

TESUCO[®]

TECHNICAL SUPPLIES COMPANY

FLAME  **PRO**  **RANGE**

AIR ACETYLENE KIT

**OPERATING
INSTRUCTIONS**

QUALITY GAS EQUIPMENT

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- Flame Pro™ air acetylene quick connect handle (GBT A)
- Flame Pro™ air acetylene auto ignite attachment (GBT AIA)
- Acetylene regulator (RC1SAC1.5)
- Acetylene hose (GWSWA4)
- Combination spanner (GWS)
- Tesuco® Tool Bag (GBT1)

SAFETY

Read this manual thoroughly and carefully before using this product.

Retain this manual for future reference.

Ensure all connections are secure by tightening with a spanner and do not use if any leaks are found.

Always use in a well-ventilated area.

If the flame is suddenly extinguished during use, immediately close the valve on the handle and check the cause.

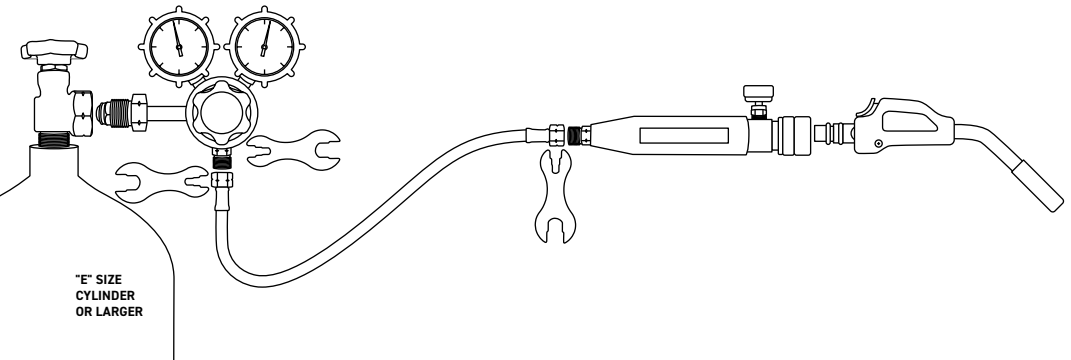
Note: Only trained operators may use this equipment.

Only use this equipment on "E" size cylinder or larger with withdrawal rate of above 0.27m³/hr.

INSTALLATION & OPERATION

1. Connect the regulator to the acetylene cylinder using the correct size spanner.
2. Connect the acetylene hose to the outlet of the regulator and the inlet of the torch handle, using spanners of the correct size.
3. Ensuring the adjustment knob on the regulator is wound fully out, open the cylinder valve slowly.
4. Adjust the gas pressure on the regulator according to the specifications of the welding tip (100 kPa).
5. Ensure there are no leaks prior to lighting.
Holding the welding torch in one hand, open the gas valve slightly (about 3/4 turn), and then press the auto ignition lighter with the other hand to ignite the flame.
6. Slowly increase the gas until the correct flame is achieved.
7. To stop use, close the valve on the torch handle until the flame goes out.
8. After use, close the gas cylinder valve, and then release the gas from the system safely by opening the torch handle valve. Once empty of gas, detach the regulator from the cylinder and dis-assemble the hose from the regulator and torch handle.

INSTALLATION & OPERATION



MAINTENANCE

With pressure in the system and with the torch valve fully closed, immerse the nozzle in water. No continuous bubbles should be evident. If bubbles are evident the torch handle valve needs to be repaired or replaced.

When the torch contains gas, use "Gas Control" leak detection spray to make sure all the threads and inlet connection points are not leaking.

Frequently check if the nozzle is damaged or obstructed. If it is blocked, the cone surface is deformed or the O-ring is damaged, the nozzle must be replaced.

Replacement Nozzle Part Number: GBTAN12

SPECIFICATIONS

Standards		Flame Pro™ Auto Ignite Attachment	GBTAlA
Regulator	AS 4267-1995 R2016	Flow rate	0.27 m ³ /hr
Hose	AS/NZS 1335:2020	Operating pressure	100 kPa (15 PSI, 1 BAR)
Handle and tip	ISO 9012:2008	Inlet connection	Quick connect male bayonet
Regulator	RC1SAC1.5	Hose	
Flow rate	28.5 m ³ /hr	Length	4 m
Inlet configuration	Side	Inlet connection	5/8"-18 UNF LH
Max. inlet pressure	3,000 kPa	Outlet connection	5/8"-18 UNF LH
Max. outlet pressure	150 kPa	Rating	1,500 kPa
Inlet connection	Type 20	Size	5 mm ID
Outlet connection	5/8"-18 UNF LH Male		
Flame Pro™ Handle	GBTAl		
Max. inlet pressure	150 kPa		
Inlet connection	5/8"-18 UNF LH Male		
Outlet connection	Quick connect female		

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The information contained herein is provided to assist the operator in the safe use of the Flame Pro™ Air Acetylene Kit . However, the ultimate responsibility for the safe use of this lies solely with the operator, including any requirements of associated Australian Standards.

