ESAB 0323-0261

Victor 0323-0261 12-MFA Professional Heating Nozzle User Manual

Brand: ESAB | Model: 0323-0261

1. Product Overview

The Victor 0323-0261 12-MFA Professional Heating Nozzle is engineered for precision heating applications. It is designed for use with the HD 310C Torch Handle and features a multi-flame heating head, making it suitable for various tasks including heat treating, straightening, and priming. This nozzle operates with Acetylene and Hydrogen as fuel gases.

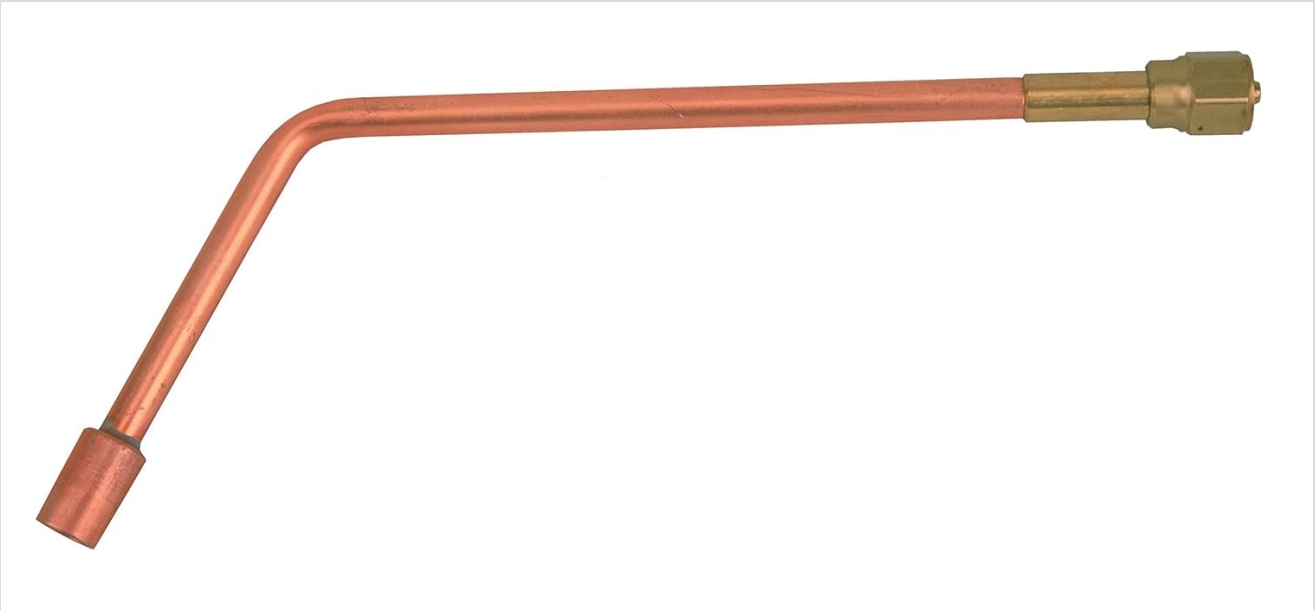

Image: The Victor 0323-0261 12-MFA Professional Heating Nozzle, a copper-colored, angled nozzle with a brass fitting at one end, designed for heating applications.

2. Safety Information

Always prioritize safety when operating heating equipment. Failure to follow safety guidelines can result in serious injury or property damage.

- **Personal Protective Equipment (PPE):** Always wear appropriate PPE, including welding gloves, safety glasses or a face shield, and protective clothing, to guard against heat, sparks, and UV radiation.

- **Ventilation:** Ensure adequate ventilation in the work area to prevent the accumulation of hazardous fumes and gases. Work in a well-ventilated space or use local exhaust ventilation.
- **Gas Cylinder Handling:** Handle gas cylinders with care. Secure them upright to prevent tipping. Ensure regulators and hoses are in good condition and properly connected.
- **Leak Detection:** Before each use, check all connections for leaks using a suitable leak detection solution. Never use a flame to check for leaks.
- **Flammable Materials:** Keep flammable materials away from the work area. Be aware of your surroundings and potential fire hazards.
- **Torch Handle Compatibility:** This nozzle is designed for use with the HD 310C Torch Handle. Ensure compatibility before attachment.
- **Pressure Settings:** Adhere strictly to the recommended oxygen and fuel gas pressure settings to prevent equipment damage or unsafe operation.
- **Emergency Procedures:** Know the location of fire extinguishers and emergency shut-off valves for gas supplies.

3. Setup

1. **Inspect Equipment:** Before setup, visually inspect the heating nozzle, torch handle (HD 310C), hoses, and regulators for any signs of damage, wear, or blockages.
2. **Connect Nozzle:** Carefully thread the Victor 0323-0261 12-MFA heating nozzle onto the HD 310C Torch Handle. Hand-tighten first, then use a wrench to secure it firmly, but do not overtighten.
3. **Connect Hoses:** Ensure the oxygen and fuel gas hoses are securely connected to their respective regulators and the torch handle.
4. **Purge Hoses:** Briefly open the cylinder valves to purge any air or contaminants from the hoses before connecting to the torch.
5. **Check for Leaks:** Apply a leak detection solution to all connections (nozzle to torch, hoses to torch, hoses to regulators, regulators to cylinders). Bubbles indicate a leak. Tighten connections or replace faulty components if leaks are detected.
6. **Set Pressures:** With the torch valves closed, slowly open the oxygen and fuel gas cylinder valves. Adjust the regulators to the recommended operating pressures:
    - Oxygen Pressure: 50-60 PSIG
    - Fuel Pressure (Acetylene/Hydrogen): 12-15 PSIG

4. Operating Instructions

This multi-flame heating nozzle is designed for heat treating, straightening, and priming applications.

1. **Ignition:**
    - Open the fuel gas valve on the torch handle slightly.
    - Use a spark lighter to ignite the gas at the nozzle tip. Never use matches or a cigarette lighter.
    - Slowly open the oxygen valve on the torch handle until the desired flame is achieved. Adjust both valves for a neutral flame, characterized by a clear, well-defined inner cone.

2. **Application:**
    - Direct the flame towards the workpiece, maintaining a consistent distance for even heat distribution.
    - For heat treating, apply heat uniformly to the area requiring treatment.
    - For straightening, apply heat to the convex side of the bend to cause expansion and subsequent contraction upon cooling.
    - For priming, heat the surface to remove moisture and contaminants, preparing it for coating.
3. **Shut Down:**
    - First, close the oxygen valve on the torch handle.
    - Then, close the fuel gas valve on the torch handle.
    - Close the cylinder valves for both oxygen and fuel gas.
    - Bleed the pressure from the regulators by opening the torch valves briefly until the gauge readings drop to zero. Close the torch valves.

Gas Consumption Rates:

- Oxygen Consumption: 66-165 SCFH
- Fuel Consumption (Acetylene/Hydrogen): 60-150 SCFH

5. Maintenance

Regular maintenance ensures the longevity and safe operation of your heating nozzle.

- **Nozzle Cleaning:** Periodically clean the nozzle tip to remove any carbon buildup or debris that may obstruct the gas flow. Use appropriate tip cleaners designed for heating nozzles. Do not use abrasive materials that could damage the tip.
- **Inspection:** Regularly inspect the nozzle for any signs of damage, such as cracks, dents, or excessive wear. Check the brass fitting for secure attachment and integrity.
- **Hose and Regulator Check:** Inspect hoses for cuts, abrasions, or leaks. Ensure regulators are functioning correctly and gauges are accurate. Replace any damaged components immediately.
- **Storage:** Store the heating nozzle and associated equipment in a clean, dry place, protected from extreme temperatures and physical damage. Disconnect from gas supplies when not in use for extended periods.

6. Troubleshooting

This section addresses common issues you might encounter with your heating nozzle.

Problem	Possible Cause	Solution

Problem	Possible Cause	Solution
No flame or weak flame	Gas cylinders empty or valves closed Regulator pressure too low Nozzle tip clogged Hose kinked or damaged	Check cylinder levels and open valves Adjust regulator pressure to recommended settings Clean nozzle tip with appropriate cleaner Inspect and straighten/replace hose
Inconsistent or sputtering flame	Improper gas mixture Partial nozzle blockage Loose connections	Adjust oxygen and fuel gas valves for a stable flame Clean nozzle tip thoroughly Check and tighten all connections
Gas leaks detected	Loose fittings Damaged O-rings or seals Faulty hose or regulator	Tighten all connections Replace damaged O-rings or seals Replace faulty hose or regulator immediately

7. Specifications

Attribute	Detail
Model Number	0323-0261 (12-MFA)
Manufacturer	Victor
Brand	ESAB
Compatibility	HD 310C Torch Handle
Applications	Heat treating, straightening, priming
Fuel Gas Usage	Acetylene and Hydrogen
Overall Length	17.5 inches
Oxygen Pressure (PSIG)	50-60
Fuel Pressure (PSIG)	12-15
Oxygen Consumption (SCFH)	66-165
Fuel Consumption (SCFH)	60-150
Product Dimensions	18 x 3 x 3 inches
Item Weight	0.64 ounces

8. Warranty and Support

For specific warranty information regarding your Victor 0323-0261 12-MFA Professional Heating Nozzle, please refer to the documentation provided with your purchase or visit the official ESAB/Victor website. Warranty terms and conditions typically cover manufacturing defects and material flaws under normal use.

For technical support, spare parts, or service inquiries, please contact ESAB customer service or an authorized Victor dealer. You can often find contact information and support resources on the official ESAB website: www.esab.com

Documents - ESAB – 0323-0261

[pdf] User Manual Accessories Catalog

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