

MODEL INFORMATION

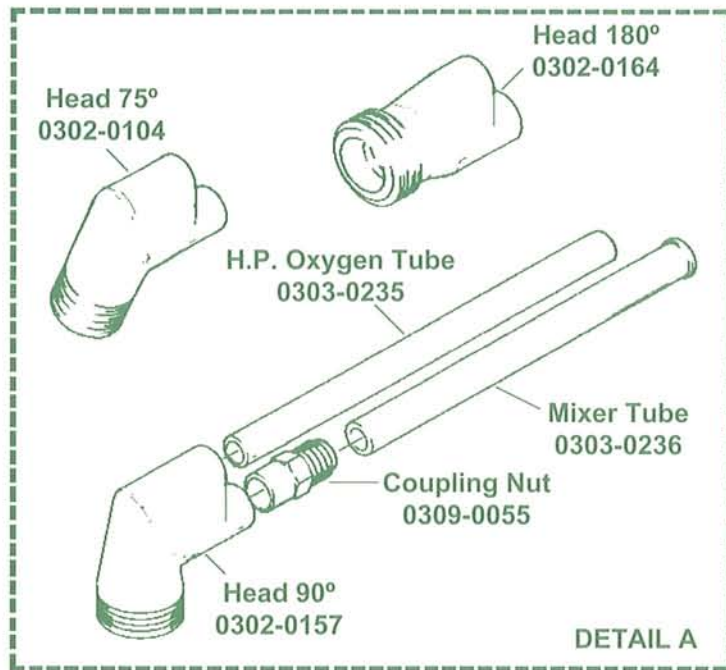
| Cutting Attachment Model Number | Part Number | Head Angle |
|---------------------------------|-------------|------------|
| CA 1260 | 0381-0162 | 90° |
| CA 1350 | 0381-0418 | 90° |
| CA 1351 | 0381-0420 | 75° |
| CA 1352 | 0381-0421 | 180° |
| CA 2460 | 0381-0816 | 90° |
| CA 2461 | 0381-0817 | 75° |
| CA 2462 | 0381-0818 | 180° |
| CA 2470 | 0381-0823 | 90° |

⚠WARNING⚠

Apparatus improperly operated, maintained or repaired can be dangerous. Some parts and accessories manufactured by others may fit VICTOR apparatus but not conform to VICTOR's exacting standards. For your own protection, specify and use ONLY VICTOR-made parts and accessories with your VICTOR apparatus.

Service or repair of VICTOR apparatus should be performed only by a qualified technician. Improper service, repair or modification of the product could result in damage to the product or injury to the operator.

To assure peak performance, VICTOR recommends this unit be examined periodically by a qualified repair technician.



Seat Repair Kit 0390-0016

† Items most commonly used for Cutting Attachment repair and recommended for stock.

* Items included in Repair Kit 0390-0009.

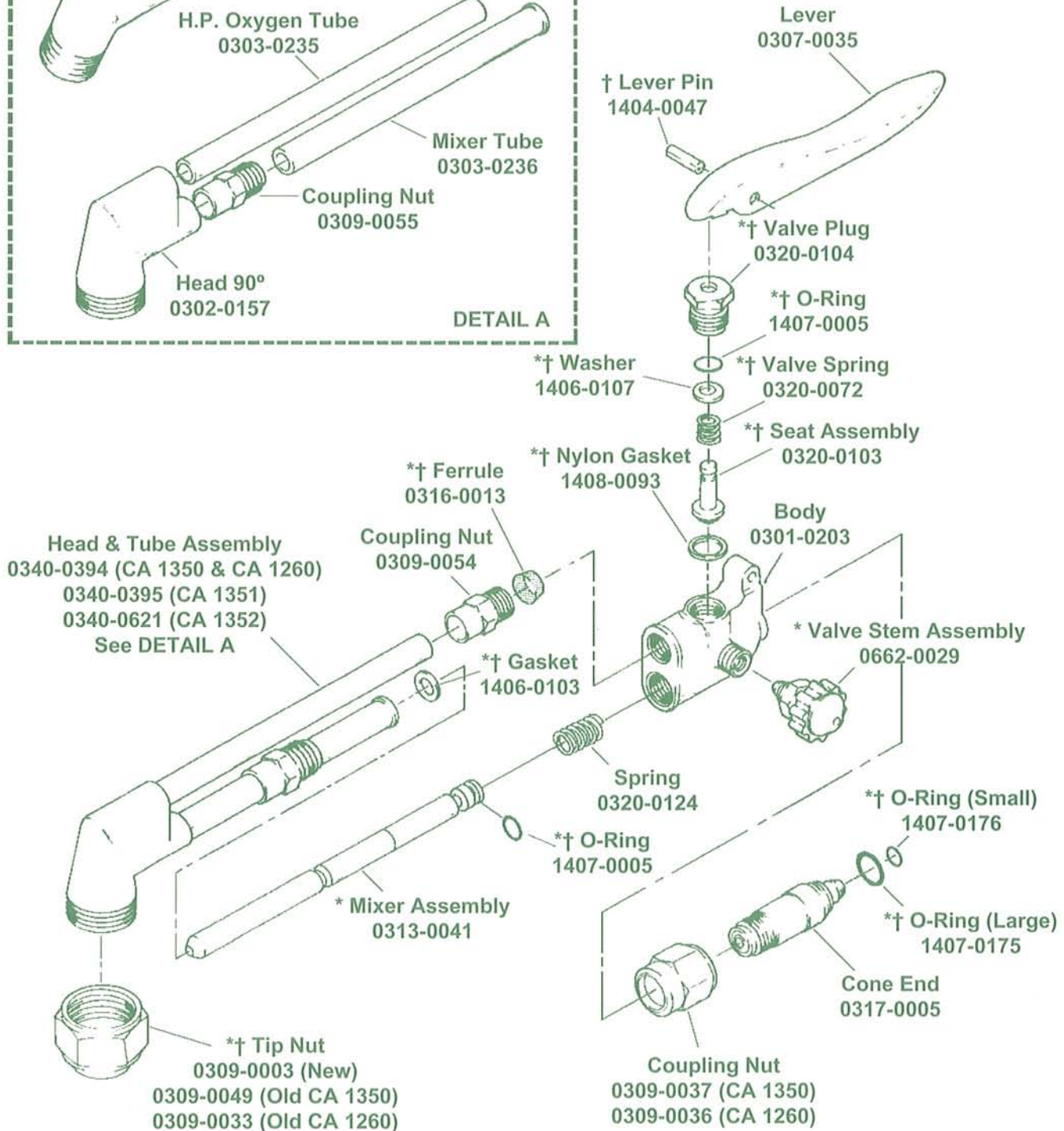


Figure 1: CA 1350 Series and CA 1260 Cutting Attachments

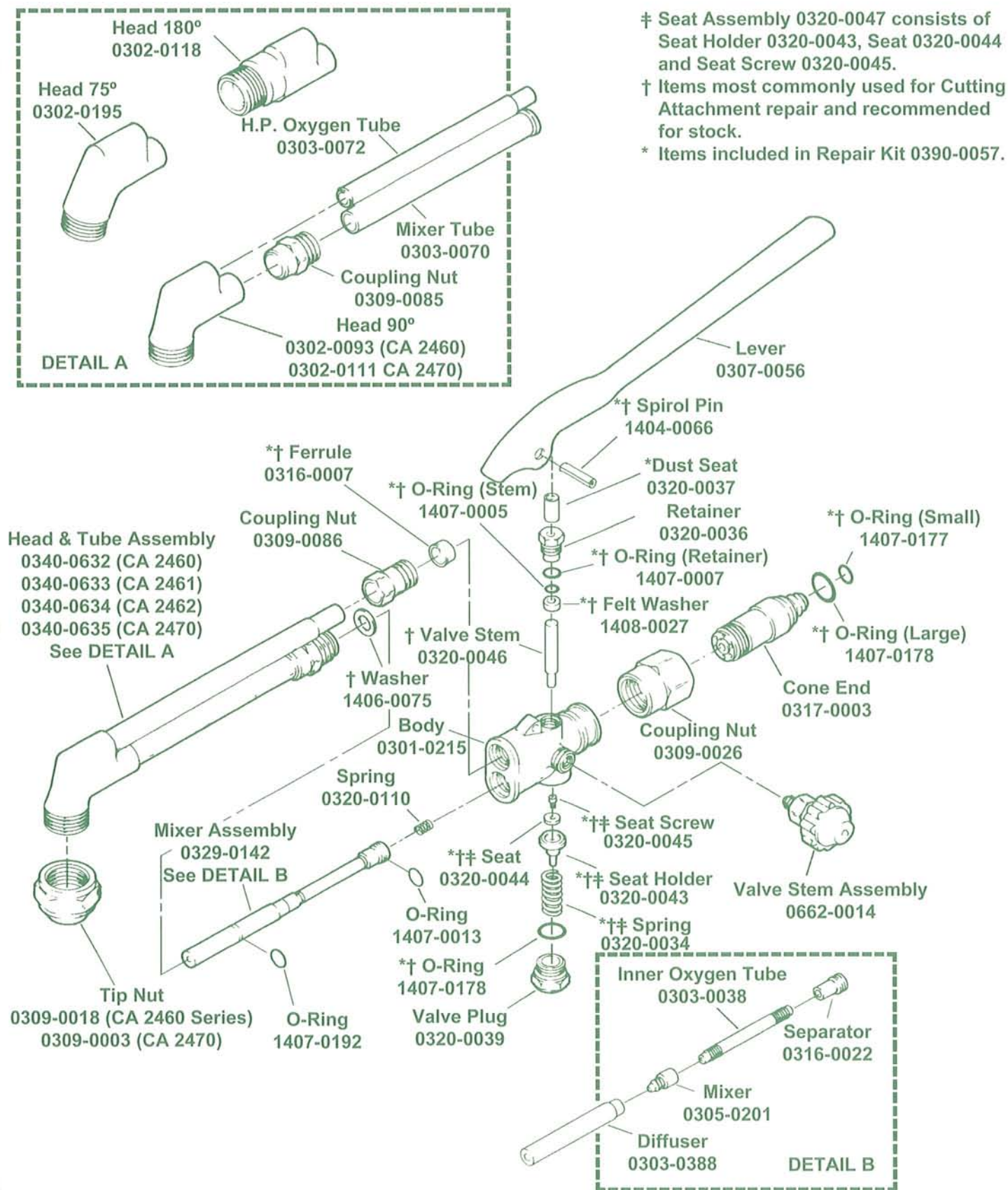


Figure 2: CA 2460 and CA 2470 Cutting Attachments

DISASSEMBLY PROCEDURES

Recommended Tools

CA 1260 and CA 1350 Series

Holding Fixture RT-147
1/2" Open-end Wrenches
5/32" Box-end Wrenches
5/32" Drift Punch
Small Hammer
Cone End Assembly Clamp RT-109
Brazing Torch
Vise

CA 2460 Series

Holding Fixture RT-147
5/8" and 9/16" Open-end Wrenches
7/16" and 11/16" Box-end Wrenches
3/16" Drift Punch
Small Hammer
Cone End Assembly Clamp RT-108
Brazing Torch
Vise

Disassembling the Cutting Attachment

1. Place the Holding Fixture RT-147 in a vise. Place the Cutting Attachment in the Holding Fixture.
2. Remove the Valve Stem Assembly from the Body.
3. To remove the Lever, tap the Spirol Pin lightly with the Drift Punch until it comes free from the Body.
4. **CA 1260 and CA 1350 Series** - Remove the Valve Plug, Washer, Spring, Seat Assembly and Nylon Gasket from the Body. Remove the O-Ring from the Valve Plug. Discard the Nylon Gasket and O-Ring.
CA 2460 Series - Remove the Retainer, O-Ring (Retainer), Felt Washer and H.P. Valve Stem from the Body. Remove the O-Ring (Stem) from the Retainer. Remove the Dust Seal from the H. P. Valve Stem. Discard the O-Rings and Felt Washer. Remove the Valve Plug, Spring and Seat Holder Assembly from the Body. Remove the O-Ring from the Valve Plug. Discard the O-Ring.
5. Loosen the Oxygen Tube Coupling Nut and the Mixer Tube Coupling Nut.
6. Remove the Head and Tube Assembly from the Body.
7. Remove the Ferrule and the Oxygen Tube Coupling Nut from the Oxygen Tube. Discard the Ferrule.
8. Remove the Mixer Assembly from the Mixer Tube. Remove the O-Ring(s) from the Mixer Assembly. Discard the O-Ring(s).
9. **CA 1260 and CA 1350 Series** - Remove the Gasket, Washer and Spring from the Body. Discard the Gasket.
CA 2460 Series - Remove the Spring and metal Gasket from the Body. Discard the Gasket.
10. Remove the Cone End from the Body. Use the Cone End Assembly Clamp and Vise.
11. Remove the Coupling Nut from the Cone End. Remove the O-Rings from the Cone End. Discard the O-Rings.

Disassembling the Mixer Assembly

(CA 2460 ONLY)

12. Disassemble the Mixer Assembly as shown in Detail B of Figure 2, CA 2460 and CA 2470 Cutting Attachments.

Disassembling the Head and Tube Assembly

13. Heat the Tube/Head connections with a brazing torch.
Remove the Tubes from the Head. Remove the Mixer Tube Coupling Nut from the Mixer Tube.

CLEANING PROCEDURES

Contact your local chemical supplier for recommended cleaning solvents applicable to the metals used in this product. Always use cleaning solvents in accordance with the manufacturer's instructions.

⚠WARNING⚠ DO NOT allow nonmetal components (Seat, O-Rings, Dust Seal, Gaskets) to contact cleaning solvents! Cleaning solvents cause elastomeric and plastic parts to swell and stress crack. If these parts require cleaning, use a mild soap solution, followed by a thorough rinsing in water. Dry these parts completely before installing. **REPLACE NONMETAL PARTS THAT HAVE COME IN CONTACT WITH OIL, GREASE OR ANY OTHER PETROLEUM-BASED SUBSTANCE!** Petroleum-based substances become dangerously flammable in the presence of oxygen.

Assembly Procedures

Recommended Tools

CA 1260 and CA 1350 Series

Holding Fixture RT-147
1/2" Open-end Wrenches
5/32" Box-end Wrenches
5/32" Drift Punch
Small Hammer
Cone End Assembly Clamp RT-109
Brazing Torch
Vise
45% Silver Solder
Silver Solder Flux
Loctite #79 (0028-0056)
Christo-Lube 129 (0034-0021)

CA 2460 Series

Holding Fixture RT-147
5/8" and 9/16" Open-end Wrenches
7/16" and 11/16" Box-end Wrenches
3/16" Drift Punch
Small Hammer
Cone End Assembly Clamp RT-108
Brazing Torch
Vise
45% Silver Solder
Silver Solder Flux
Loctite #79 (0028-0056)
Christo-Lube 129 (0034-0021)

Assembling the Head and Tube Assembly

1. Install the Mixer Tube Coupling Nut on the Mixer Tube.
2. Insert the Mixer Tube and the Oxygen Tube into the Head. Make sure the tubes bottom out in the Head. Silver-braze the connections.

3. **CA 2460 ONLY** - Assemble the Mixer Assembly as shown in Detail B of Figure 2, CA 2460 and CA 2470 Cutting Attachments. Tighten securely for a gas tight seal. Use no sealants or lubricants.

Assembling the Cutting Attachment

4. Lubricate the new Mixer O-Ring(s). Install the O-Ring(s) on the Mixer Assembly as shown.
5. Install the new Cone End O-Rings on the Cone End.
6. Place the Coupling Nut on the Cone End. Install the Cone End in the Body. Use the Cone End Assembly Clamp and Vise.
7. Install the Mixer Assembly in the Mixer Tube.
8. Install the Oxygen Tube coupling Nut and the new Ferrule on the Oxygen Tube.
9. Install the Spring and new Metal Gasket in the Body.
10. Install the Head and Tube Assembly in the Body. Apply a small amount of Loctite #79 to the male threads of the Mixer Tube Coupling Nut and the Oxygen Tube Coupling Nut. Tighten the Coupling Nuts.
11. **CA 2460 Series ONLY** - Place the Holding Fixture RT-147 in a vise. Place the Cutting Attachment upside down in the Fixture. Install the Seat Assembly and the Spring in the Body. Lubricate the new O-Ring. Install the new O-Ring on the Valve Plug. Install the Valve Plug in the Body and tighten.
12. **CA 1350 and CA 1260 Series** - Install the new Nylon Gasket, Seat Assembly, Spring and Washer in the Body. Lubricate the new Valve Plug O-Ring. Install the new O-Ring on the Valve Plug. Install the Valve Plug in the Body and tighten.
CA 2460 Series - Install the Valve Stem and new Felt Washer in the Body. Lubricate the new O-Rings. Install the new O-Ring in the Retainer. Install the new O-Ring in the Body. Install the Retainer in the Body and tighten. Place the Dust Seal on the Valve Stem.
13. Secure the Lever to the Body with the Spirol Pin.
CA 1350 and CA 1260 Series - Make sure the Lever tabs fit into the Valve Stem groove.
14. Apply a small amount of Christo-Lube to the end and first few male threads of the Valve Stem Assembly. Install the Valve Stem Assembly in the Body.

⚠WARNING⚠ For your safety and the safety of the operator, always perform the test procedures described in TEST PROCEDURES after reassembling the Cutting Attachment.

If the Cutting Attachment does not perform properly during testing, refer to the TROUBLESHOOTING CHART in the Victor "Apparatus Service and Testing Procedures Manual for Cutting Torches, Cutting Attachments and Torch Handles" (Form No. 0056-0885).

TEST PROCEDURES

Recommended Tools

- Plugged Cutting Tip (See Figure 3)
- 1" or 1 1/8" Box-end Wrench
- Fire Brick
- 30-35 PSIG Source of Oxygen
- 40 PSIG Source of Oil-free Air or Dry Nitrogen
- 3-6 PSIG Source of Acetylene

CA 1260 Series

- J100C Torch Handle
- 1-3-101 Cutting Tip

CA 1350 Series

- 100C Torch Handle
- 1-3-101 Cutting Tip

CA 2460 Series

- 315C Torch Handle
- 1-1-101 Cutting Tip

Leak Testing the Cutting Attachment

1. Attach the Cutting Attachment to a Torch Handle.
2. Attach the hoses to the Torch Handle. Install a plugged Cutting Tip (See Figure 3). Tighten the Tip Nut to a torque of 15 ft-lbs.



Figure 3: Plugged Cutting Tip for Leak Testing

3. Pressurize both the fuel and the oxygen sides of the Torch Handle to 40 PSIG of oil-free air or dry nitrogen.
4. Completely submerge the Cutting Attachment in water. Open the oxygen and fuel control valves on the Torch Handle. Open the Cutting Attachment Valve. Depress the Lever.
 - a. Observe the Cutting Attachment for leaks indicated by escaping bubbles.
 - b. Observe the Cutting Attachment Valve packing nut for five (5) seconds. If bubbles escape from the Head, the Cutting Attachment Valve or Torch Handle fuel valve seat is leaking.

NOTICE To determine the exact location of a seat leak, disconnect the Cutting Attachment from the Torch Handle. Leak test the Torch Handle separately.

Flame Testing the Cutting Attachment

⚠WARNING⚠ For your safety, comply with the requirements given in the Victor "Safety and Operating Instruction for Cutting Attachments, Torch Handles and Heating Nozzles" (Form No. 0056-0138) whenever you operate this apparatus.

5. Attach the Torch Handle hoses to the oxygen and acetylene sources.

6. Install a 1-1-101 Tip (CA 1260) or a 1-3-101 Tip (CA 1350 and CA 1260). Tighten the Tip Nut to 15 ft-lbs. of torque.
7. Adjust the oxygen delivery pressure to 30-35 PSIG. Adjust the fuel delivery pressure to 3-6 PSIG. Open the Torch Handle oxygen valve completely.

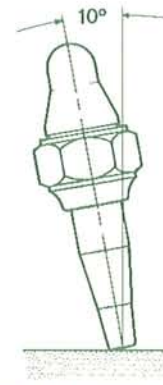


Figure 4: Flame Testing

⚠WARNING⚠ Always purge the cutting oxygen passages by opening the Cutting Attachment valve and depressing the Lever for at least five (5) seconds before lighting the Torch. Release the Lever. Close the valve after purging.

8. Open the Torch Handle fuel control valve one-eighth to one-quarter turn. Ignite the fuel gas. Continue to open the Torch Handle fuel control valve until soot and smoke disappear.
9. Slowly open the Cutting Attachment Valve until a neutral fame is established. Depress the Lever. Adjust the Cutting Attachment Valve until the flame is neutral again.
10. Position the tip on the fire brick at a 10 degree angle as shown in Figure 4. Rock the Cutting Attachment from side to side on the fire brick for 5-8 seconds. The Cutting Attachment should "pop" during this flame test.

11. After testing is complete, release the Lever. Shut off both the Cutting Attachment and the Torch Handle oxygen valves. Then, shut off the Torch Handle fuel valve.
12. When the Cutting Attachment use is complete, shut down the system as recommended in the Victor "Safety and Operating Instructions for Cutting Attachments, Torch Handles and Heating Nozzles," Form No. 0056-0138.

⚠WARNING⚠ If you experience a backfire or back-flash (flame disappears suddenly and/or a hissing sound is heard when the flame is burning inside the Cutting Attachment) immediately turn off first the oxygen valve, then the fuel valve. Allow the Cutting Attachment to cool before using again. If the trouble reoccurs, disassemble the Cutting Attachment. Replace any suspect or damaged parts.

VICTOR REPAIR TOOLS

| MODEL NO. | HEAD DIE | HEAD REAMER | VALVE BODY DIE | VALVE BODY TAP | VALVE SEAT REAMER | H.P. CUTTING SEAT REAMER | CONE END ASS'Y CLAMP | HEAD & TUBE HOLDING FIXTURE |
|----------------------|-----------------------|---------------------|----------------------|----------------------|--------------------|--------------------------|----------------------|-----------------------------|
| CA 1260 | 7/8-20 1422-0106 | RT-58 1420-0093 | 7/16-27 1422-0126 | 5/16-32 1422-0043 | RT-33 1420-0059 | RT-151 1420-0229 | RT-109 1420-0167 | RT-147 1420-0221 |
| CA 1350 3/4" head | 3/4-20 1422-0099 | RT-117 1420-0185 | 7/16-27 1422-0126 | 5/16-32 1422-0043 | RT-33 1420-0059 | RT-151 1420-0229 | RT-109 1420-0167 | RT-147 1420-0221 |
| CA 1350 7/8" head | 7/8-20 1422-0106 | RT-58 1420-0093 | 7/16-27 1422-0126 | 5/16-32 1422-0043 | RT-33 1420-0059 | RT-151 1420-0229 | RT-109 1420-0167 | RT-147 1420-0221 |
| CA 2460 Series | 15/16-18 1422-0114 | RT-57 1420-0086 | 1/2-27 1422-0075 | 5/16-32 1422-0043 | RT-33 1420-0059 | RT-105 1420-0163 | RT-108 1420-0166 | RT-147 1420-0221 |
| CA 2470 | 7/8-20 1422-0106 | RT-58 1420-0093 | 1/2-27 1422-0075 | 5/16-32 1422-0043 | RT-33 1420-0059 | RT-105 1420-0163 | RT-108 1420-0166 | RT-147 1420-0221 |

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