

PORTABLE GAS CUTTING MACHINE MANUAL



Vavdi Survey no. 28, Shivam Industrial Area, Street No.3 Plot No.7, Near Sunny Raj Metal,
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SPECIFICATION

Blow pipe shall have separate control knob for acetylene (Red Colour) and oxygen (Blue Colour).	Yes
Supplied with Oxygen Cylinder	YES
Capacity of Oxygen Cylinder(in Cu-m) if no choose NA	7
Acetylene cylinder	Yes
Capacity of Acetylene Cylinder (in Cu-m)if provided otherwise put NA	6
Size of tip for Blow pipes in mm	6
Fuel gas	Acetylene
Cutting capacity (in millimeters)	9
Cutting speed range (in mm per min)	0-200
Max. Cutting width (in mm)	0-500
Range of Pressure Adjustment of Oxygen Regulator (Kgf/Cm2)	6
Range of Pressure Adjustment of Acetylene Regulator (in Kgf/Cm2)	6
Hose pipe for Acetylene and Oxygen	Yes
Electric supply of 230 V \pm 10% AC, single phase, 50 Hz \pm 3% through a 3- core wire	Yes
Maximum Current (in amp)	3
Warranty (in years)	1
Class of Insulation	H
Hose Internal Diameter for Acetylene (in mm)	6
Hose outside Diameter for Acetylene (in mm)	12
Length of Hose for Acetylene (in meters)	5
Color of Hose Pipe for Acetylene	Red
Hose Internal Diameter for Oxygen	6
Hose outside Diameter for Oxygen	12
Length of Hose for oxygen (in meters)	5
Color of Hose Pipe for oxygen	Blue
Dimensions of Machine (L x W x H) (in mm x mm x mm)	200X150X200
Weight of Machine (in kg)	10
Horizontal Adjustment of Torch (in mm)	25
Vertical Adjustment of Torch (in mm)	25
Length of Power Cable with End Connectors (in meters)	10
Cylinder Content and Outlet Pressure gauge to be provided	Yes
Non Return valve to be provided	Yes
Trolley for cylinders Movement to be provided	Yes
Adjustable spanner 10 inch to be provided	Yes
Spindle key- 1no to be provided	Yes

Spark lighter- 1 no to be provided	Yes
Emergency on/off switch to be provided	Yes

INTRODUCTION

Thank you very much for purchasing this product. Read this instruction manual thoroughly to ensure correct, safe and effective use of the machine. Read the manual first to understand how to operate and maintain the machine.

SAFETY PRECAUTIONS

- Do not use the machine carelessly without following the instructions in the manual.
- Use the machine only after you have completely understood the contents of the manual.
- If an explanation in the manual is difficult to understand, contact our company or sales service office.
- Keep the manual to hand at all times and read it as many times as is necessary for a complete understanding.
- If the manual becomes lost or damaged, place an order with our company or sales service office for a new one.
- When transferring the machine to a new owner, be sure to hand over this instruction manual as well.

Safety information

Operation, inspection, and maintenance that disregard the basic safety rules cause many accidents. Carefully read, understand, and master the safety measures and precautions described in this instruction manual and on the machine before operating, inspecting, and maintaining the machine. The safety messages are classified as indicated on the machine safety labels:

Machine safety

The machine casing is mainly made of aluminum alloy to reduce weight. For this reason, be careful not to drop a heavy item on the machine, or not drop the machine when carrying it, since the alloy is not designed to withstand such impact.

When fixing a tip to the torch, tighten the nut with the two wrenches attached. In addition, avoid damaging the taper part of the tip since this may cause backfire.

Never disassemble the machine other than during maintenance and inspection. Otherwise, malfunction will result.

Operation and handling safety precautions

1. Read this instruction manual before operating the machine.
2. Mount and center the machine correctly and confirm correct motion before operation.
3. Prior to operating the machine, check the safety of the surroundings to avoid accidents.
4. Never move the machine while the preheat flame is on.
5. Take great care of spatters and dross when operating the machine at a high position. They may injure people below.
6. Do not hit any object against the surface of the wheel to be in touch with pipes or drop the wheel so as not to scratch the surface; otherwise knocking will result.
7. Weak chain tension will make the machine slip. Give an appropriate tension to the chain.
8. Be careful not to get your hand caught between the upper plate and slide bracket.
9. When stretching the chain, be careful not to get your hand caught in the wing bolt.
10. Do not insert your hand into rotary sections (sprocket and wheel).
11. Be careful not to drop the machine when changing the chain.
12. Do not use deformed or rusted chains; otherwise the chain may be disengaged.
13. Do not mistake the top and bottom sides of the chain.
14. The number of chains must match the pipes.

15. Do not place the machine on pipes when it is unused.

Gas cutting safety precautions

Strictly observe the safety rules and precautions to ensure the safety of gas cutting operations. Operators and supervisors **MUST** keep safety in mind.

Pressure regulator safety precautions

1. Before starting operation, check that all pressure regulators are operating correctly.
2. Ask a skilled repair engineer to perform maintenance and inspection service.
3. Do not use pressure regulators from which gas is leaking, nor malfunctioning pressure regulators.
4. Do not use pressure regulators smeared with oil or grease.