

## Victor 0311-0650

# Victor 0311-0650 15-A-Mfa Heating Tip User Manual

Comprehensive instructions for safe and effective use of your Victor heating tip.

## 1. INTRODUCTION AND PRODUCT OVERVIEW

The Victor 0311-0650 15-A-Mfa Heating Tip is a precision-engineered component designed for use with oxy-fuel torch systems. It is specifically crafted to deliver a broad, controlled flame for various heating applications, including bending, straightening, preheating, and stress relieving. This tip ensures efficient heat transfer and consistent performance when properly installed and operated with compatible Victor torch handles and gas regulators.

## 2. SAFETY INFORMATION

Always prioritize safety when working with oxy-fuel 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 goggles with proper shade, and protective clothing to prevent burns and eye injuries.
- **Ventilation:** Ensure adequate ventilation in the work area to disperse fumes and gases.
- **Flammable Materials:** Keep all flammable materials away from the work area.
- **Gas Cylinders:** Handle gas cylinders with care. Secure them upright and ensure regulators are properly attached.
- **Leak Testing:** Always perform a leak test with a suitable leak detection solution after connecting equipment.
- **Equipment Inspection:** Regularly inspect all equipment for damage, wear, or leaks before each use. Do not use damaged equipment.
- **Fire Extinguisher:** Have a suitable fire extinguisher readily available.

## 3. SETUP

Proper setup is crucial for safe and effective operation.

1. **Inspect Components:** Before assembly, inspect the heating tip, torch handle, and all connections for any signs of damage, debris, or wear. Ensure all O-rings and sealing surfaces are clean and intact.
2. **Attach Heating Tip:** Carefully thread the Victor 0311-0650 15-A-Mfa Heating Tip onto the compatible Victor torch handle. Hand-tighten first, then use a wrench to snug it securely. *Do not overtighten*, as this can damage the threads

or sealing surfaces.

3. **Connect Hoses and Regulators:** Ensure oxygen and fuel gas hoses are correctly connected to their respective regulators and the torch handle. Double-check that all connections are tight.
4. **Leak Test:** With gas cylinders open and regulators set to low pressure, 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. Tighten connections or replace faulty components if leaks are detected.



*Image 1: The Victor 0311-0650 15-A-Mfa Heating Tip. This image shows the tip's design, which connects to a compatible torch handle for oxy-fuel heating operations.*

## 4. OPERATING INSTRUCTIONS

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Follow these steps for safe ignition and operation of your heating tip.

1. **Open Fuel Gas:** Slowly open the fuel gas valve on the torch handle (typically the red or left valve) a quarter turn.
2. **Ignite Flame:** Using a spark lighter, ignite the fuel gas at the tip. *Never use matches or a cigarette lighter.*
3. **Adjust Fuel Gas:** Slowly open the fuel gas valve further until the flame is approximately 4-6 inches long and does not "blow off" the tip.
4. **Open Oxygen:** Slowly open the oxygen valve on the torch handle (typically the green or right valve) until the desired neutral flame is achieved. For heating, a slightly carburizing (excess fuel) flame is often preferred, but adjust according to the specific application.
5. **Heating:** Direct the flame to the workpiece, maintaining a consistent distance for even heating. Move the torch steadily to distribute heat as required.
6. **Shut-down Procedure:**
  - Close the oxygen valve on the torch handle first.
  - Then, close the fuel gas valve on the torch handle.
  - Close the cylinder valves for both oxygen and fuel gas.
  - Bleed the lines by opening the torch valves briefly until the regulator gauges read zero.
  - Close the torch valves.

## 5. MAINTENANCE

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Regular maintenance ensures optimal performance and extends the life of your heating tip.

- **Tip Cleaning:** Periodically clean the tip orifices using appropriate tip cleaners. Ensure the cleaners are the correct size for the orifices to avoid damage. Do not use hard objects or drills.
- **Inspection:** Regularly inspect the tip for signs of wear, damage, or blockages. Check for any deformation of the tip end or internal passages.
- **Storage:** Store the heating tip in a clean, dry place, protected from dust and physical damage, when not in use.
- **Replacement:** Replace the heating tip if it becomes damaged, clogged beyond cleaning, or shows signs of excessive

wear that affects flame quality or safety.

## 6. TROUBLESHOOTING

Refer to this section for common issues and their solutions.

Problem	Possible Cause	Solution
No flame or weak flame	Clogged tip orifices, insufficient gas pressure, closed cylinder valves.	Clean tip orifices, check regulator settings, ensure cylinder valves are open.
Unstable or "popping" flame	Incorrect gas pressure balance, loose tip, dirty tip.	Adjust gas pressures, ensure tip is securely tightened, clean tip.
Gas leak detected	Loose connections, damaged O-rings or seals, faulty hose.	Tighten connections, replace damaged O-rings/seals, replace faulty hose.

## 7. SPECIFICATIONS

Key specifications for the Victor 0311-0650 15-A-Mfa Heating Tip.

- **Model Number:** 0311-0650
- **Part Number:** 15-A-Mfa
- **Brand:** Victor
- **Product Dimensions:** 6 x 1 x 1 inches
- **Item Weight:** 5 pounds
- **Manufacturer:** VICTOR
- **ASIN:** B004RILG22
- **Date First Available:** June 14, 2012

## 8. WARRANTY AND SUPPORT

For warranty information, technical support, or service inquiries regarding your Victor 0311-0650 15-A-Mfa Heating Tip, please refer to the documentation included with your purchase or visit the official Victor website. You may also contact Victor customer service directly for assistance.

**Manufacturer:** VICTOR

**Website:** [www.victortechnologies.com](http://www.victortechnologies.com) (Note: This is a general link to the brand's website and may not be the exact support page.)