INSTRUCTIONS for

PREST-O-LITE®
ACETYLENE REGULATORS

<table>
<thead>
<tr>
<th>Regulator</th>
<th>Connections, CGA No.</th>
<th>Max. Delivery Press.</th>
<th>Gauges Tank Contents</th>
<th>Delivery</th>
</tr>
</thead>
<tbody>
<tr>
<td>Model</td>
<td>Part No.</td>
<td>Inlet</td>
<td>Outlet</td>
<td></td>
</tr>
<tr>
<td>R-411B</td>
<td>04X36</td>
<td>520 (*B&quot; Tank)</td>
<td>021 (3/8&quot;-24LH)</td>
<td>15psi</td>
</tr>
<tr>
<td>R-411MC</td>
<td>04X37</td>
<td>200 (*MC&quot; Tank)</td>
<td>021 (3/8&quot;-24LH)</td>
<td>15psi</td>
</tr>
</tbody>
</table>

*Marked with fractional contents of cylinder (1/4, 1/2, 3/4, Full)

---

**CAUTION**

These INSTRUCTIONS are for experienced operators. If you are not fully familiar with the principles of operation and safe practices for air-fuel gas equipment, we urge you to read our booklet “Precautions and Safe Practices for Welding, Cutting and Heating,” Form 2035. Do NOT permit untrained persons to operate this equipment. Do NOT attempt to operate this equipment until you have read and fully understand these instructions. If you do not fully understand these instructions, contact your supplier for further information.

The regulators covered by these instructions are listed by Underwriter’s Laboratories only when using parts manufactured by ESAB Welding & Cutting Products to the specifications on file with Underwriter’s Laboratories, Inc., and when they are used in the gas service for which they are designed and listed. The use of other parts voids the manufacturer’s warranty.

---

**CONNECTING:**

1. Before attaching the regulator to a tank (cylinder) open the tank valve slightly, for an instant, then close it. This will blow out any dust or dirt which may be in the valve outlet. **Never open the tank valve near hot work, a spark-creating device, or any other possible source of ignition.**
2. Attach the regulator to the tank valve. Tighten the connection nut with a wrench.
3. Attach hose with correct fittings to the regulator outlet and to the torch or other appliance. (All fuel gas hose connection nuts have a left-hand threads.) Tighten the connection nuts with a wrench.
4. Make sure the shutoff valve on your torch or other appliance is closed. Back out pressure-adjusting screw and then open the tank valve about one-quarter turn. If you are using a small acetylene tank, always use a tank key (P/N 505100) to open the valve. DO NOT USE PLIERS. When opening the tank valve, always stand to one side of the regulator, not in front of the gauge face (or faces).
5. Turn the pressure-adjusting screw on the regulator to the right (clockwise) until the delivery-pressure gauge (if the regulator has one) shows 10 psi (lb. per sq. in.) pressure. If the regulator does not have a delivery gauge, pressure setting is read from the letters embossed on two flat surfaces on the screw. The regulator valve opens when the point of the diamond around letter 'A' is flush with the front surface of the cap. Letter 'B' setting will provide a pressure of 5 psi, letter 'C' setting a delivery pressure of 10 psi. To go from one letter to the next pressures can be determined with considerable accuracy; for example, one full turn past 'B' will provide 7-1/2 psi.

---

Be sure this information reaches the operator. You can get extra copies through your supplier.
TESTING FOR LEAKS:

1. Using thick solution of soap and water, applied with a small brush, test for leaks at the tank valve, regulator connections, and torch or appliance connection. If you find a leak, correct it before continuing. (A leak around the stem of a small acetylene tank valve can often be corrected by tightening the valve packing nut with a wrench. If this will not stop the leak, remove the tank, tag it to indicate valve stem leakage, and place it outdoors in a safe spot until you can return it to your supplier.

SETTING WORKING PRESSURE:

1. Since the 10 psi pressure specified for leak-testing may be more than desired for operating your torch, after leak-testing you should reset the regulator to deliver gas at the desired working pressure. To do this, merely reset the pressure-adjusting screw to the desired setting, as indicated by the letters on the side of the screw. (See 5. above.)

STOPPING WORK:

1. Whenever you stop work, and are going to leave the outfit unattended, always close the tank valve. It is not necessary to disturb the setting of the regulator-pressure adjusting screw.

2. When the regulator is removed from the tank, and is to be idle for some time, leave the adjusting screw at the 'A' setting, or a quarter-turn beyond, to keep the regulator valve seat off the seating surface within the regulator.

REPAIRING:

Regulators in need of repair should be returned to your PREST-O-LITE equipment supplier.

If you have your own properly-equipped and staffed repair facility, repair parts information for this regulator is available on request. Request Form 12-384 which covers all regulators listed on this sheet.

PRECAUTIONS AND SAFE PRACTICES

A. DO NOT let acetylene or LP-Gas escape near any possible source of ignition. Accumulations of either in certain proportions may explode if ignited.

B. NEVER store acetylene or LP-Gas tanks (cylinders) in a closed or confined space, such as a closet, tool box, or automobile trunk.

C. NEVER solder a container that contains or has contained flammable liquids or vapors (including gasoline, benzene, solvents, and other similar materials) unless the container has been thoroughly purged of all traces of flammable material and vapors.

D. Before starting work always test for leaks around all joints with a soapy water solution.

E. NEVER use a flame to test for leaks of flammable gases.

F. NEVER use a tank with a leaking valve.

G. DO NOT attempt any repairs to an acetylene or LP-Gas tank, except to tighten the packing-gland nut on the valve.

H. DO NOT abuse or drop tanks or handle them roughly.

I. NEVER use a tank as a roller or support.

J. NEVER use a hammer, wrench, or pliers on a tank valve equipped with a handwheel. On small acetylene tanks, always use PREST-O-LITE valve wrench (box type, P/N 505L00).

K. DO NOT open tank valve more than 1-1/2 turns (preferable no more than 3/4 of a turn).

L. Leave valve wrench on tank valve stem so that tank valve can be closed quickly in case of emergency.

M. NEVER allow full tank pressure to enter the hose. Always use a regulator when there is a needle valve on the torch handle.

N. NEVER lay a torch down unless the gas flow has been shut off. If you want to maintain a pilot flame when you stop work for short intervals, provide a rack or stand for the torch, away from combustible materials. Do not leave is unattended unless you are sure there is no danger of it being disturbed by unauthorized persons.

O. Examine your hose for leaks frequently. Dipping it in a bucket of clean water, with the pressure in the hose, is the quickest and easiest way.

P. DO NOT use hose that is worn, or any equipment that is in need of repairs.

Q. DO NOT start fires. Be very careful with fusible metal safety devices. NEVER store tanks near radiators, furnaces, or other heat sources.

PREST-O-LITE is a registered trademark of ESAB Welding & Cutting Products.