INSTRUCTIONS FOR USE OF

FLASH CIRCLE-CUTTING ATTACHMENT

Part No. 21X33 . . . For torches and cutting attachments which use OXWELD '1500' group cutting nozzles.
Part No. 21X31 . . . For torches and cutting attachments which use PUROX '4200' group cutting nozzles.

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 above, the attachment consists of a 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 less than 2 inches to 19 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.

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

CIRCLE CUTTING
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 against the center point. Hold the cutting nozzle at the proper distance above the workpiece and then retighten the screws.
3. Place the follower wheel on the workpiece so that the cutting nozzle is directly over the intended line of cut. (Note: You can locate the follower wheel either inside or outside the line 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.

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 19 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 40 inches.

MAGNETIC CENTER FIXER
This handy permanent magnet accessory (Part No. 639500) can be positioned directly over the center mark and will keep the pivot point of the attachment properly centered while the operator uses both hands to guide the torch. It is especially useful when cutting large circles with the radius bar extension.