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› TurboTorch Swirl Air Acetylene Kit - Model 0386-0336 Instruction Manual

TurboTorch 0386-0336

TurboTorch Swirl Air Acetylene Kit

Model: 0386-0336 (X-4B)

INTRODUCTION

This manual provides essential information for the safe and effective operation, maintenance, and troubleshooting of your TurboTorch Swirl Air Acetylene Kit, Model 0386-0336. This kit is engineered for heavy-duty applications, particularly in A/C and refrigeration, offering reliable performance with extreme swirl technology for hotter combustion.

The kit includes an acetylene AR-style regulator with all brass construction, a 12-foot acetylene hose, a torch handle, and two A-style tips (Size 5 and Size 14) designed for quick disconnect. Please read this manual thoroughly before initial use.

SAFETY INFORMATION

WARNING: Acetylene gas is highly flammable. Always follow all local and national safety codes and regulations when handling and using this equipment. Failure to do so can result in serious injury or death.

- Always wear appropriate personal protective equipment (PPE), including safety glasses, gloves, and protective clothing.
- Ensure adequate ventilation in the work area.
- Keep flammable materials away from the work area.
- Before each use, **PROPERLY TIGHTEN ALL CONNECTIONS** and **CHECK FOR LEAKS** using a suitable leak detection solution. Never use an open flame to check for leaks.
- Never use damaged or worn equipment. Inspect hoses, connections, and the torch for any signs of wear or damage before each use.
- Store acetylene cylinders upright in a well-ventilated area, secured to prevent falling.
- Do not expose cylinders to excessive heat.

KIT COMPONENTS OVERVIEW



Image: The TurboTorch Swirl Air Acetylene Kit, Model X-4B, showing the red acetylene hose, brass regulator, gray torch handle, and two A-style tips. The packaging highlights 'New Tips! Hotter Swirl Combustion' and 'For Heavy Duty Applications'.

The TurboTorch Swirl Air Acetylene Kit (X-4B) is designed for efficiency and durability. Key components include:

- **Acetylene Regulator:** AR-style, all brass construction with an easy-to-read contents gauge and standard 3/8 inch 24-thread LH outlet fitting.
- **Acetylene Hose:** 12-foot length with 3/8 inch 24-thread LH nuts for secure connections.
- **Torch Handle:** Ergonomically designed for comfortable use, featuring a quick disconnect fitting for rapid tip changes.
- **A-Style Tips:** Includes Size 5 and Size 14 tips, engineered for extreme swirl technology to provide hotter combustion.

SETUP INSTRUCTIONS

1. **Connect Regulator to Cylinder:** Ensure the acetylene cylinder valve is closed. Connect the acetylene regulator to the cylinder valve. Hand-tighten first, then use a wrench to secure the connection firmly.
2. **Connect Hose to Regulator:** Attach one end of the 12-foot acetylene hose to the regulator's outlet fitting.

Ensure the 3/8 inch 24-thread LH nut is properly aligned and tightened.

3. **Connect Hose to Torch Handle:** Attach the other end of the hose to the inlet of the torch handle. Tighten securely.
4. **Attach Tip to Torch Handle:** Select the desired A-style tip (Size 5 or Size 14). Insert the tip into the quick disconnect fitting on the torch handle and twist to lock it into place. Ensure it is seated firmly.
5. **Leak Check:** Before opening the cylinder valve, ensure all connections are tight. Slowly open the acetylene cylinder valve. Apply a leak detection solution to all connections (regulator to cylinder, hose to regulator, hose to torch handle, and tip to torch handle). Look for bubbles, which indicate a leak. If a leak is detected, close the cylinder valve, relieve pressure, and re-tighten the connection. Repeat the leak check until no bubbles appear.

OPERATING INSTRUCTIONS

1. **Open Acetylene Valve:** Slowly open the acetylene cylinder valve fully. The regulator gauge will show the cylinder pressure.
2. **Set Working Pressure:** Turn the regulator adjusting screw clockwise to set the desired working pressure. Refer to the tip manufacturer's recommendations for appropriate pressure settings.
3. **Open Torch Valve:** Slightly open the acetylene valve on the torch handle.
4. **Light the Torch:** Use a spark lighter or friction igniter to light the gas at the tip. Never use matches or a cigarette lighter.
5. **Adjust Flame:** Adjust the acetylene flow at the torch handle to achieve the desired flame. For brazing, a neutral flame is typically used. The extreme swirl technology of the tips provides a concentrated, hot flame.
6. **Perform Work:** Proceed with your brazing or soldering task.
7. **Shut Down:** When finished, first close the acetylene valve on the torch handle. Then, close the acetylene cylinder valve. Allow the flame to extinguish as the gas in the hose is consumed. Once the flame is out, open the torch handle valve briefly to bleed off any remaining pressure in the hose and regulator, then close it. Turn the regulator adjusting screw counter-clockwise until it is loose to release spring tension.

MAINTENANCE

- **Tip Cleaning:** Regularly clean the tip orifices using appropriate tip cleaners. Do not use hard objects that could damage the tip.
- **Hose Inspection:** Periodically inspect the entire length of the hose for cuts, abrasions, bulges, or signs of wear. Replace any damaged hoses immediately.
- **Connection Integrity:** Routinely check all connections for tightness. Re-tighten as necessary and perform a leak check.
- **Regulator Care:** Keep the regulator clean and free from oil or grease. Do not attempt to repair a damaged regulator; have it serviced by qualified personnel.
- **Storage:** Store the kit in a clean, dry place, away from extreme temperatures and direct sunlight. Disconnect the regulator from the cylinder when not in use for extended periods.

TROUBLESHOOTING

- **No Gas Flow / No Flame:**
 - Check if the acetylene cylinder valve is open.
 - Verify the regulator working pressure is set correctly.

- Ensure the torch handle valve is open.
- Check for blockages in the tip or hose.
- Confirm there is sufficient gas in the cylinder.

- **Unstable Flame / Popping:**

- Clean the torch tip.
- Check for loose connections, especially at the tip.
- Ensure correct gas pressure settings.

- **Gas Leaks:**

- Immediately close the cylinder valve.
- Apply leak detection solution to all connections to pinpoint the leak.
- Tighten or replace the faulty component (e.g., O-ring, fitting).
- Never use the kit if a leak cannot be resolved.

SPECIFICATIONS

Attribute	Detail
Model Number	0386-0336 (X-4B)
Brand	TurboTorch
Kit Type	Air Acetylene
Application	Heavy Duty, A/C and Refrigeration
Item Weight	3.5 pounds
Hose Length	12 feet
Tip Sizes Included	Size 5, Size 14 (A-Style)
Regulator Type	AR-Style, All Brass Construction
Hose Fittings	3/8 inch 24-thread LH nuts

WARRANTY INFORMATION

This TurboTorch Swirl Air Acetylene Kit, Model 0386-0336, comes with a **3 YEAR LIMITED WARRANTY**. This warranty covers defects in materials and workmanship under normal use and service. Please retain your proof of purchase for warranty claims. For specific terms and conditions, refer to the warranty documentation included with your product or contact TurboTorch customer support.

SUPPORT

For technical assistance, replacement parts, or warranty service, please contact TurboTorch customer support. Visit the official TurboTorch website for the most up-to-date contact information and additional resources. Always provide your product model number (0386-0336) and serial number (if applicable) when contacting support to ensure efficient service.

