

Safe Torch Operation Procedures Using Propylene

1. Prior to lighting torch, make sure valves from source (cyl/pipeline) are closed. There should be “0” pressure on both the fuel gas and oxygen regulators. If pressure appears on the regulators, slightly open both torch valves to bleed lines. Close both torch valves.
2. Inspect cutting tip. Make sure no obstructions or slag is blocking preheat and cutting orifices. Inspect all connections and make sure they are tight.
3. Make sure the set screw in both the oxygen and fuel gas regulators has been backed out (counter clockwise) to the point of no pressure on the diaphragm (loose). When the above has been completed, you are ready to start the lighting procedure:
 - A. Open valves from source (cyl/pipeline) slowly. Set desired pressure on regulators by turning set screw clockwise. (8# fuel gas – 40% oxygen pressure on hand torch operations). In the case of machine torches, follow tip manufacturer’s recommendations. Open both the oxygen and fuel gas torch valve ¼ turn, light torch with approved lighter. Adjust to desired flame by adding fuel gas, then oxygen.
 - B. To close your cutting operation, cut off the fuel gas valve at torch first. This will extinguish the flame. Then close oxygen valve.
 - C. At day’s end or shift change, close the fuel gas and oxygen valves from source (cyl/pipeline). Drain regulators and line by slightly opening both torch valves, and “0” pressure shows on the regulators. Close torch valves. Turn regulator set screws counter clockwise until “0” pressure is applied on the diaphragm of both the fuel gas and oxygen.
 - D. The above procedures do not apply to acetylene.



EM-300-4C (EXTERNAL MIX) TORCHES & NOZZLES HIGH VOLUME, AIR COOLED TORCH, STRAIGHT & BEVEL CUTTING

The **EM (External Mix)** torches and tips are of a completely new design to increase productivity. The **External Mix** type tip assures safety, high quality cutting, long life, ease of operation and economy. For use with propylene, cutting materials up to 24 inches thick

OUTSTANDING FEATURES

- **Safe – No Flash Back**
External mixing eliminates any possibility of flash-back
- **Cool Running – No Overheating**
External mixing is engineered to run cool when cutting.
- **Extra Stand-Off Distance**
Conventional stand-off is less than 2" With EM (External Mix). 5" to 6" is common.
- **High Quality Cutting Surface**
Minimal slag – straight cut – square top.
- **Highly Energy Efficient**
Oxygen shielding of the fuel gas reduces consumption
- **Available With Attachable Nozzle Protection**
Protective shroud for cooler, enhanced operation

