

- Make sure to have proper clothing, gloves, and an approved pair of oxy-fuel cutting safety glasses.
- Check the torch tip to insure the tip is clean.
- Check the oxygen regulator screw to insure pressure is released.
- Check the acetylene regulator screw to insure pressure is released.
- Open the oxygen cylinder valve completely.
- Adjust the oxygen cylinder working pressure gauge using the regulator adjusting screw to approximately 25 p.s.i.
- Open the acetylene cylinder valve one (1) full turn.
- Adjust the acetylene cylinder working pressure gauge using the regulator adjusting screw to approximately 5 p.s.i.
- Open the oxygen torch valve completely.
- Crack the acetylene torch valve.
- Ignite the torch with a flint lighter.
- Once the torch is lit, use the acetylene torch valve to increase the fuel until the flame stops smoking.
- Using the oxygen preheat valve, adjust the flame to neutral.
- Once the flame is neutral, make sure the inner cone (blue flame) does not change when the oxygen-cutting lever is depressed.
- You are now ready to cut your material.
- FYI: The neutral oxy-acetylene flame has a temperature of approximately 5500°F.