



Installation and start-up made easier by an efficient and optimal conceiving.

- One adjustment knob
- One inlet valve and one outlet valve.
- Possible maintenance without unavailability of the regulator.
- Robust and stable.

Exists for « Building sites » for temperatures below 10°C

Suitable with all kinds of gas (Propane, town gas, acetylene, tetren)

Humid gas (propane, town gas) will need to be dried up with a scrubber placed before the FLUXOGAZ

To check possible leakage, use a leak detector (DETEC'FUITE ref. M005012).

⚠ No cleaning or maintenance operation shall be carried out with the regulator under pressure.

It is strictly forbidden to remove or alter the non-return security equipment.

⚠ No maintenance or adjustment operation shall be carried out prior to the reading and understanding of this manual's instructions.

⚠ Do not use this flow regulator with a gas pression higher than 0,5÷0,6 bars.



Liquid for FLUXOGAZ.

Hermetical plastic container with a gauge.

Exists in 9 different concentration rates
10 liter plastic containers.

Exists in a non-toxic version
Reference with an E

Use leadtime: 2 years

MAINTENANCE AND USER GUIDE

Flow regulator

Model: E

Part Nr : _____



Delivery and/or installation date: _____

Owner or User:

Name _____

Address _____ *Tel :*

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1.0. PREFACE

The present manual is aimed at the operator and is an integrated part of the flow regulator. It contains the necessary information for its functioning and maintenance.

The user must carefully read it before the installation. Moreover we suggest you to contact the supplier for any further information you may require on the user guide, spare parts and accessories.

Copy of the present manual must always remain at the operator's disposal for consultation.

1.1. Consultation Guide

Pay attention to this symbol, it shows the most dangerous operations and situations.



This symbol points out a very important recommendation or note.



All safety rules are important and must be carefully respected.

1.2. Identification notes

The necessary identification notes are written on the plate placed on the upper part of the regulator as shown on fig. 1.



fig. 1

➔ Do not alter the identification notes.



It is highly recommended that the plate and dangerous symbols remain clean and in a good condition. Plate must be replaced if needed.

1.3. Use of the flow regulator

This flow regulator has been designed only to bring deoxidant during torch brazing. Any other way to use the flow regulator is considered against appointed use.

The flow regulator is mainly composed by:

- Liquid flux tank
- Group of regulation valves.
- Safety valve.

The flow regulator can only be used by people aged more than 18 years.

It must be used by staff familiar with its particular characteristics and the main safety procedures.

The flow regulator must NOT be used in an environment with explosive atmosphere

Accident precautionary rules and any other safety measures must always be strictly observed.

Any arbitrary changes made at the flow regulator exclude the producer's responsibility for possible damages.

2.0. WARRANTY

Warranty doesn't work if

- The instructions in the present manual are not respected.
- Modifications are introduced without the preventive authorization of the producer.
- Planned maintenance is neglected.
- The flow regulator is used in a different way from this manual's instructions
- The original parts have been replaced by other parts of different manufacture.

Warranty is recognized for a period of 12 months from delivery date. Warranty is only applicable once our technical department has inspected the default and its causes and agreed to apply warranty. If our technical department refuses warranty, an estimate for repair cost will be provided to the customer.

Customer must verify at delivery time that the flow regulator meets the contract's terms and that it hasn't suffered any damage during transport.

3.0. SAFETY RULES

The flow regulator can only be used by qualified personnel who must read in advance this manual's instructions and respect them.

Before starting working it is necessary to familiarize with the flow regulator's controls as described in this manual.

This flow regulator must not be used at higher pressure than instructed (**max 0,6 bars**).

Never use the flow regulator improperly.

Suitable clothes must be worn as established in this manual and in respect of the local laws of the country in which the regulator is used.

Large clothes, belts, rings and chains must be avoided and long hair must be put in a cap.

Do not use lubricant on the valves. Use a leak detector to check possible leaks (**DETEC'FUITE ref. M005012**).

 **Never proceed to any maintenance or repair when the flow regulator is under pressure.**

It is forbidden to remove or tamper the safety device.

 **This manual's instructions must be read and understood before proceeding to any maintenance or adjustment on the regulator.**

Periodical maintenance operations must be scrupulously respected as reported in this manual to work in safety and to keep the regulator efficient.

In order to avoid accident, check that the safety labels are in a good condition and learn their significance. If safety labels are deteriorated or missing, they must be replaced by original ones that need to be requested to the producer and placed them in the position described in this manual.

 **In case of fire, use dry powder extinguisher.**

It is useful to remind that the best safety against any accident is a cautious operator in a good condition.

Danger symbols shown below (see fig. 2) are specified on the outside of the regulator.

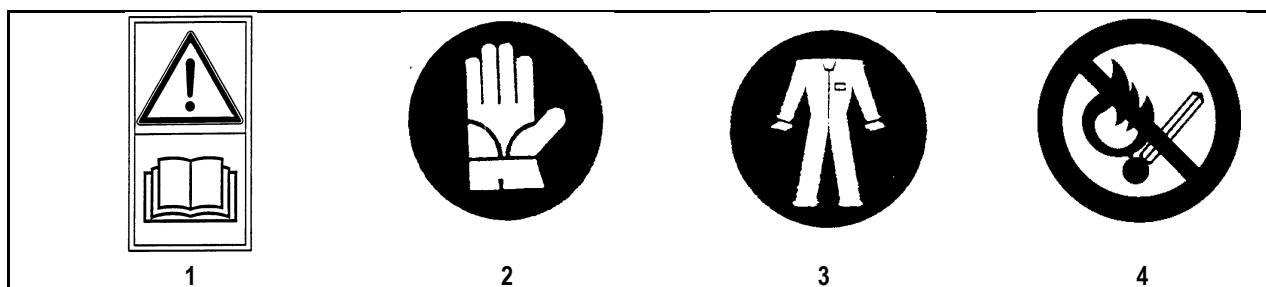



fig. 2

 **Do not use the regulator with a gas pressure higher than 0,5÷0,6 bars.**

- 1) Read the manual before using the flow regulator
- 2) Gloves must be worn.
- 3) Suitable clothes must be worn.
- 4) Do not use any free flame.

4.0. USE OF THE FLOW REGULATOR

4.1. Advice and controls before operating

Operation must be carried out by experienced staff.

Check the good condition of the regulator and its correct position (vertical).

Check that the regulator is connected in series with the gas tube (Acetylene, Propane, Hydrogen, etc.).

Pay attention to the compulsory sense of the gas as indicated by an arrow printed on the valves.



Make sure that the non-return valve is correctly placed on the gas tube which brings both gas and deoxidant in order to avoid back fire of the tank.

4.2. Filling-up

Operation must be carried out by experienced staff.



It is strictly forbidden to use free flame or to smoke during operation as all types of deoxidant are highly inflammable.



Scrupulously follow the present manual's instructions.

Turn off the gas supply cylinder, close the flow regulator's valve 2, the valve must be in a horizontal position (see fig. 3).

Discharge the gas pressure keeping the torch open (if possible switched on) rather than switch off the torch and valve Nr 3.

Unscrew cup Nr 4 after checking that the gas pressure has been released.

Put in about 1 liter of deoxidant (possibly up until the lower part of the cap) and close the cap tightly.

Proceed to necessary adjustment.

4.3 Adjustment

The valve group is suitable to get the best supply of the flux in the flame of the deoxidant.

Valves 2 and 3 must be completely open (vertical position) and valve 1 must be completely closed to get optimal erogation of the flux

Deoxidant concentration is reduced by gradually opening valve 1 (until the right adjustment is achieved).

Gas can go through directly without deoxidant when valve 1 is open and valves 2 and 3 closed (horizontal position).

⚠ Keep the regulator in an upright position when operating. Do not turn it upside down.

4.4. Switching off

Once brazing is finished, switch off the gas cylinder's reducer and valve **2**, discharge the gas pressure by keeping the torch open and turn off valve **3**.

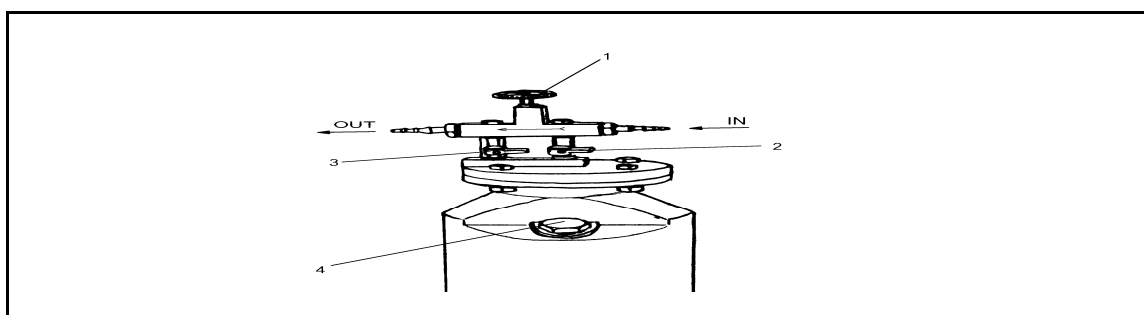


fig. 3

5.0. MAINTENANCE AND REPAIR

Maintenance must be carried out by qualified staff in observance of the manual's instructions.



Take all necessary precautions before starting maintenance operation, discharge the gas pressure, remove the supply tube, clean off the work area and use suitable tools in good condition.

Intervention time below reported refers to normal use conditions. If the flow regulator is subject to important work times, the time should be consequently reduced.

Each month: Open valves and clean with compressed air.

Every 6 months: Remove the upper cover, clean the inside of the regulator and make sure that the inside is very dry before closing and that the gasket is in good condition.

6.0. INACTIVITY

After a long time of non-use and before using the regulator again, it is necessary to :

- carefully check the flow regulator and replace damaged parts
- carefully check the condition of the screws and bolts
- carefully clean all parts subject to oxidation

7.0. PACKING AND TRANSPORT

The flow regulator is packed in a carton box that must be evacuated in the dedicated bin.

Transport can be carried out by simple staff.

7.1. Installation

Operative environmental conditions

The flow regulator must be used in the following environmental conditions:

	min	max	suggested
Temperature °C	5	35	18

Flow regulator must be placed far from the brazing area and other areas with free flames.
It is strictly forbidden to smoke during filling-up operation.

7.2. Technical characteristics

Weight (kg)	Width (mm)	Height (mm)	Length (mm)
8.5	230	430	220

8.0. EVACUATION AND SELLING OFF

Flow regulator does not contain any dangerous component for human health or environment as it is produced with materials that are completely recyclable or that can be normally evacuated.

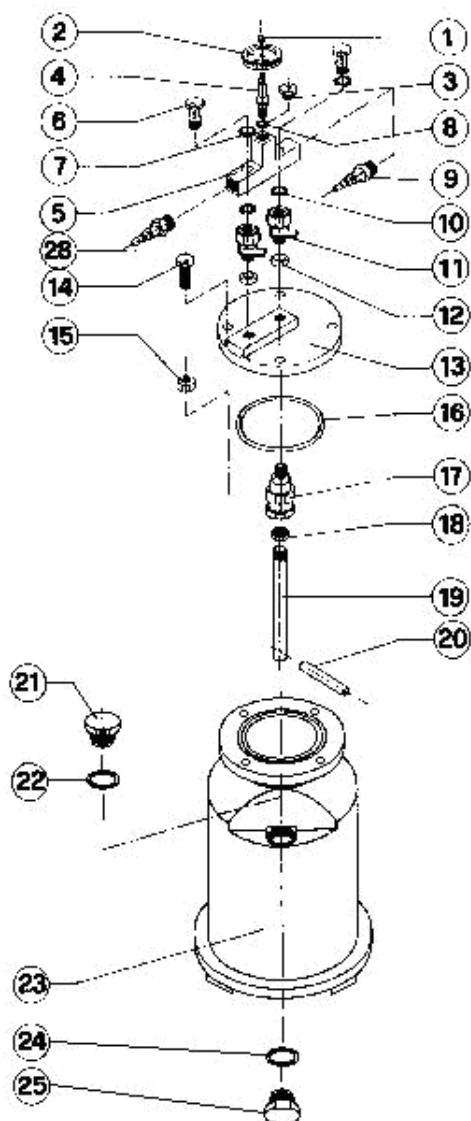
Therefore pay high attention and take precautions for the regulator's destruction when it has come to the end of its life:

- After removing deoxidant, give the flow regulator to a specialized company in non-ferrous scrap disposal following the country regulations.

ANNEX A

THE FOLLOWING PART OF THIS MANUAL
IS RESERVED AS SUPPORT TO
SPECIALIZED STAFF SPECIALIZED IN
MAINTENANCE AND TECHNICAL SUPPORT

Drawing and list of spare parts



SPARE PARTS LIST

1	M5 hexagonal blind nut	X00005
2	Whell	X00006
3	Pin seat	X00007
4	Regulation pin	X00008
5	Outlet feed body	X00009
6	Inlet-Outlet gas screw	X00010
7	Inlet-Outlet gas screw gasket	X00011
8	O-ring	X00012
9	Inlet-Outlet gas connection	07650027 07651026 08550010
10	Upper spherical valve gasket	X00011
11	Spherical valve	X00015
12	Lower spherical valve gasket	X00011
13	Tank body flange	X00016
14	M10x40 UNI 5739 screw	X0000414
15	M10 UNI 5588-65- Rondelle M10 screw nut	X0000415
16	O-ring	X00017
17	Non-return valve	08550110
18	M 14x1 screw nut	X00038
19	Inlet gas tube	X0000419
20	Transverse tube	X0000426
21	Inlet cap	08550022
22	Inlet cap gasket	08550015
23	Tank body	X0000323
24	O-ring	X00026
25	Blind nut	X00027
28	Inlet – Outlet gas connection	07650027 07651026 08550010

Non-return protection valve**Material:**

Body	brass OT 58 UNI 2164
Connection	brass OT 58 UNI 2164
Obturator	brass OT 58 UNI 2164
Spring	Stainless steel
Sealing ring	EPDM

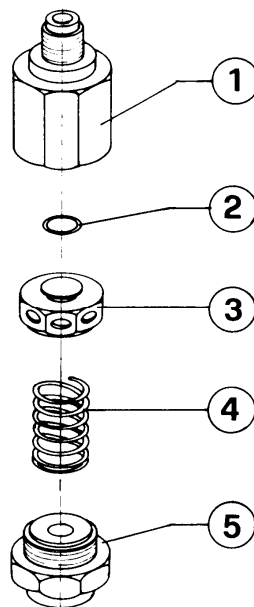
Functioning:

Valve normally closed.

It allows the gas flow in one direction. Pressure must be over 0.5 bar in order to win against the power of antagonist spring.

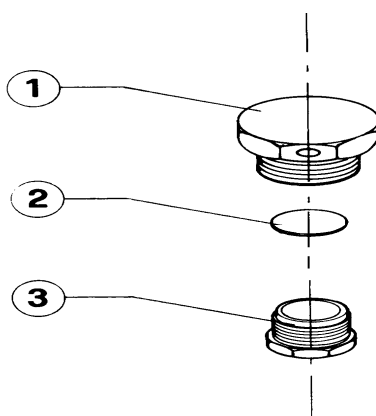
The spring pushes the shutter to stroke end at the faintest counter-pressure and it stops the flow through the sealing ring.

PARTICULAR N° 17



1	Non-return valve body
2	O-Ring
3	Spring seat
4	Spring
5	Closure valve screw nut

PARTICULAR N° 21



1	Cup body
2	Plate
3	Plate screw nut