

## Bending OXWELD 1510 Series Nozzles

For specific applications this nozzle may be bent at any angle up to 90°, and at any point from 1 to 5-1/2 inches from the flame end without the use of heat. The method described on this sheet is recommended as both easy and safe. Just follow these simple steps:

1. Select a metal block, preferably brass or copper, that can be held in a vise. Drill a hole in the block and tighten the block in a vise. (A pair of brass or copper vise jaw pads may be used instead of the block.)
2. Consult the chart on the reverse side of this sheet for the size of the cleaning drills required for the preheat and cutting holes of the nozzle you want to bend. At your local hardware outlet, obtain sufficient piano wire to form size inch lengths about .003 to .007 in. smaller than the decimal diameter of the cleaning drills for preheat and cutting holes. Lubricate these wires with Krytox® Compound (Part No. 7358-5064) and insert them about three inches into the holes in the nozzle.
3. Insert the front end of the nozzle to the desired depth in the prepared block. (Note: The nozzle must be inserted at least one inch into the block. Do not attempt a bend within one inch of the flame end of the nozzle.)
4. Bend the nozzle to the desired angle. Bends made near the flame end of the nozzle can be done by hand. For bends further back, a rawhide or wooden mallet may be used to tap the protruding end into the desired position. Strike the band which forms the largest diameter of the nozzle - **DO NOT STRIKE THE SEAT OR NOZZLE PILOT.**
5. Remove the wires from the nozzle, using pliers if necessary. Wash the nozzle in clean hot water and blow passages clear with a jet of air.



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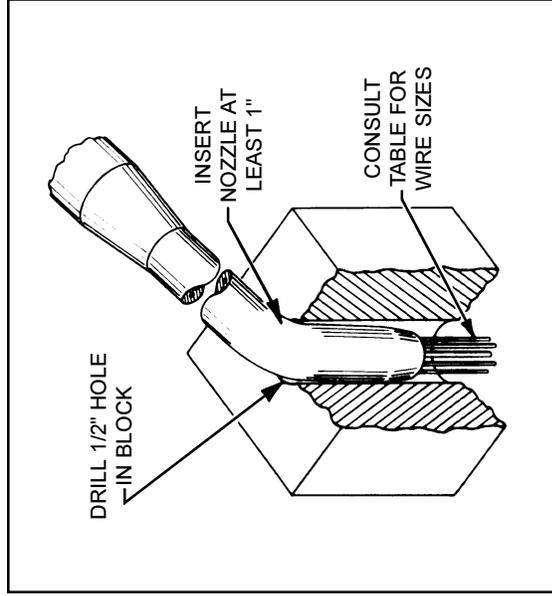
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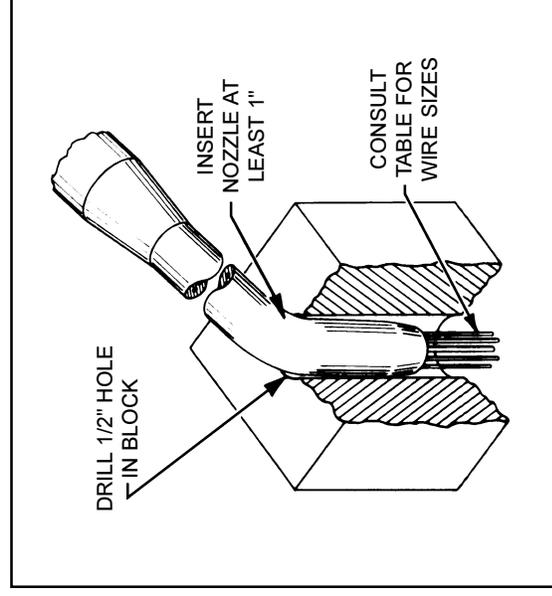
Nozzle Size	Part No.	Preheat Holes	Cleaning Drill Size	
			Preheat	Cutting
8	08Z40	6	61 ( .039)	46 ( .081)
10	08Z41	6	57 ( .043)	39 (.0995)
12	08Z42	6	56 (.0465)	31 ( .120)



**Recommended Procedure**

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