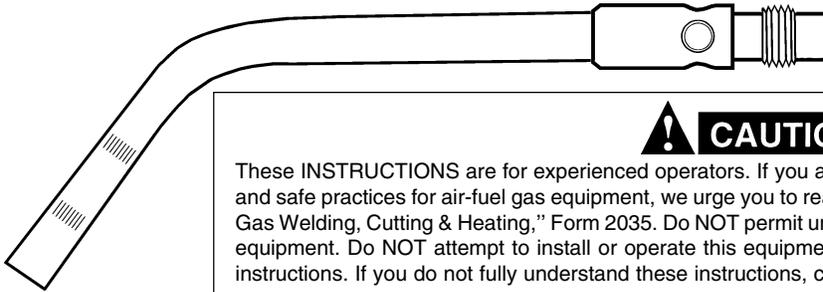


PREST-O-LITE® SWIRLJET AIR-ACETYLENE TIPS



For Use on PREST-O-LITE
Torch Handles

! 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 Gas Welding, Cutting & Heating," Form 2035. Do NOT permit untrained persons to install, operate, or maintain this equipment. Do NOT attempt to install or 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.

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|--------------------|----------------|
| SJ-0A SWIRLJET Tip | Part No. 22588 |
| SJ-1A SWIRLJET Tip | Part No. 22589 |
| SJ-2A SWIRLJET Tip | Part No. 22590 |
| SJ-3A SWIRLJET Tip | Part No. 21471 |
| SJ-4A SWIRLJET Tip | Part No. 21472 |
| SJ-5A SWIRLJET Tip | Part No. 21473 |

This SWIRLJET tip is designed for use with acetylene gas only. DO NOT ATTEMPT TO USE IT WITH PROPANE, or any other gas.

1. The acetylene should be supplied from a PREST-O-LITE small tank, or from any standard acetylene cylinder, through an adjustable regulator capable of maintaining a delivery pressure of at least 13 lb. sq. in. (psi), such as the PREST-O-LITE R-411 regulator. DO NOT use this tip with a regulator preset to deliver acetylene at any pressure less than 13 psi.
2. Following the instructions supplied with your regulator, connect the regulator to the acetylene tank. Connect the regulator to the PREST-O-LITE torch handle with an acetylene hose assembly. Then insert the tip in the handle and hand tighten the tip connection nut on the handle. DO NOT over tighten.
3. If your acetylene regulator is equipped with a delivery-pressure gauge, adjust the regulator to deliver 13 psi with gas flowing through the torch. If you are using a PREST-O-LITE R-411 regulator with no delivery-pressure gauge, turn in the regulator pressure adjusting screw about one-half turn past the "C" mark on the screw.
4. Always open the torch valve WIDE before you light the torch, and leave it WIDE OPEN except when you wish to shut off the torch. DO NOT adjust the flame with the torch valve.
5. Always use a friction lighter to light the flame. DO NOT USE A MATCH. Use of a match could seriously burn your hand. After lighting the torch, check to see if any part of the visible flame is touching the flame tube. If necessary, increase the acetylene delivery pressure at the regulator until you can see a slight gap between the visible flame and the flame tube. If there is not a slight gap, the tip will overheat rapidly and be damaged.

6. When you wish to stop work for a few minutes, shut off the torch by closing the torch valve. For longer shutdowns (always for an overnight shutdown) close the tank valve, and then open the torch valve for a few seconds to bleed all the gas pressure from the line. Finally, close the torch valve and back out the regulator pressure-adjusting screw.
7. SWIRLJET air-acetylene tips provide adequate heat for soft-soldered or silver-soldered joints in copper tubing systems as follows:

	Soft-Soldered	Silver-Soldered
SJ-0A	1/8 to 1/2-in.	1/8 to 1/4-in.
SJ-1A	1/4 to 1-in.	1/4 to 1/2-in.
SJ-2A	3/4 to 1-1/2-in.	1/4 to 3/4-in.
SJ-3A	3/8 to 2-in.	3/8 to 1-in.
SJ-4A	1-1/4 to 4-in.	7/8 to 2-in.
SJ-5A	4-in. and up	1-1/2 to 4-in.

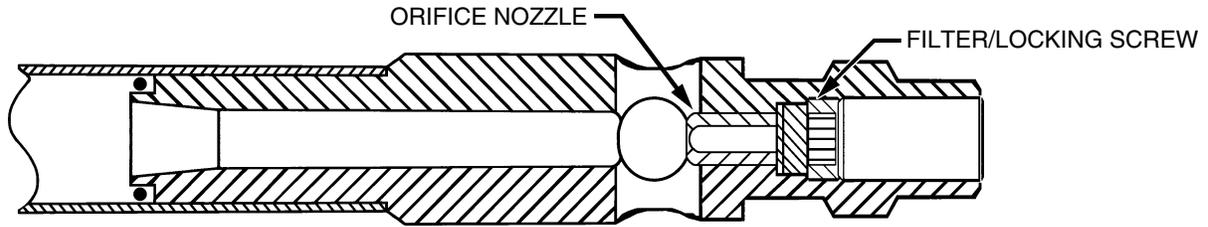
8. If the tip overheats, even though acetylene is being supplied at pressures of 13 psi or more, the orifice nozzle in the back end of the tip may be clogged. To clear, shut off the torch and remove the tip. Use a 1/8-in. Allen wrench (key) to remove the filter screw recessed in the connection end, and then tap the tip to dislodge the orifice nozzle. Blowing air through the nozzle from its front end will usually dislodge any dust which may have become lodged in the small orifice. If necessary, replace the orifice nozzle and filter screw with new parts. DO NOT attempt to clean orifice nozzle with a wire or other such object. The small orifice hole may become damaged and cause tip to operate improperly.

APPROXIMATE ACETYLENE CONSUMPTION (at 13 psi pressure to torch)

SJ-0A Tip	2 cu. ft./hr.
SJ-1A Tip	3.6 cu. ft./hr.
SJ-2A Tip	5.7 cu. ft./hr.
SJ-3A Tip	7 cu. ft./hr.
SJ-4A Tip	13 cu. ft./hr.
SJ-5A Tip	32 cu. ft./hr.

F-15-132-B

**Be sure this information reaches the operator.
You can get extra copies through your supplier.**



REPLACEMENT PARTS

998311	Filter Screw (SJ-3A & SJ-4A Tips)
998312	Locking Screw (SJ-5A Tip)
21478	Orifice Nozzle for SJ-0A SWIRLJET Air Acetylene Tip
21479	Orifice Nozzle for SJ-1A SWIRLJET Air Acetylene Tip
21480	Orifice Nozzle for SJ-2A SWIRLJET Air Acetylene Tip
21481	Orifice Nozzle for SJ-3A SWIRLJET Air Acetylene Tip
21482	Orifice Nozzle for SJ-4A SWIRLJET Air Acetylene Tip
21483	Orifice Nozzle for SJ-5A SWIRLJET Air Acetylene Tip

NOTE: Filter screw (998311) should not be used in SJ-5A Tip. Overheating may occur.

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