

JOB PROCEDURES

OXY-ACETYLENE CUTTING TORCH

**This information does not take precedence over OH&S. All employees should be familiar with the Saskatchewan Employment Act and the OH&S Regulations.*

APPROVED BY:	REVIEWED/REVISED DATE:
MATERIAL & EQUIPMENT REQUIRED	PERSONAL PROTECTIVE EQUIPMENT
	Hand/Eye/Foot/Respiratory Protection
JOB STEPS	
1. You must be trained by a competent and experienced individual before using this equipment on your own.	
2. Zero out the regulators by turning the knob counter-clockwise until it turns freely.	
3. Uncap the cylinders and quickly open and close the valve – make sure that the stream is not directed towards you, others, or an open flame or spark.	
4. Mount the regulators on the cylinders along with the hoses and torch head. Make sure that the flashback arrestors are installed on the torch and at the regulator. Red hose is for the acetylene and green is for oxygen.	
5. Open the oxygen valve on the cylinder all the way. Open the acetylene valve on the cylinder no more than ½ turn. When opening any cylinder valve, always stand so that the valve is between you and the regulator. <i>Do not stand in front or back of the regulator when turning the cylinder.</i>	
6. Turn the regulator clockwise and set the oxygen at 25-40 psi. Set the acetylene at 4-8 psi.	
7. Check for leaks by turning off the cylinders and watching the gauge for 5 minutes.	
8. Open the acetylene valve on the torch ¼ turn and light with a striker.	
9. Turn up the acetylene valve on the torch until the black smoke diminishes.	
10. Turn on oxygen at the torch; increase until the flame has a short tip and no feathers. The flame should not lift off or go out when the lever is pressed.	
11. Check the area for combustibles before cutting with the torch.	
12. To shut off the torch, turn off the oxygen first, then the acetylene.	
13. When you are done with the torch, shut off the valves on the cylinders and take the regulators off and store in a safe, secure location.	