



Propylene Torch

BEST PRACTICES

Tool Uses

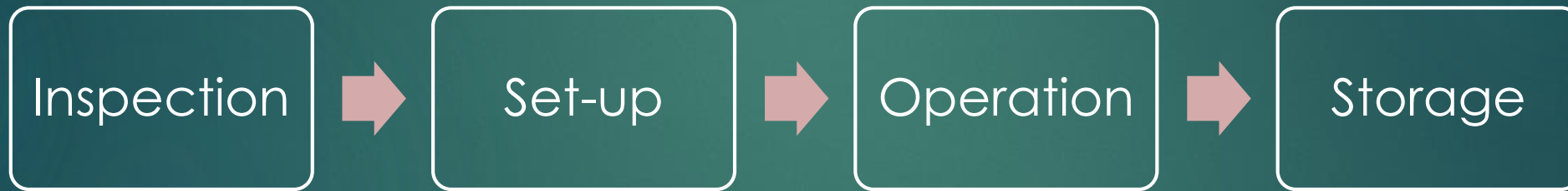
- ▶ NCU Primarily uses the propylene torch for cutting carbon steel



- ▶ Cross members
- ▶ Rusted nuts/bolts
- ▶ Shock mount brackets
- ▶ Landing Gear/Legs
- ▶ Rear Bumper



Best Practice - Tooling



Inspect Before Use

- ▶ Preparation
 - ▶ No unnecessary flammable materials exposed
 - ▶ No grease or oil near cutting area
 - ▶ Place tank on level surface in upright position
- ▶ Safety
 - ▶ Tinted goggles, face mask
 - ▶ Gloves, long sleeves, Pants, and boots should be worn
 - ▶ Have a fire extinguisher readily available

Set-Up

- ▶ Assembly
 - ▶ Connect propane and oxygen hoses to tanks
 - ▶ Connect Torch to propane and oxygen hoses
 - ▶ Screw cleaned tip into torch
 - ▶ Check hoses and connections for leaks
 - ▶ Check tip for anything blocking the hole

Lighting the Torch

- ▶ Open propane valve on torch handle
- ▶ Use a Striker only to Ignite the gas
- ▶ Open oxygen valve on torch handle
- ▶ Adjust flame to neutral or approximately 40 psi

Operation

- ▶ Hold torch tip 1/8" to 3/16" from metal
- ▶ Wait until metal begins to puddle or melt
- ▶ Depress oxygen cutting lever
- ▶ Wait for oxygen stream to push molten metal through, creating "kerf"
- ▶ Watch puddle and listen to adjust cut speed

Essential for a good Cut

- ▶ Clean tips
- ▶ Propylene and oxygen levels set to working pressures
- ▶ Clean metal
- ▶ Neutral flame

Watch Out For...

- ▶ Things to watch out for
 - ▶ Bad Connections
 - ▶ Leaking hoses
 - ▶ Smell of gas
 - ▶ Flammable materials around the work area
- ▶ Improper Use
 - ▶ Lighting torch with anything other than a striker
 - ▶ Using dirty equipment
 - ▶ Bringing flame close to tank, hose, or anything flammable

Instructional Video

- ▶ Propylene Torch Video



- ▶ <https://www.youtube.com/watch?v=CfvYfzE0P9I>

Tool Storage

- ▶ Shutting Down
 - ▶ Turn off gas
 - ▶ Turn off Oxygen
 - ▶ Bleed out both hoses
 - ▶ Wrap up hoses
 - ▶ Wait for tip to cool before storing
 - ▶ Store gauges, hoses, and tanks in a safe clean place
- ▶ Transportation
 - ▶ Secure tanks with caps for transportation

Training

Training Quiz



- ▶ <https://www.flexiquiz.com/SC/N/d53f3e73-0446-4379-be6a-15a9c7d29efe>