

PREST-O-LITE®**NO. 6 FG AIR-FUEL GAS TIP**

SERIES 2 /PART NO. 11X19

For industrial use with FG-2, Propane, or MAPP* 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 and Heating," Form 2035. Do NOT permit untrained persons to operate this equipment. Do NOT attempt to 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.

The No. 6FG Air-Fuel Gas Tip, P/N 11X19, produces a mild flame intended for heating heat-shrinkable material over solder joints or other applications where temperature required is approximately 200°F (93°C). The tip may be used with FG-2, propane, or MAPP fuel gas. Do not use with acetylene. An acetylene flame can quickly overheat and damage tip.

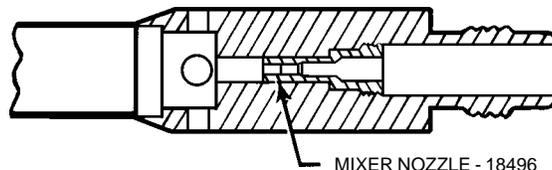
1. The fuel gas should be supplied from a tank through a suitable regulator, such as the *PREST-O-LITE* R-511LPG regulator (P/N 21820).

NOTE: The tip can also be attached to a small disposable cylinder of FG-2, propane, or MAPP using PREST-O-LITE R-10-40-600 Regulator (P/N 21504). Instructions (Form F-15-166) are packed with the regulator.

2. Follow all instructions supplied with the regulator. Connect the regulator to the fuel gas tank.
3. Connect a special fuel gas hose (90F49) to the regulator and to the *PREST-O-LITE* No. 403 (P/N 02X93) or No. 401M (P/N 17200) torch handle. Tighten the hose connecting nuts firmly with a wrench. Do NOT overtighten.
4. Insert the tip into the torch handle, and hand tighten the tip connection nut.
5. Adjust the regulator to deliver approximately 25 psi pressure. Crack the torch valve open, and light the gas flowing from the tip with a friction lighter. Do NOT use a match. Use of a match can seriously burn your hand. When lit, open the torch valve wide.
6. Best operating pressure for this tip with any fuel gas is around 25 psi with the torch valve wide open. When using FG-2, it can operate as low as 10 psi without overheating the tip. If heavier

or lighter flame is desired, adjust pressure accordingly at the regulator with the torch valve wide open.

7. To stop work, close the torch valve. If shutting down for more than a few minutes (always for an overnight shutdown), release pressure from the regulator to prevent any occurrence of leakage or accidental release of fuel gas. Shut down as follows: (1) Close tank valve; (2) Open torch valve; (3) When delivery pressure drops to zero, back out the regulator pressure-adjusting screw and close torch valve.
8. If the tip overheats, even though fuel gas is being supplied at more than the recommended 25 psi pressure, specified, the mixer nozzle in the back end of the tip may be clogged (see illustration). To clear, shut off the torch, allow the tip to cool, and then 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 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 mixer nozzle and filter-screw with new parts.



NOTE: On older tips with 2-pc. mixer, use Mixer Nozzle - 633904 and Filter Screw - 998311.

SAFETY PRECAUTIONS: Be sure to read and understand all Safety Precautions in the Instructions supplied with the regulator and torch handle.

*MAPP is a Registered trademark of Air Reduction Co.

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



ESAB Welding & Cutting Products
PO Box 100545, Florence SC 29501-0545