oxygen valve, turn in pressure-adjusting screw on oxygen regulator to desired pressure, then close torch oxygen valve Open acetylene cylinder valve (1½ turns only), and with torch acetylene valve *closed,* turn in pressure-adjusting screw on acetylene regulator to desired pressure

10 Purge each line individually Open oxygen torch valve and release oxygen to the atmosphere for a few seconds before closing the valve, then open acetylene torch valve and release acetylene to the atmosphere for a few seconds and close the valve

11 Open torch acetylene valve, light flame, and readjust regulator Then close torch acetylene valve (Acetylene pressure should first be adjusted with torch valve closed to prevent release of acetylene to air)

12 Open torch valves and light torch according to procedure described in instructions provided with the equipment The procedure for operating one torch is not necessarily best or even satisfactory for another

Hose and hose connections

The oxygen and acetylene hoses should be of different colors or otherwise identified and distinguished from each other Red is the generally recognized color for fuel gas hose and green for oxygen hose (Fig 31-3)

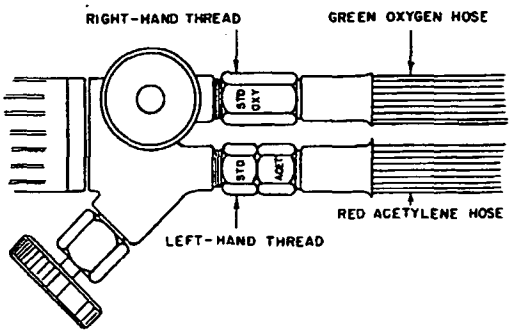

FIG 31-3 —When attaching hoses to a welding or cutting torch, use the red hose for acetylene and the green hose for oxygen, then test connections for leaks

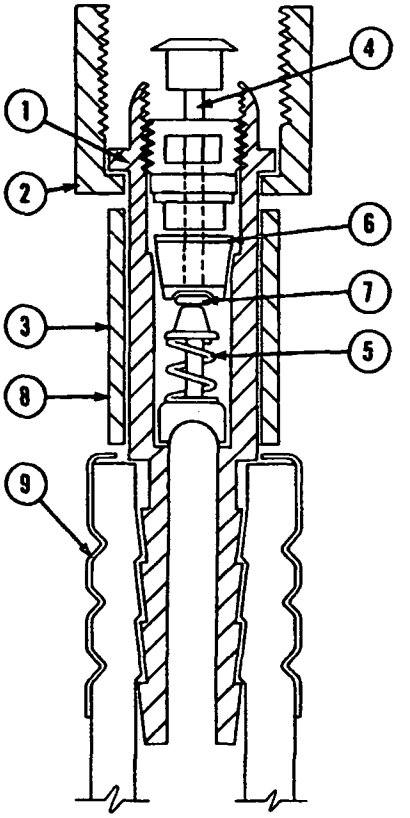

FIG 31-4 —This type connector can provide positive gas shutoff and eliminate need for purging hose when torches are changed Numbers indicate 1—valve body, 2—connecting nut, 3—retainer sleeve, 4—valve stem, 5—spring, 6—seat, 7—valve body seat, 8—sleeve, and 9—hose collar Overall length is 2⅝ in

Courtesy Anderson Equipment Co

The hose connections are usually marked STD-OXY for oxygen and STD-ACET for acetylene The acetylene union nut has a groove cut around the center to indicate left-hand threads

Connections for joining the hose to the hose nipple on the torches and regulators may be either the ferrule or clamp type Gaskets should not be used on these connections Special torch connectors with built-in shutoff valves are available (Fig 31-4 shows one type)

Following are suggestions for safe use of