

TORCH BEVEL ATTACHMENT

OPERATION MANUAL

INTRODUCTION:

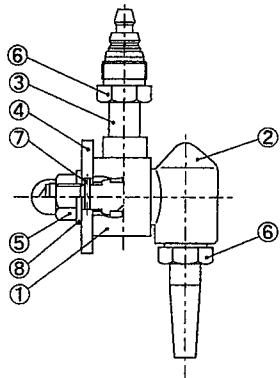
Thank you very much for your choice on our Torch Bevel Attachment.
Please read carefully the provided operation manual when you want to use it.

SPECIFICATIONS:

1. The gases available for the use: acetylene and propane
2. The available torch tip: Type.100 Cutting Tip numbers, OO-6
3. The maximum cutting thickness 150mm

NAMES OF PARTS:

See Fig. 1.



Ref Numbers	Names of parts
1	Body
2	Torch head
3	Fixing nut
4	Torch angle while
5	Lock nut (2)
6	Lock nut (1)
7	Spring pin
8	Washer

HOW TO MOUNT THE TORCH BEVEL ATTACHMENT TO THE BLOW PIPE :

1. Mount the attachment to the blow pipe.
2. Put the torch tip to the top of the torch, put the nut to the torch tip and tighten it by spana.

CUTTING OPERATION :

Please refer to the Torch Cutting Capacity List to find out the required oxygen cutting pressure or your fuel gas cutting pressure, and adjust your gas pressure for the practical use.

For example: For the oxygen used 102 Type torch, try to give pressure up for 0.05MPa. For acetylene used 102 Type torch, the gas pressure should stay same. For the same gas used 102 D7 tip, try to get 0.01MPa more.

For the propane used 106 and 106 D7 tips try 0.01MPa up.

CAUTION FOR THE OPERATION :

1. Don't change the torch angle while discharging the gas.
2. Always try to protect the torch head and don't make it get scratchy by Apply the cap there after the operation and or while storing.
3. When you want to change the torch angle, make it sure that you try it after making the lock nut (Z) to be loosed.