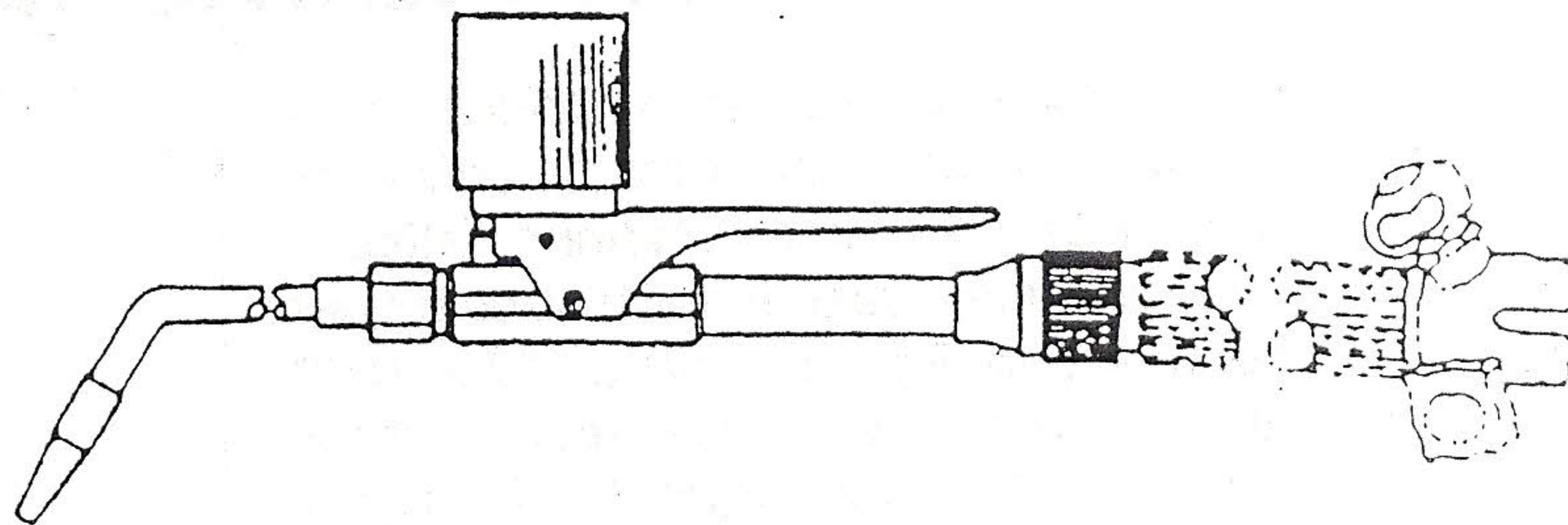


WearSpray Torch

Model 10



The *ATS* WearSpray Model 10 Torch was designed with the operator in mind. It is a light, well-balanced tool, compatible with most existing oxyacetylene equipment. The WearSpray Torch is efficient, safe to operate and versatile. These features and its nominal cost make it an attractive tool for small repair operations or for the production hardfacing of many parts.

A Model 10 safety feature is the venturi-vented hopper, preventing blow back or gas accumulation in the hopper.

A full range of single flame tips and two multi-flame tips for larger parts are available (see next page). Tip connectors require only hand tightness and no wrenches are needed.

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OPERATING INSTRUCTIONS

Preparing for Torch Use

Insert desired powder spray tip into attachment body and seal by finger-tightening the connector nut. Tip injector should be wiped clean with a cloth before inserting into the body; do not wipe injectors with fingers. Clean injector cavity by opening oxygen valve momentarily.

To check the torch for operation without powder, light it and adjust to a carburizing flame of 1X and 2X. Depress the powder feed handle. If the torch is clear, the flame will change to neutral. If it does not change, clear the passages by blocking the orifice with a soft material and purge the oxygen. *Do not try to clear the passage by blowing with the mouth; this can introduce moisture into the system, causing the valve to stick.*

Backflush the unit before and after each use to remove residual powder. Condensation can cause residual powder to cake on internal passages if this is not done. To backflush, empty hopper, turn on oxygen, hold powder feed handle down and intermittently stop oxygen flow at the tip. This will cause residual powder to be expelled through the hopper exhaust port. To change tip position, loosen p nut one half turn. Pull tip forward slightly, then rotate to desired position. Do not rotate the tip when the tip nut is tightened since the tip nut compresses an "O" ring which could be damaged. If the torch is

operated at too low a flame (choked back), powder feed control will not be as brisk and positive as it should be. Tip ends may also overheat, decreasing their normal life.

Typical regulator gauge readings are: All tip sizes: 15 psi acetylene; 20 psi oxygen.

Backfire and Flashback Precautions

Improper adjustment of the torch can cause backfires. The torch should be adjusted by turning on the acetylene until the flame just breaks away from the tip. Then, adjust the oxygen. If the flame size is too large or too small, change the tip rather than adjusting the gas volumes. *Acetylene cylinders release one-seventh (1/7) of their content per hour; larger tip sizes may require larger acetylene cylinders.*

Should the flame flash back inside the tip, close the torch acetylene valve immediately, then close the oxygen valve. A flashback is usually accompanied by a shrill hissing or squealing. Closing the acetylene valve stops the flashback at once. After the flashback, the torch should be allowed to cool off before relighting. Flashbacks indicate that something is radically wrong, often lack of gas pressure, overheating of tip, etc. Do not relight the torch until everything is checked out and found to be in good operating condition.