I. OPERATING INSTRUCTIONS

The instructions contained in this booklet are for experienced operators. They assume that the operator knows the general principles of operation and safe practices to be followed in operating oxy-acetylene equipment. If you are not sure that you understand these principles fully, we urge you to read LINDE'S booklet "Precautions and Safe Practices," in addition to these instructions. You can get a copy of "Precautions and Safe Practices" (F-2035) without charge from any LINDE office. (The same basic information on operating principles and safe practices is in Chapters 5, 6, and 7 of "The Oxy-Acetylene Handbook." This handbook of more than 500 pages, contains many valuable chapters on welding, cutting, and other uses of oxy-acetylene equipment. It may be purchased from any LINDE office or from any LINDE distributor.)

A. To Connect
1. Open (crack) the cylinder valve slightly, for only an instant, to blow dust or dirt from the valve outlet. (Never crack an acetylene cylinder valve near welding or cutting work, or near sparks, flames, or any possible source of ignition.)
2. Attach the regulator to the cylinder valve.
3. Make sure the regulator pressure-adjusting screw is released by turning it to the left (counter-clockwise) until it spins freely.
4. Open the cylinder valve slowly a fraction of a turn, then open it 1-1/2 turns — no more. Do not stand directly in front of the gauges when opening the cylinder valve.
5. Attach the acetylene hose to the regulator outlet and to the blowpipe. Make sure that all connections are gas-tight.

B. To Adjust Pressure
The blowpipe acetylene valve should be open whenever you are adjusting the delivery-pressure to a blowpipe. If it is not open you cannot get a true working-pressure reading on the regulator delivery-pressure gauge. To increase pressure turn the pressure-adjusting screw to the right (clockwise). To decrease pressure turn the pressure-adjusting screw to the left (counter-clockwise). For the initial adjustment, before lighting the blowpipe follow these steps:
1. Open the blowpipe acetylene valve.
2. Turn the pressure-adjusting screw to the right (clockwise) until the delivery-pressure gauge shows the desired pressure.
3. Close the blowpipe acetylene valve.

C. To Release Pressure
If work is to be stopped for a half-hour or more, release pressure from the regulator as follows:
1. Close the cylinder valve.
2. Open the acetylene valve.
3. Release the pressure-adjusting screw.
4. Close the acetylene valve.
Follow the same procedure before removing the regulator from a cylinder.

D. Operating Hints
1. If a regulator is to be out of use for a few weeks or more, turn in the pressure-adjusting screw enough to move the valve stem off the metal seat.
2. Unless cylinders are mounted on a suitable truck, always remove regulators before moving cylinders.
3. Remember that this regulator is a precision instrument designed to control acetylene at pressures up to 250 lb. per sq. in. If used in accordance with these instructions and otherwise given reasonably good care, it should give satisfactory service for many years.

II. MAINTENANCE INSTRUCTIONS

For all repairs and replacements other than those specifically described below, send the regulator to a Linde Air Products Company apparatus repair station.

The specific repair information shown on the parts drawing is provided for experienced and qualified persons engaged in the repair of oxy-acetylene apparatus. Improperly repaired apparatus may be hazardous. Linde Air Products Company offers economical repair services through its district offices.

A. To Disassemble the Regulator
1. Hold the regulator upright in a vise by means of the flat surfaces on the under side of the body.
2. Turn the pressure-adjusting screw out (counterclockwise) until it spins freely.
3. Unscrew the regulator cap and lift it off. Lift off the spring and spring washer.
4. Lift off the diaphragm assembly.
5. Using a socket wrench, unscrew the valve screw and lift out the parts located within it. Lift out the valve closing spring.
6. Hold the diaphragm assembly in a vise by means of the clamping screw and unscrew the 5/16 in. hex nut. Lift off all parts.

B. To Inspect the Regulator Parts
1. Using a clean cloth, wipe all the parts clean, then examine them for defects or excessive wear. Here is what you look for:
   (a) Diaphragm: Should be free from cracks and signs of excessive wear. (It should compare favorably with a new one.)
   (b) Valve stem: Should be clean, straight and unmarred, examine especially the plastic seating surface which closes against the valve seat screw.
   (c) Valve screw: Examine especially the seating corner against which the valve stem seats. It should be clean and unmarred.
   (d) Valve closing spring: Should not have acquired a permanent set. It should be full length (compare it with a new one).

C. To Reassemble the Regulator
1. Reassemble the diaphragm and associated parts to the diaphragm attaching screw to form a subassembly. To do this:
   (a) Hold the diaphragm screw in a vise.
   (b) Wash the diaphragm in clear water and dry it with a clean cloth.
   (c) Assemble the parts to the screw in this order: diaphragm, plate, guide and hex nut. Tighten the hex nut securely — but don’t use excessive force.
   (d) Lay the sub-assembly aside.
2. Hold the regulator upright in a vise.
3. Place the valve closing spring (large end down) in the regulator.
4. Place the valve stem in the valve sleeve and set the valve sleeve on the valve closing spring so that the 3/32-in. diameter of the sleeve is located inside the top of the spring.
5. Place the valve screw over the parts so that the valve stem protrudes through the hole in the top of the screw.
6. Press down and screw the valve screw in a few threads. (To start the valve screw into the body, it is necessary to depress the valve spring until the valve screw “catches”)
7. Screw the valve screw home and tighten it securely with a socket wrench.

(Continued on page 4.)

NEVER TEST AN ACETYLENE REGULATOR NEAR WELDING OR CUTTING WORK, OR NEAR SPARKS, FLAMES, OR ANY POSSIBLE SOURCE OF IGNITION.

The terms "Oxweld" and "Purox" are registered trade-marks of Union Carbide and Carbon Corporation.
## Replacement Parts List

**FOR**

"PREST-O-WELD" ACETYLENE REGULATOR

**TYPE R-127 PART NO. 04X39**

<table>
<thead>
<tr>
<th>PART NO.</th>
<th>DESCRIPTION</th>
<th>PART NO.</th>
<th>DESCRIPTION</th>
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</thead>
<tbody>
<tr>
<td>1369</td>
<td>Inlet Nut</td>
<td>37261</td>
<td>Valve Screw</td>
</tr>
<tr>
<td>3390</td>
<td>Outlet Connection</td>
<td>48239</td>
<td>Valve Stem Sleeve</td>
</tr>
<tr>
<td>3835-6</td>
<td>30-lb. Acetylene Gauge</td>
<td>82244</td>
<td>Diaphragm Ring</td>
</tr>
<tr>
<td>▲ 3836-6</td>
<td>400-lb. Acetylene Gauge</td>
<td>82245</td>
<td>Pressure-Adjusting Spring Washer</td>
</tr>
<tr>
<td>6868</td>
<td>Beveled Gauge Crystal</td>
<td>92202</td>
<td>Cap Bushing</td>
</tr>
<tr>
<td>32Y31</td>
<td>Valve Stem</td>
<td></td>
<td></td>
</tr>
<tr>
<td>35Y13</td>
<td>Pressure-Adjusting Screw</td>
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<tr>
<td>03291</td>
<td>Inlet Nipple</td>
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<td></td>
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<tr>
<td>29256</td>
<td>Valve Closing Spring</td>
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<td></td>
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<tr>
<td>29257</td>
<td>Pressure-Adjusting Spring</td>
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<tr>
<td>30280</td>
<td>Diaphragm</td>
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</tr>
<tr>
<td>30282</td>
<td>Diaphragm Plate</td>
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<td>30283</td>
<td>Diaphragm Plate Spring Guide</td>
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<tr>
<td>31278</td>
<td>Cap</td>
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<td></td>
</tr>
<tr>
<td>35283</td>
<td>Diaphragm Screw</td>
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</tbody>
</table>

▲ On the R-127(L) (Part No. 04X78) the 400 lb. gauge is replaced by a 1/4-in. pipe plug (Part No. 6354).

**HARDWARE**

M-R1-1: Cap Bushing Retaining Ring, National Lock Washer Co.'s No. XRC-330

N-H-18: 5/16-in. 24 Hex Steel Nut

**ACCESSORIES**

05Z15: Shatterproof Gauge Crystal

78Z52: OXWELD Anti-Friction Compound (for Pressure-Adjusting Screw Threads)
(Continued from page 2.)

(d) Close the cylinder valve and remove the regulator from the cylinder.

9. Place the diaphragm sub-assembly in position.
10. Place the diaphragm ring in position.
11. Assemble the spring, spring washer, and cap. Tighten the cap securely with a wrench.

D. To Test for Leakage
1. Connect the regulator to a full cylinder of acetylene.
2. Fully release the regulator pressure-adjusting screw.
3. Slowly open the cylinder valve.
4. Place a film of soapy water over the regulator outlet. If bubbles form and burst, it indicates that
   the regulator valve stem and valve screw is not forming a perfect seat, and that the regulator
   should again be disassembled, and one or both parts replaced.
5. Blank off the regulator outlet. This can be done by connecting the blowpipe to the regulator and
   closing the blowpipe acetylene valve.
6. Set the regulator pressure at 15 lb. per sq. in. and test for leaks around the regulator cap
   threads and at the vent holes in the cap.

NOTE
If you have followed these instructions carefully and the regulator still does not function properly, send it to the jobber from whom the regulator was purchased or to the nearest apparatus
repair station of Linde Air Products Company.

LINDE AIR PRODUCTS COMPANY
A Division of Union Carbide and Carbon Corporation

General Office: New York

UCC Offices in Principal Cities

In Canada: DOMINION OXYGEN COMPANY, LIMITED, Toronto