

This guideline provides North Zone procedures for the use of the North Zone cutting torch. This guideline has been developed so that personnel can perform cutting torch operations efficiently and safely. All cutting torch operations will follow this procedure.

PERSONNEL PROTECTION:

Full safety clothing shall be worn at all times during torch operation.

- In addition to safety clothing, approved safety goggles have been provided with the cutting torch and must be worn.
- Keep all protective clothing free of hazardous chemicals.

SAFETY PROCEDURES:

- Assure cylinders are secured and held upright by chains mounted on cutting torch cart and the apparatus.
- Maintain adequate ventilation in the area of operation to prevent buildup of toxic fumes.
- Have fire extinguisher or charged hoseline staffed during all cutting operations.
- Do not use hazardous chemicals on or around cutting torch.

OPERATING PROCEDURES:

- Examine hoses before attaching them to cutting torch handle or regulators.
- Open acetylene cylinder valve $\frac{3}{4}$ of a turn, but no more than $1\frac{1}{2}$ turns.
- Assure pure oxygen and acetylene gas passes separately before lighting torch.
- If the cutting unit requires a cylinder wrench, keep it affixed on the valve so the cylinder may be turned off quickly.
- All gases except acetylene: Open the cylinder valve completely to seal the back seal packing.
- Use recommended pressure setting. When working with acetylene never exceed 15 psig.
- Keep hoses clear of any falling metal, slag, or sparks.
- Purge system after each use. Bleed system by emptying both hoses independently.

MAINTENANCE:

- Always keep regulator free of oil, grease, and like substances.
- Completely replace welding hose if found to contain any cracks, multiple splices, abrasions, or severe wear.
- Be sure that all connections are tight. Use a soapy water solution applied to fittings to check for air bubbles.
- Inspect tips after each use and clean with proper size tip cleaner.