

Remove the cap from the cutting torch's head nut followed by the nut itself. Fit the required nozzle (see table), screw the head nut back in place and tighten up with the spanner provided.

Nozzle Type	Acetylene PSI	Oxygen PSI	Cut Thickness Range
ANM-S 1/32"	2	20 – 25	1/8" to _"
ANM-S 3/32"	3	70 – 80	5" to 7"
ANM-S 1/8"	4	90 – 100	9" to 12"

Check that the control valves on the cutting torch are fully closed then slowly open the valve on the acetylene cylinder with the spanner provided – keep this in place so you can turn the gas off quickly in an emergency.

Set the regulator's pressure adjustment valve to the working pressure required then check for leaks (see Gas Safety). Repeat the process and checks for the Oxygen connections. If no leaks are found you may proceed.

### Backfires

If the equipment 'backfires' (that is, if gas burns inside the blowpipe) immediately close all acetylene valves, followed by the oxygen valves. Once the fire is extinguished, let the equipment cool and check its condition before re-lighting. If in doubt, contact your local HSS Hire Weld Depot for advice.

Now you can light the cutter. Slightly open the oxygen valve followed by the acetylene valve, point the spark lighter along the nozzle and squeeze its trigger.

Adjust the acetylene valve to stop the flame smoking, then continue to open the cutter's oxygen valve until you have a neutral flame – a well defined white cone surrounded by a mere haze of Acetylene.

Finally, depress the cutter's lever and re-adjust the oxygen flow to give a neutral flame once again.

### Fire Safety

Never cut any container that has held fuel or any flammable or oil based product. Always ensure combustible materials are removed to 9m from the work area or protect them with suitable guards. Always keep a dry power extinguisher handy.

## EQUIPMENT CARE

Never push the equipment beyond its design limits. If it will not do what you want with reasonable ease and speed, assume you have the wrong type or size of cutting equipment for the job. Ask at your local HSS Hire Weld Depot for advice.

**Handle hoses with care.** Never expose them to heat, slag, sparks, oil or grease. Never trail them anywhere they will be vulnerable to damage or where they could trip someone.

**Treat nozzles with care.** If they block up, clean them out with one of the reamers provided. However, never use these to clean out the small preheat and cutting stream holes at the seating end of the nozzle.

**Never interfere with the seating surfaces of nozzle or cutting attachment.**

When not in use, store the equipment somewhere clean, dry and safe from thieves.

**Look after the gas cylinder.** Keep them away from dirt, never open their valves with anything other than the key provided.

## FINISHING OFF

Close the cutting torch's acetylene valve, wait for the flame to go out, then close the oxygen valve (in that order).

Close both cylinder valves and relieve the pressure in the system.

Open the oxygen valves on the cutting torch and wait for the pressure to drop, then close both valves in reverse order. Open the cutting torch's acetylene valve and close it when the pressure drops.

Turn the oxygen and acetylene regulator's pressure adjustment valves fully anti-clockwise and leave the equipment to cool before dismantling

Put everything back in its case and coil the hose without kinks, ready for return to your local HSS Hire Weld Depot.



## ...any comments?

If you have any suggestions to enable us to improve the information within this guide please fax your comments or write to the Product Manager at the address below

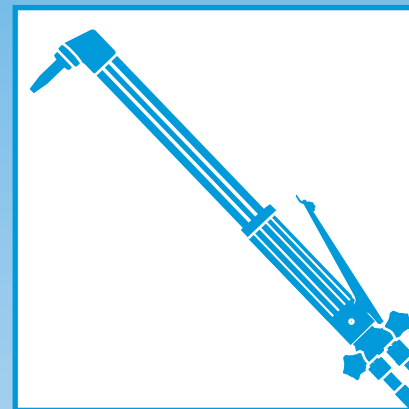
**Fax: 020 8687 5001**

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# HSS Hire-Weld



# Heavy Duty Cutting Kit Oxy-Acetylene

A portable cutting kit capable of cutting up to 300mm thickness.



## GENERAL SAFETY

For advice on the safety and suitability of this equipment contact your local HSS Hire Weld Depot.

There is a serious risk of personal injury if you do not follow all instructions laid down in this guide. The hirer has a responsibility to ensure that all necessary risk assessments have been completed prior to the use of this equipment.

Most welding tasks may be considered as hot work in site situations and may be subject to specific permits to work.

This equipment should only be used by an operator who has been deemed competent to do so by his/her employer.



This equipment should be used by an able bodied, competent adult who has read and understood these instructions. Anyone with either a temporary or permanent disability, should seek expert advice before using it.


Keep children, animals and bystanders away from the work area. Cordon off a NO GO area using cones and either barriers or tape, available for hire from your local HSS Hire Weld Depot.


Welding screens are also available for hire from your local HSS Hire Weld Depot.




## Gas Safety

Store oxygen and acetylene cylinders separately in a cool, clean, well ventilated place offering protection against mechanical damage and accidental ignition. Before lighting up, check gas connections for leaks by smearing leak detecting fluid on the joints and looking for bubbles. Never check for leaks with a naked flame. Tighten leaking connections with the spanner provided. If the leak remains STOP, close all cylinder valves and contact your local HSS Hire Weld Depot.

  Never use this equipment if you are ill, feeling tired, or under the influence of alcohol or drugs.

 Fumes produced by the cutting process, if inhaled, can be harmful to health. A suitable mask must be worn when using this equipment. Respiratory protective equipment is available for hire, contact your local HSS Hire Weld Depot for details.

 Suitable welding goggles are supplied with this kit. If the lenses of the goggles become damaged, return them to your local HSS Hire Weld Depot.

   Wear non-flammable clothing and footwear, plus gauntlets and welding goggles, to protect you against sparks and slag. Avoid loose garments and jewellery.



Gas cylinders are heavy, never attempt to lift a cylinder, full or empty, on your own always get help.

## Let It Cool

Handle cutting equipment and work with care – it will be hot. Leave equipment to cool before attempting to handle it.

Always transport, store and operate the equipment with the cylinders in an upright position.

Ensure the work area is well lit and ventilated, a fume extractor should be used. If in doubt, ask about lighting and ventilation equipment at your local HSS Hire Weld Depot.

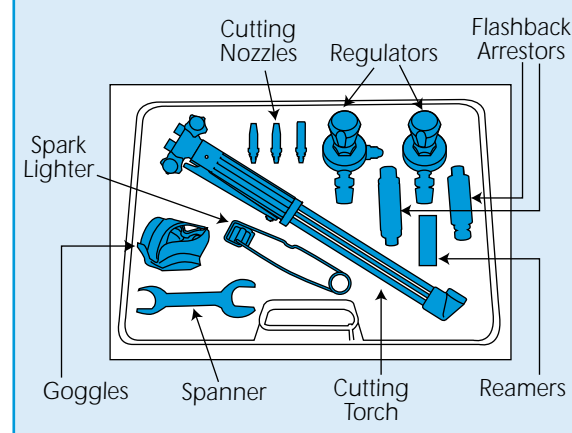
Do not work near flammable gases or liquids, petrol or paint thinner fumes for example. Keep combustible materials at a safe distance – at least 9m.

Check the condition of the equipment before use paying special attention to the hoses and the rubber 'O' rings on gas connections. If it shows signs of damage or excessive wear, return it to your local HSS Hire Weld Depot.

COSHH information sheets are available from your local HSS Hire Weld Depot.

## GETTING STARTED

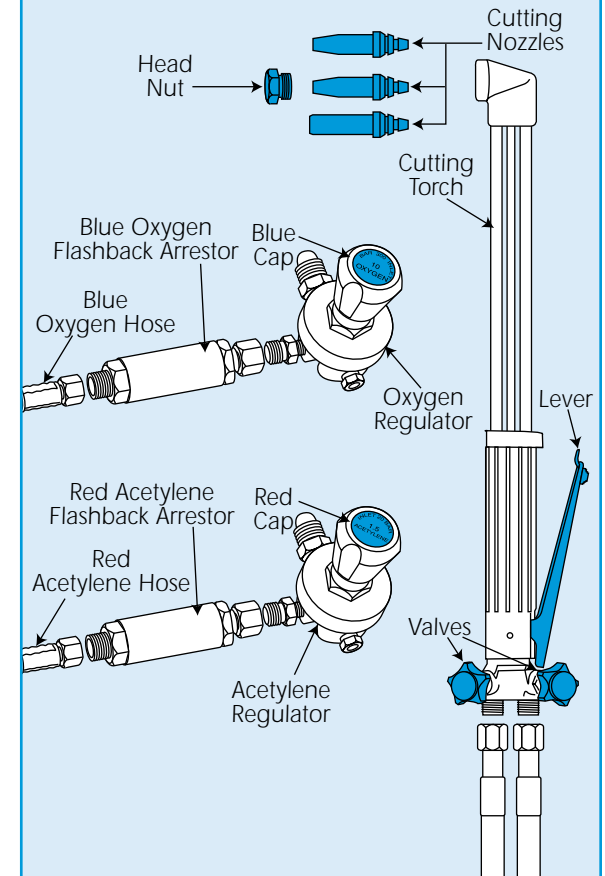
### Case Contents



This guide is designed to help the user to safely set up and dismantle the equipment. It is not intended as a guide to cutting techniques as it is assumed that the user already has the necessary training/knowledge and experience.

The cutting kit is supplied with a combination spanner for opening the cylinder and for tightening all connections. When making connections, NEVER extend the spanner's length to gain extra torque, or hit it with a hammer or mallet.

## Heavy Duty Cutting Kit Oxy-Acetylene



Clamp the gas cylinders in the trolley and check that their valves are clean, opening them momentarily to blow out any dirt.

Fit each cylinder with the correct regulator, making sure that all connections are undamaged, clean and free from grease. Never use sealing compound on any connection. **Note: All acetylene connections** (with grooves in the nuts) **have left-handed threads.**

Connect the supply hoses to the respective regulators, ensuring the flashback arrestor is fitted between the hose and regulator.

The Oxygen hose is coloured blue and all connections have a right hand thread.

The Acetylene hose is coloured red and all connections have a left hand thread.

Check that both regulators' pressure adjustment valves are fully closed (turn clockwise). You can now connect the supply hoses to the cutting torch.