

Maintenance instructions

Daily Observation

The Gasfluxer, its connections and the acetylene hose should receive a visual inspection daily for possible leakages which will appear in the form of a white deposit. The places where a leak may be found and the procedure to adopt is as follows:

1. If a white deposit appears around valves and/or pipe connections, tighten in ordinary way.
2. If a white deposit appears around the sight glass cover tighten with a spanner wrench.
3. If a white deposit appears around the top tank gasket tighten all six bolts.
4. A white deposit appearing on the acetylene hose indicates a leak calls for the replacement of the hose. The use of propane hose, from the Gasfluxer to the torch, may therefore be preferred

Special information on the operation of the Gasfluxer

Capacity: One gallon of Superior Gasflux will process from 3,500 to 4,000 cu.ft. of acetylene at an approximate rate of 20 cu. ft per hour.

Dehydration: Water or moisture in the fuel line causes precipitation of solids in the gasflux, forming a white deposit in the torch tip.

Old hose: When old hose is used, having cracks and crevices in the interior, a sufficient quantity of gasflux, may be absorbed to provide a greenish colour to the flame for a considerable time even after the Gasfluxer has been bypassed. The amount of gasflux, though it may colour the flame, is not important from a practical standpoint.

Clogging tips: Superior Gasflux is really a cleaning agent and as such, in its initial action, may remove impurities from the line and cause temporary clogging of the tips. However, after this first material has been removed, the gasflux act to keep tips clean, and users over a period of time report unusually clean tips through the use of Superior Gasflux



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THE GASFLUXER PROCESS



Instruction Manual

To install the Gasfluxer

1. The unit is perfectly rigid if placed on a level surface, but holes are provided in the base so that it may be fixed in position if desired.
2. Make certain that both oxygen and acetylene are turned off at the supply source
3. Attach hose from acetylene supply to gas inlet valve on the Gasfluxer
4. DO NOT connect the oxygen supply to the Gasfluxer

To charge the Gasfluxer

WARNING: Superior Gasflux is a volatile, inflammable but non explosive liquid and it should not be poured within 20 feet of an open flame.

1. Close the reserve tank valve. Remove the filler cap on the top of the reserve tank and fill the tank with Superior Gasflux. The capacity of the tank is one gallon.
2. Close the gas inlet valve and by-pass valve; open the gas outlet valve and the acetylene valve on the torch
3. Open the reserve tank valve. This allows the Superior Gasflux to flow into the Gasfluxer. When the liquid reaches the sight glass level, close the reserve tank valve. It is dangerous for the flux level to be any higher. Replace the filler cap and screw right down to make a tight joint
4. Close the outlet valve and the torch valve. The unit is then ready for use

To use the Gasfluxer

1. Make certain that both the reserve tank and by-pass valves are closed.
2. Turn on the oxygen and acetylene at the supply sources
3. Open the gas inlet and gas outlet valves on the Gasfluxer
4. Purge the Gasfluxer of air by opening the torch acetylene valve.
5. Light the torch in the normal way and adjust to a neutral flame. The flame may fluctuate slightly at first but will quickly return to normal.
6. The correct amount of flux is automatically delivered to the torch without any adjustment by the operator.

To re-charge the Gasfluxer

1. The Gasfluxer needs re-filling when the Superior Gasflux level approaches the bottom of the sight glass
2. Close the gas inlet valve and open the acetylene valve on the torch to release the pressure inside the Gasfluxer. The acetylene must be discharged in a safe place, preferably in the open air.
3. Proceed as under 3 and 4 of To charge the Gasfluxer
4. The Gasfluxer can be re-filled 12 to 15 times before the reserve tank is empty. To re-fill the reserve tank, make certain that the reserve tank valve is closed, then proceed as under 1 of To charge the Gasfluxer
5. If the tank has been over filled, and this can be dangerous, close the gas outlet valve and turn off the cylinder valve. Disconnect the hoses from the Gasfluxer, turn the unit upside down, open the reserve tank valve and wait until the Superior Gasflux has returned completely into the reserve tank. Close the reserve tank valve, return the Gasfluxer to an upright position and open valves to discharge any surplus gas or flux. Reconnect the hoses and proceed as under 3 and 4 of To charge the Gasfluxer

Operating hints

1. The Gasfluxer gives only the correct amount of Superior Gasflux required to keep the deposited metal free flowing and bonding with the parent metal. It will be found that brazing can proceed quicker than with powder flux and less deposited metal is required. This is because the Superior Gasflux, being in the flame, draws the brazing rod quickly into the closest joint, making it unnecessary to use large deposits. The use of blue tinted goggles is recommended as these enable the green gasflux flame to be more easily seen and adjusted. Excess acetylene will be seen as a shadow.
2. On no account should the inner cone be allowed to touch either the deposited or parent metal otherwise oxidation may occur
3. Use the flame like a brush to keep the deposited metal free flowing, adding as little rod as possible.
4. Use the torch tip and pressure recommended for the work and avoid over heating as the flux may become unstable
5. If an operation, such as preheating, call for the use of the flame without gasflux, close the gas inlet valve and the gas outlet valve and open the bypass valve.
6. Do not use the Gasfluxer when the level of Superior Gasflux, as shown in the sight glass is either too high or too low.
7. Since the flux is in the flame it can only go to parts reached by the flame and, naturally enough, access to tight capillary gaps cannot readily be obtained. Penetration into such joints can be made by using a little paste flux and then proceeding with Superior Gasflux in the normal way
8. The gas outlet, gas inlet, bypass and reserve tank valves are all fitted with diaphragms. Do not use force to close them or you may damage the diaphragm.

Safety Precautions

Acetylene is an explosive gas. Superior Gasflux, whilst not explosive, is highly inflammable and the following precautions must be strictly observed.

1. The units are manufactured to work at normal acetylene pressures, the maximum being 9lbs p.s.i.
2. Except when the Gasfluxer is being charged, the reserve tank MUST BE KEPT CLOSED. If it remains open during operation:
(a) Acetylene will enter the reserve tank and escape when the filler cap is removed, or
(b) An excess of flux will enter the Gasfluxer, impeding the flow of gas, and emerge from the torch.
3. Extinguish the torch before removing the filler cap to refill the reserve tank, and make certain that there is no source of ignition in the immediate vicinity
4. Periodically check valves and connections for leakages, as explained under Maintenance Instructions
5. If, for any reason, the Gasfluxer has to be disconnected from the line, make certain that the gas inlet and gas outlet valves are closed to prevent evaporation of the Superior Gasflux
6. The gas inlet valve and gas outlet valves should be kept closed when the Gasfluxer is not in use
7. The Gasfluxer and acetylene cylinders should be kept well away from any possible source of ignition.

