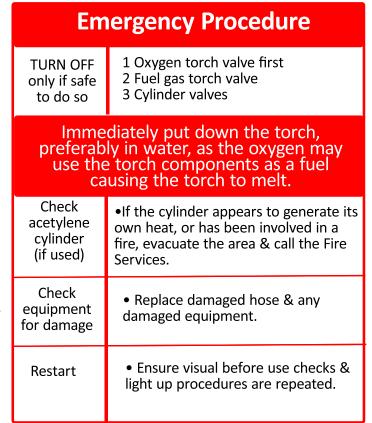
Mobile Oxy-Fuel Procedures

Light Up Procedure		
Check	 Local fire procedures are followed Fire extinguishers are available Appropriate PPE is in use. 	
Visual Check	 Before use visual checks are completed. 	
Purge Purging should only take place in well ventilated areas, not in confined spaces.	Purge oxygen & fuel hoses in turn whilst setting working pressure. • Purge oxygen & fuel assembly in turn. • Open cylinder valve to a maximum 1.5 turns • Open torch valve • Open regulator & adjust to set for initial working pressure. • Purge each hose & gas assembly checking for gas flow from torch. • Close torch valves.	
Leak Check	•All Joints	
Ensure torch valves are closed before proceeding		
Purge Torch	 Open oxygen torch valve, purge 3-5 seconds, then close the valve. Open fuel torch valve, purge 3-5 seconds, then close the valve. 	
Lighting the system Select the correct spark lighter. Naked flames must not be used.	 Open fuel gas torch valve Ignite the fuel gas with the correct spark lighter. For acetylene increase fuel gas valve to reduce smoke if necessary. 	
	•Slowly open the oxygen torch valve until a clear sharply defined flame is achieved.	

Shut Down Procedure		
The fuel gas is normally switched off first - consult the Equipment Supplier's handbook as there may be variations		
Extinguish the working Flame at the torch	Fuel gas offOxygen off	
Close Cylinder Valve	•Turn the cylinder valve keys clockwise until closed.	
Vent System (No Gas)	Open torch valves in turn.Vent the gas from each of the hosesCheck gauges are reading zero.	
Close Torch Valves	•Close all torch valves.	
Close Regulator	•Close regulator pressure adjustment screw.	
Check Three Stops		
Three Stops Employed	1.) Torch Valves Closed2.) Cylinder Closed3.) Regulator Closed	
Safely Store Equipment	 Preferably do not stow hoses around the cylinders Remove the cylinders from any confined space. 	





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