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› Hot Max 24024 1-GPN-0 Victor Style Gas Cutting Tips User Manual

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Hot Max 24024 1-GPN-0 Victor Style Gas Cutting Tips User Manual

Model: 24024

PRODUCT OVERVIEW

The Hot Max Victor Style Gas Cutting Tips are designed for use with natural gas or propane in oxy-fuel cutting processes. These tips facilitate the severing of metals through a chemical reaction of oxygen with the base metal at elevated temperatures. This specific model, 1-GPN-0, is a heavy-duty tip suitable for various cutting applications.

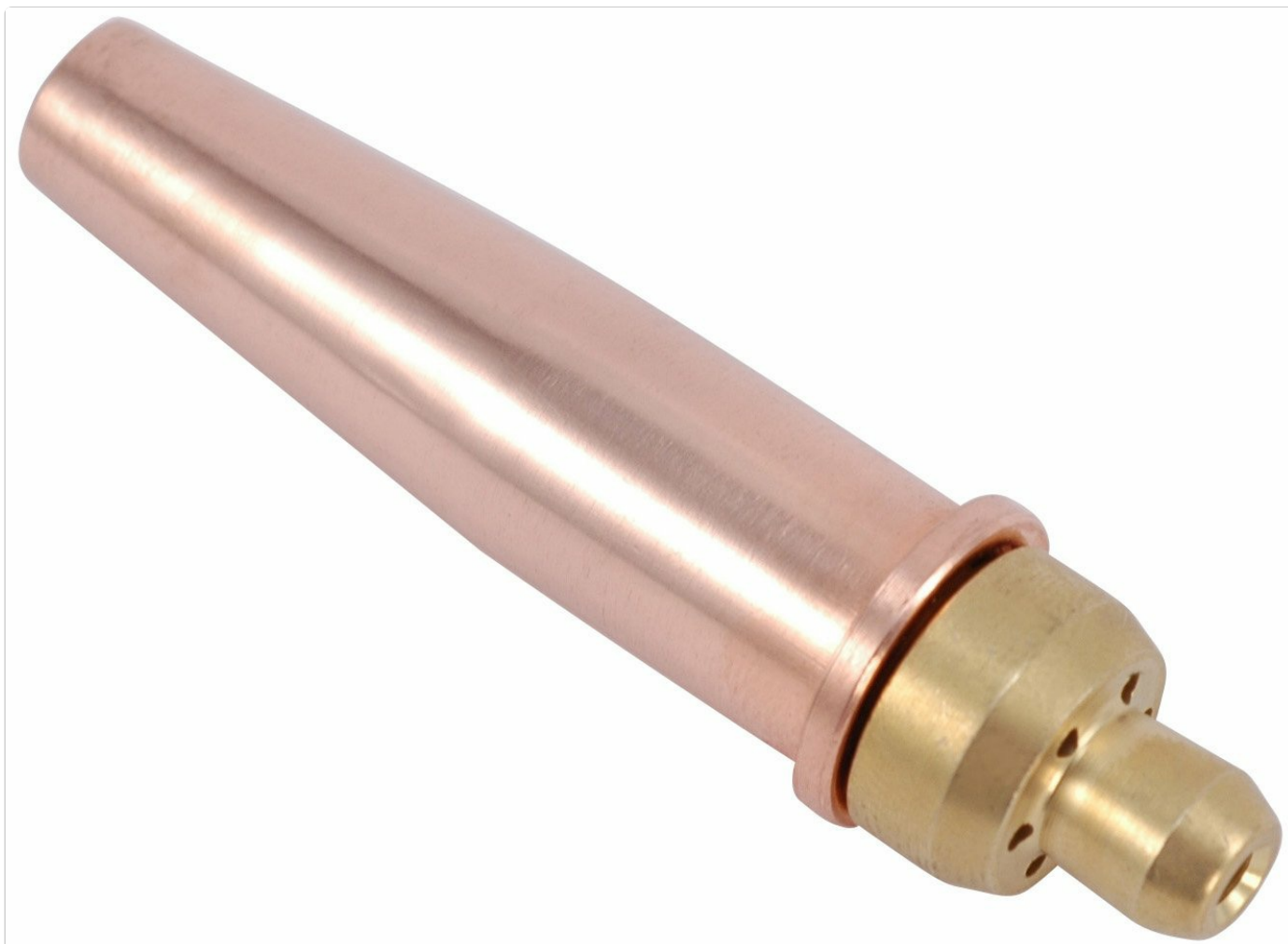


Image: Hot Max 1-GPN-0 Victor Style Gas Cutting Tip, showing its copper body and brass nozzle with multiple orifices.

SETUP AND INSTALLATION

Proper setup is crucial for safe and effective operation. Always ensure your cutting torch is compatible with Victor Style tips.

1. **Safety First:** Before handling any gas cutting equipment, ensure all gas cylinders are turned off and lines are depressurized. Wear appropriate personal protective equipment (PPE), including welding gloves, safety glasses, and flame-resistant clothing.
2. **Inspect the Tip:** Examine the Hot Max cutting tip for any signs of damage, blockages, or wear. A clean, undamaged tip ensures optimal performance and safety.
3. **Clean the Torch Head:** Ensure the torch head where the tip seats is clean and free of debris. Any foreign material can prevent a proper seal and lead to gas leaks.
4. **Install the Tip:** Carefully insert the Hot Max 1-GPN-0 cutting tip into the torch head. Hand-tighten the tip securely. Do not overtighten, as this can damage the tip or torch.
5. **Leak Check:** After installation, perform a leak check using a leak detection solution (e.g., soapy water) on all connections, including the tip, before igniting the torch. Bubbles indicate a leak.

OPERATING INSTRUCTIONS

These tips are designed for oxy-natural gas or oxy-propane cutting. Follow standard industry practices for gas cutting operations.

- **Gas Pressure Settings:** Refer to your torch manufacturer's recommendations and gas supplier's guidelines for appropriate oxygen and fuel gas (natural gas or propane) pressures for the 1-GPN-0 tip size. Incorrect pressures can lead to inefficient cutting or flashback.
- **Ignition:** Open the fuel gas valve slightly, ignite the gas with a spark lighter, then slowly open the oxygen valve until a neutral

flame is achieved. Adjust the cutting oxygen lever for the preheat flames.

- **Preheating:** Position the preheat flames on the edge of the metal to be cut until it reaches ignition temperature (bright cherry red).
- **Cutting:** Once the metal is preheated, depress the cutting oxygen lever fully. Move the torch steadily along the cutting line, maintaining a consistent speed and standoff distance to achieve a clean cut.
- **Shut Down:** To shut down, first close the oxygen valve on the torch, then the fuel gas valve. Turn off cylinder valves and bleed lines.

MAINTENANCE

Regular maintenance extends the life of your cutting tip and ensures safe operation.

- **Tip Cleaning:** After each use, inspect the tip orifices for slag or carbon buildup. Use appropriate tip cleaners (sized for the specific orifices) to gently clear any obstructions. Never use hard objects or drills that can damage the precision orifices.
- **Storage:** Store cutting tips in a clean, dry place to prevent corrosion and damage.
- **Replacement:** Replace the tip if it shows signs of excessive wear, damage, or if the orifices are enlarged or distorted, as this can affect flame characteristics and cutting performance.

TROUBLESHOOTING

Common issues and their potential solutions:

Problem	Possible Cause	Solution
Rough or Uneven Cut	Incorrect cutting speed, improper gas pressure, dirty or damaged tip.	Adjust cutting speed, verify gas pressures, clean or replace tip.
Tip Overheating/Backfire	Insufficient gas flow, tip too close to workpiece, dirty tip.	Increase gas flow, maintain proper standoff distance, clean tip.
Difficulty Igniting	Blocked orifices, low gas pressure.	Clean tip orifices, check gas supply and regulator settings.

SPECIFICATIONS

Attribute	Detail
Manufacturer	Hot Max
Part Number	24024
Item Model Number	24024
Style	1-GPN-0 (Victor Style)
Item Weight	0.3 ounces
Product Dimensions	6.5 x 2.75 x 1.25 inches
Item Package Quantity	1

Attribute	Detail
Batteries Required?	No
Country Of Origin	China
Date First Available	October 21, 2011

WARRANTY INFORMATION

This Hot Max product comes with a **30-day warranty** from the date of purchase. This warranty covers manufacturing defects. For warranty claims or further details, please contact Hot Max customer support.

CUSTOMER SUPPORT

For technical assistance, product inquiries, or support regarding your Hot Max 1-GPN-0 Victor Style Gas Cutting Tip, please refer to the contact information provided on the official Hot Max website or product packaging. Always provide your model number (24024) when seeking support.