INSTRUCTIONS FOR USE OF

FLASH CIRCLE-CUTTING ATTACHMENT

INTRODUCTION
The Flash Circle-Cutting Attachment is a handy and simple accessory for cutting clean, accurate circles with your cutting blowpipe or cutting attachment. As shown in Fig. 1, the attachment consists of a ball-bearing rotary head and radius bar with a sliding pivot block and center point, and a follower wheel.

The Flash Circle-Cutting Attachment will cut circles from 2-1/2 inches to 17 inches in diameter. It can be used equally well in horizontal or vertical positions. While it is primarily designed for circle-cutting it can also be used for straight-line cutting, and as a guide for hand shape-cutting.

ASSEMBLY
To assemble the Flash Circle-Cutting Attachment to your cutting blowpipe or cutting attachment, merely screw it into the cutting head in the same manner as you would a nozzle nut.

CIRCLE CUTTING (Fig. 2)
1. Locate the center of the circle to cut and mark it with a deep punch mark. A punch with a 60-degree angle point is recommended for this purpose.
2. Loosen the screws which bear against the follower-wheel bar and the center point. Adjust the cutting nozzle for proper distance above the workpiece and retighten the screws.
3. Place the follower wheel on the workpiece so that the cutting nozzle is directly over the intended lines of cut.

Loosen the screw which bears against the radius bar and slide the pivot back along the bar until the center point rests in the punch mark that you have made in the workpiece. Retighten the screw.

STRAIGHT-LINE CUTTING
To cut straight lines, remove the sliding pivot block and center point and hold the radius bar with the rotary head against a straight edge.

SHAPE-CUTTING
For shape-cutting, remove the sliding pivot block and center point and guide the torch by manipulating the radius bar.
FOLLOWER-WHEEL ADAPTOR (Fig. 3)

An adaptor (Part No. 84W86) is available for mounting the follower wheel on the radius bar between the nozzle and the center point. This results in a saving of material by permitting the cut to be made to the very edge of the plate.

SPECIAL EXTENSION BAR

A special 11-in. extension bar and adaptor (Part No. 163Z23) is available if it is desired to cut circles larger than 17 inches in diameter. The extension bar has an adaptor attached at one end which clamps to the radius bar of the Flash Circle-Cutting Attachment. The extension bar increases the diameter of circles that can be cut to 38 inches.

Fig. 3 - Circle-Cutting with Follower-Wheel Adaptor