



LOCKSMITHS

SAFE OPERATING PROCEDURE OXY ACETYLENE SET

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

PERSONAL PROTECTIVE EQUIPMENT

 CLOSE FITTING PROTECTIVE CLOTHING MUST BE WORN	 WELDING GOGGLES MUST BE WORN	 FOOT PROTECTION MUST BE WORN	 HAIR PROTECTION MUST BE WORN	 EYE PROTECTION MUST BE WORN	 Oil free leather gloves and spats must be worn when welding	 TOXIC AND/OR FLAMMABLE VAPOURS MAY BE PRESENT	 NO RINGS OR JEWELLERY TO BE WORN



PRE-OPERATIONAL SAFETY CHECKS

- Read Operators Manual and Risk assessment.
- Task (e.g. Drawings, instructions, specifications etc.) is clearly understood.
- Ensure the work area is clean and clear of grease, oil and any other flammable materials.
- Ensure no slip/trip hazards are present in workspaces and walkways.
- Gas hoses must be in good condition and not create a tripping hazard.
- Before lighting up make a visual inspection of all equipment for damage.

- Check that the area is well ventilated and fume extraction unit is on.
- Ensure appropriate PPE is worn.

OPERATIONAL SAFETY CHECKS

- PRESSURE SETTING
 - Check that the oxygen and acetylene/fuel 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 for 2 seconds valve and check the delivery gauge.
 If necessary re-adjust the oxygen regulator to achieve a 70kPa pressure.
 Close the oxygen blowpipe valve.
- Purge and check for constant acetylene/fuel gas flow.
 Open the acetylene/fuel 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.

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✓ LIGHTING UP

Open the acetylene/fuel blowpipe valve slightly and light the blowpipe with a flint lighter.
 Continue to slowly open the acetylene/fuel valve until the flame no longer produces soot.
 Slowly open the oxygen blowpipe valve until a neutral flame is produced.

ENDING OPERATIONS AND CLEAN UP

✓ SHUTTING OFF BLOWPIPE

Close the acetylene/fuel blowpipe valve first.
 Then close the oxygen blowpipe valve Close the shielding gas bottle valve and regulator.

✓ CLOSING DOWN

- Close down both cylinder valves.
- Open oxygen blowpipe valve to allow the gas to drain out.
- When oxygen gauges read zero, unscrew regulator-adjusting knob.
- Close oxygen blowpipe valve.
- Turn off acetylene/fuel cylinder valve.
- Open acetylene/fuel blowpipe valve and release gas.
- When acetylene/fuel gauges read zero, release regulator adjusting knob.
- Close acetylene/fuel blowpipe valve.

- ✓ Hang up welding blowpipe and hoses.
- ✓ Turn off fume extraction.
- ✓ Leave the work area in a safe, clean and tidy condition

MAINTENANCE

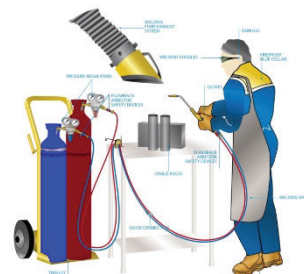
- ✓ Maintenance must only be performed by qualified personnel in accordance with the Maintenance section of the Operators Manual.
- ✓ This Safe Operating Procedure DOES NOT apply to any equipment that has been modified outside manufacturer's specifications.

POTENTIAL HAZARDS AND INJURIES

- i IR radiation burns to eyes & skin.
- i Flying sparks.
- i Fumes.
- i Flashbacks
- i Fumes and vapours.
- i Explosion by gas leakage.
- i Trips/slips with possible muscular skeletal injury.
- i Burns due to hot, molten materials.
- i Fire.

DON'T

- ✗ DO NOT operate equipment without wearing appropriate PPE.
- ✗ Lighting the blowpipe with matches or lighters.
- ✗ Using oil, greases or other hydrocarbons near or around Oxy/Acetylene gasses.
- ✗ Using oxygen as a substitute for compressed air.
- ✗ Use faulty equipment. Immediately report any suspect equipment & apply a DO NOT USE tag.



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