

Torch Maintenance and Parts List

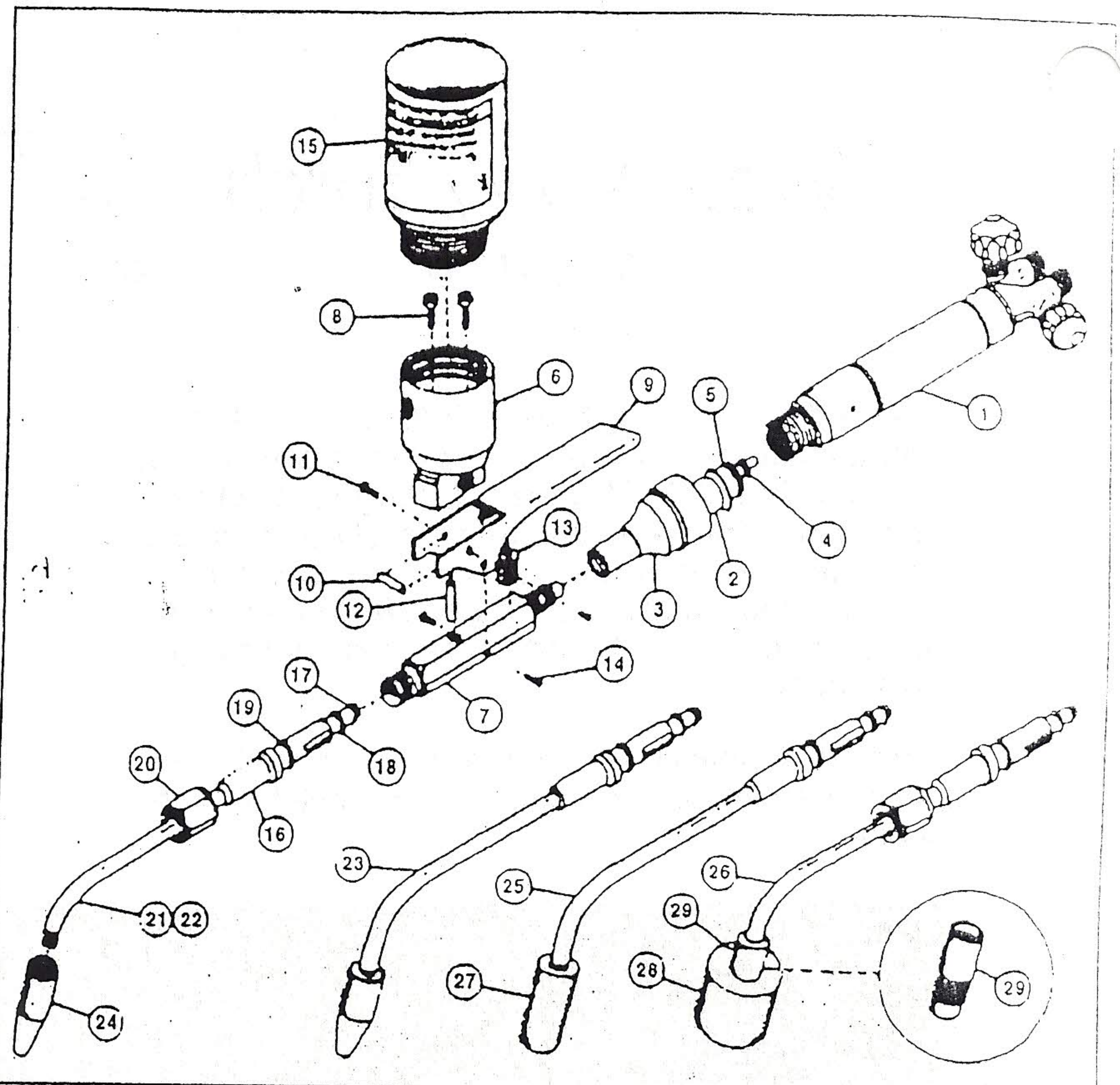
If the torch should begin to *pop out* for no apparent reason, check the tip orifice for wear. Tips will normally perform satisfactorily until they wear about 10% over their nominal size. For example, a #20 is .073" and will operate well until it wears to about .080". At .082" and larger, the flame will *pop out* for no apparent reason.

To Replace the Powder Feed Valve

1. Remove one of the valve bar screws (11).
2. Press powder feed lever and remove valve bar (10).
3. Remove hopper screws (8).
4. Remove valve (12).

To Reassemble

1. Replace valve tapered end toward the hex body (7).
2. Insert and tighten hopper screws. As the screws are tightened, the valve is compressed causing a seal to be formed at both ends.
3. Depress the powder feed lever and insert the valve bar. Apply and tighten the valve bar screw while fully depressing the feed lever. If the feed lever is not depressed, the valve bar may rotate causing the valve to be forced from its proper position resulting in erratic or no powder feed. Keep parts absolutely clean. Use clean tools and no lubricants. Avoid transferring skin oils to internal torch parts.



INJECTOR TIP ASSEMBLY

(1) Tip End (2) Barrel (3) Aspirator/Injector (4) "O" Ring (5) "O" Ring (6) "O" Ring

Extra Powder Injector Tip assemblies are available in the following sizes:

Single Orifice Powder Injector Tip Assembly*

No. 6	(0.042 in.)
No. 9	(0.052 in.)
No. 15	(0.059 in.)
No. 20	(0.073 in.)
No. 40	(0.098 in.)
No. 55	(0.113 in.)

Multiflame Powder Injector Tip Assembly*

No. 40	(0.040 in. 7 Orifice)
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* Replaceable copper tip ends are available from stock in the same sizes shown for the assemblies.

PART NUMBER	NAME	PART NUMBER	NAME
1	Torch Handle	20	Tip Coupling Nut
2	Mixer	21	6" Tip Barrel (For # 6-9-15-20 Tips)
3	Mixer Nut	22	8" Tip Barrel (For # 40 & 55 Tips)
4	Small "O" Ring Mixer	23	Complete Single Orifice Tip Assembly (Specify Size)
5	Large "O" Ring Mixer	24	Tip End Only (Single Orifice) (Specify Size)
6	Powder Hopper Assembly	25	Complete Tip Assembly # 20 Multiflame (3.040 Orifice)
7	Model 10 Hex Body	26	Complete Tip Assembly # 40 Multiflame (7.040 Orifice)
8	Hopper Cap Screw	26A	Complete Tip Assembly # 55 Multiflame (9.040 Orifice)
9	Powder Feed Lever	27	# 20 Multiflame Tip End Only
10	Valve Bar	28	# 40 Multiflame Tip End Only
11	Valve Bar Screw	28A	# 55 Multiflame Tip End Only
12	Powder Feed Valve (Rubber)	29	Adapter for # 40 & # 55 Tip End
13	Spring		
14	Pivot Pin		
15	Powder Bottle		
16	Injector Sub-Assembly (Specify Size)		
17	"O" Ring Powder Injector		
18	"O" Ring Powder Injector		
19	"O" Ring Powder Injector		