

Oxyacetylene Startup and Shutdown Procedure

Start Up

Step 1: Turn on the oxygen tank completely, then crack open the secondary oxygen torch valve, set the regulator to 30 psi, then close the valve.

Step 2: Turn on the acetylene tank one turn, or until there is full pressure on the regulator. Crack open the acetylene torch valve and set the regulator to 5 psi.

Step 3: Light the torch using a striker. Adjust to get a clean burning flame.

Step 4: Slowly open the secondary oxygen valve to gain a neutral flame.

Cutting

Step 1: Preheat the metal by holding the torch with the cone on the metal.

Step 2: When metal moves from red to yellow, press handle to start cutting.

Step 3: Move across slowly to maintain cutting depth and accuracy.

Step 4: Release handle to stop cutting.

Shut Down

Step 1: Close the acetylene torch valve first to kill the flame, then the secondary oxygen torch valve.

Step 2: Close the acetylene tank valve.

Step 3: Crack open the acetylene torch valve, bleed the line, then close the valve. Turn the regulator counterclockwise three times or until it hits the stops. Gauges should be zero.

Step 4: Close the oxygen tank valve.

Step 5: Crack open the oxygen torch valve, bleed the line, then close the valve. Turn the regulator counterclockwise three times or until it hits the stops. Gauges should be zero.

Step 6: Wrap hoses around cart and lay torch handle in the tray.