

- 6.3. Close the cutting torch valves and regulate the pressure of the cylinder pressure regulators. Blow out the hose and the cutting torch by briefly opening the cutting oxygen valve.
- 6.4. Open the preheating oxygen valve 1/10 of the way and the gas fuel valve half-way, ignite the gas mixture. Adjust a proper working flame with the cutting torch valves.
- 6.5. Heat the metal edge with the cutting torch flame until it is white hot. Open the cutting oxygen valve to supply oxygen into the heating area and cut the metal.
- 6.6. Turn off the gas supply in reverse order: oxygen first, gas fuel next. When the fire goes out, close the cylinders valves. Gradually open the cutting torch valves and bleed the gases from the hoses. Set the pressure regulators at zero by unscrewing the adjusting valve to the loose position.
- 6.7. In case of continuous claps or a backfire, immediately close the gas fuel valve, then the oxygen valve and let the cutting torch cool down.
- 6.8. After a backfire purge and blow out the mixing device and the nozzles, tighten the nozzles and the nuts, check the cutting torch hermeticity.

7. MAINTENANCE AND REPAIR

- 7.1. Keep the cutting torch clean, on a regular basis purge the nozzles from deposit and metal splashes with an emery cloth or a small file.
 - 7.2. To increase the product service life it is recommended to perform maintenance works once in three months. Checkups must be conducted for: 1) connection tightness, 2) suction in the gas fuel connection unit (injection), 3) burning with a cutting oxygen flame jet.
 - 7.3. Purge the nozzle passages with special needles – any contamination may adversely affect the cutting torch performance.
 - 7.4. Prevent any damages to the sealing surfaces in the cutting torch head. All repair works must be conducted solely by the manufacturer or an authorized service.
- Warranty repair is done by the manufacturer within one month after the defective goods warranty return.

8. MANUFACTURER'S WARRANTY

The manufacturer ensures the cutting torch compliance with ISO 5172 requirements subject to the consumer's respect of the service, transportation and storage instructions.

Warranty period is 12 months from the date of commissioning but no more than 24 months from the delivery date. Production year is indicated at the cutting torch shank under the straps.

DONMET plant performs warranty repair works, i.e. free defect elimination within the warranty period.

Free warranty repair is not performed if:

- 1) the product was not used in accordance with the operating instructions (p. 6) and technical specification requirements (table 1);
- 2) the product was misused or used negligently resulting in mechanical or other damages;
- 3) the cutting torch design was modified at the consumer's own discretion.

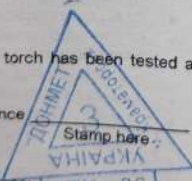
The warranty does not cover spare parts indicated in table 3.

8. TEST CERTIFICATE

The cutting torch complies with ISO 5172 requirements. The cutting torch has been tested and proven fit for service.

Date of issue **2025**

QC department acceptance



Manufacturer's address: 187A Yabluneva str., Verkhodniprovsk, Dnipropetrovsk region, 51600, Ukraine

"DONMET"

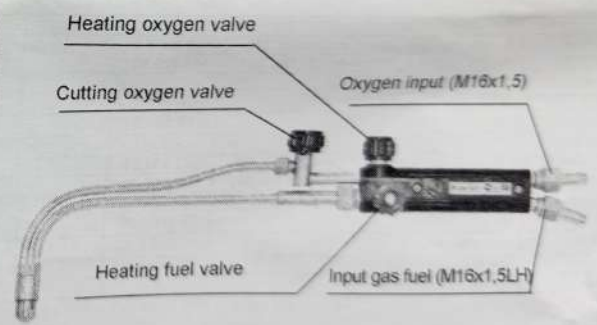
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