**Personal Protective Equipment and Clothing.**

**DO NOT** use this machine unless you have been instructed in its safe use and operation and have been given permission.

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| Wear Safety Boots Signs - from Key Signs UK | Safety footwear must be worn at all times in work areas. | ISO Safety Gloves Required Sign, SKU: IS-1008 | Safety gloves must be worn when using this equipment. |  | Fire resistant protective clothing to be worn. |
| Safety operating procedures | Long & loose hair must be contained. | Safety Glasses Must Be Worn | Signs &amp; Symbols | Safety glasses must be worn at all times. |  | Jewellery & watches forbidden. |

**Pressure Setting.**

**🗸** Check that the oxygen and acetylene regulator adjusting knobs are loose.

**🗸** Check that both blowpipe valves are closed.

**🗸** Slowly open the cylinder valves on each cylinder for half a turn only.

**🗸** Screw in the regulator adjusting knobs slowly until the delivery pressure gauges register 70kPa.

**🗸** Purge and check for constant oxygen gas flow:

-Open the oxygen blowpipe valve for 2 seconds and check the delivery gauge.

-If necessary re-adjust the oxygen regulator to achieve a 70kPa pressure.

-Close the acetylene blowpipe valve.

**🗸** Purge and check for constant acetylene gas flow:

-open the acetylene blowpipe valve for 2 seconds and check the delivery gauge.

-If necessary re-adjust the acetylene regulator to achieve a 70kPa pressure

-Close the acetylene blowpipe valve.

**This safe Operating Procedure does not necessarily cover all possible hazards associated with this equipment and should be used in conjunction with the manufacturer’s guidance. It is designed as a guide to be used to compliment training and as a reminder to users prior to equipment use. Users acknowledge that improper use of equipment increases their risk of harm and that this is a decision they make. Anyone found to be using equipment incorrectly will have their usage rights removed pending a re-training exercise on the safe use of the equipment.**

**Don’t.**

X Do not use faulty equipment. Immediately report any suspect machinery.

X do not light the blowpipe with matches or lighters.

X Do not use oil, grease or other hydrocarbons.

X Do not use oxygen as a substitute for compressed air.

**Shutting Off Blowpipe.**

**🗸** Close the acetylene blowpipe valve firs.

**🗸** Then close the oxygen blowpipe valve.

**Finishing Operations and Housekeeping.**

**🗸** Close down both cylinder valves.

**🗸** Open oxygen blowpipe valve and allow gas to drain out.

**🗸** When oxygen gauges read zero, unscrew regulator adjusting knob.

**🗸** Close oxygen blowpipe valve.

**🗸** Turn off acetylene cylinder valve.

**🗸** Open acetylene blowpipe valve and release gas.

**🗸** When acetylene gauges read zero, release regulator adjusting knob.

**🗸** Close acetylene blowpipe valve.

Hang up welding blowpipe and hoses.

Switch off the fume extraction unit.

Leave the work area in a safe, clean and tidy state.

**Pre-Operational Safety checks.**

**🗸** locate and ensure you are familiar with all machine operations and controls.

**🗸** Check workspaces and walkways to ensure no slip/trip hazards are present.

**🗸** Keep area clean and free of grease, oil and any flammable materials.

**🗸** Ensure gas hoses are in good condition and do not create a tripping hazard.

**🗸** Before lighting up, check all equipment for damage.

**🗸** Check that the area is well ventilated. Start the fume extraction unit before beginning to weld.

**🗸** Ensure the unit is fitted with working flashback arresters.

**🗸** Ensure work return earth cables make firm contact to provide a good electrical connection.

**Lighting Up.**

**🗸** Open the acetylene blowpipe valve slightly and light the blowpipe with a flint lighter

**🗸** Continue to slowly open the acetylene valve until the flame no longer produces soot.

**🗸** Slowly open the oxygen blowpipe valve until a neutral flame is produced.

**Potential Hazards and Injuries.**

**¡** Burns.

**¡** Heavy loads, manual handling.

**¡** Inhalation of fumes.

**¡** Flying Sparks.

**¡** Flashbacks.

**¡** Radiation damage to eyes.

**¡** Combustible materials.

**¡** Explosion by gas leakage.

**¡** Oil & grease.

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| A\* | *For use by trained staff only. Use by anyone else strictly prohibited.* | A | *For use by adult employees (18+) who have received and signed the safe use paperwork. No lone working.* |
| B | *For use by adult employees (16+) who have received and signed the safe use paperwork. Lone working Permitted.* | C | *For use by all employees under the supervision of adult employees who have received and signed the safe use paperwork. Adult lone working permitted.* |