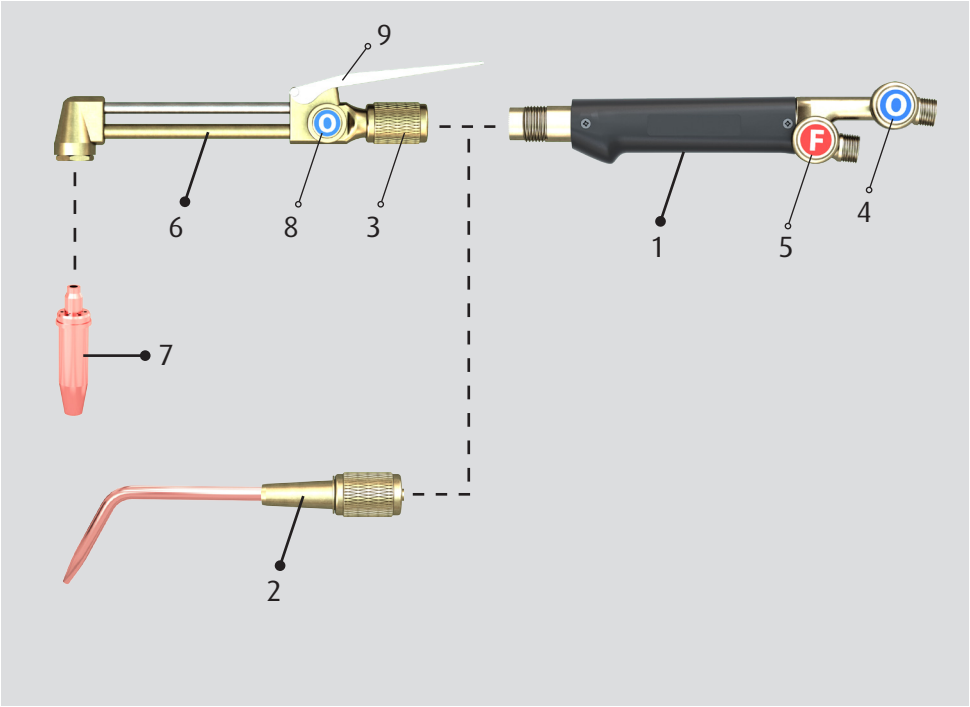
A Member of
The Linde Group

Oxy-fuel cutting, heating and welding equipment
Instructions



1. Shank
2. Welding Mixer
3. Quick connecting nut
4. Valve for Oxygen
5. Valve for Fuel Gas
6. Cutting Attachment
7. Cutting Nozzle
8. Valve for Heating Oxygen
9. Lever for Cutting Oxygen

OPERATING INSTRUCTIONS

Connecting the torch

Connect the torch to the cylinder regulators or with a central gas supply to the supply points with the approved hose. Secure the connection with hose clamps. If leakage is suspected, check using soapy water.

Lighting and regulating the torches

(using the valves on the torch)

A) Welding, brazing, heating, etc.

1. Attach an appropriate welding or heating mixer into the shank of the torch. Check that the sealing O-Ring at the end of the mixer is intact.
2. Close both valves (4 and 5) on the shank.
3. If regulator is fitted with a needle valve this should be opened. Using the regulator's pressure adjusting screw set to the recommended working pressure. The same applies to supply points if a gas pipeline is used.
4. Open the oxygen valve (4) on the shank and allow the gas to purge the hoses for a short time. Long hoses and small welding nozzles require a longer purge time. Maintain a small gas flow.
5. Open the torch fuel gas valve (5) on the shank and allow the gas to flow for a short time. Purge as above.
6. Light the torch.
7. Regulate the size and type of flame with the valves (4 and 5) on the shank. The torch is now ready for use.

B) Cutting

1. Attach the cutting attachment to the shank. Provide with a suitable cutting nozzle.
2. Open the oxygen valve (4) completely and close the fuel gas valve (5). Close the cutting attachment's heating oxygen valve (8)
3. With the help of the adjusting screw on the regulator set the recommended working pressure.
4. Open the heating oxygen valve (8) and allow the gas to purge the hose for a short time. Long hoses and/or small cutting nozzles require a longer purge time. Maintain a small gas flow.
5. Open the torch fuel gas valve on the shank (5) and allow the gas (acetylene or propane) to flow. Purge as above.
6. Light the flame.
7. Open the cutting oxygen valve by pressing down on the lever (9). Adjust to correct oxygen pressure with the adjusting screw on the regulator or supply point.
8. With the cutting oxygen flowing, adjust the heating flames using the fuel gas valve (5) on the shank and the cutting attachment's heating oxygen valve (8). The torch is now ready for use.

Extinquishing the flame

A) Welding, brazing, heating, etc.

First close the fuel gas valve (5) on the shank and then the oxygen valve (4).

B) Cutting

Release the cutting oxygen lever (9). Close the fuel gas valve (5) on the shank and then the cutting attachment's heating oxygen valve (8).

MAINTENANCE

Keep the torch clean. Do not grease any parts. Oil or grase can be explosive when in contact with oxygen.

When necessary clean the holes of the welding and cutting nozzles with appropriate cleaning needles. Push these carefully in and out without twisting. Spiral drills steel wires, etc. scratch and spoil the nozzle channels.

If the outlet end of the welding or cutting nozzle is damaged, it may be repaired by polishing perpendicularly with a fine emery cloth laid on a flat surface. Obtain help from a sevice engineer if repairs are necessary.