



Adjustable Duplex Tip Holder

INSTALLATION, PARTS AND OPERATION INSTRUCTIONS

Before Installing or Operating, Read and Comply with These Instructions

Controls Corporation of America
1501 Harpers Road Virginia Beach, VA 23454
To Order Call 1-800-225-0473 or 757-422-8330 • Fax 757-422-3125
www.concoa.com

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USER RESPONSIBILITY

This equipment will perform in conformity with the description contained in this manual and accompanying labels and/or inserts when installed, operated, maintained, and repaired in accordance with the instructions provided. This equipment must be checked periodically. Improperly working equipment should not be used. Parts that are broken, missing, worn, distorted or contaminated, should be replaced immediately. Controls Corporation of America (CONCOA) recommends that a telephone or written request for service advice be made to CONCOA Customer Service in Virginia Beach, Virginia, PHONE: 1-757-422-8330 or TOLL FREE in the US and CANADA 1-800-225-0473, FAX: 1-757-422-3125, or E-MAIL: info@concoa.com.

This equipment or any of its parts should not be altered without prior written approval by CONCOA. The user of this equipment shall have the sole responsibility for any malfunction that results from improper use, faulty maintenance, damage, improper repair, or alteration by anyone other than CONCOA or a service facility designated by CONCOA.

USER RESPONSIBILITY

In the event of equipment failure, call the CONCOA Customer Service Line: 1-757-422-8330 or TOLL FREE in the US and CANADA 1-800-225-0473. Please be prepared to provide the model number and serial number of the equipment involved, in addition to some details regarding its application.

SAFETY

Comply with all applicable precautions in the ADI 1647 torch instruction manual and this manual. **WARRANTY AND USER RESPONSIBILITIES** in the ADI 1647 torch instruction manual apply to this HOLDER.

INTRODUCTION

This manual provides installation operation, service, and parts information for the Adjustable Duplex Tip Holder. The Holder is used on 4700 machine cutting torches to permit two simultaneous, parallel cuts 1-1/4 to 12 inches apart. It can be used to cut material thickness up to 3 inches. It permits concentric circle cuts when the torch is mounted on cutting machine equipped for circle cutting.

The Holder may be used in a Series 4700 torch with any 3/4 inch 3-land; CONCOA/AIRCO style cutting tip.

The Holder's three major parts are: a torch head connector with a tip nut; a 90 degree cutting head on a fixed arm (attached to the connector); and a similar head on a swivel arm. A locknut sets swivel arm to fixed arm.

INSTALLATION

- a. Install required tips in Holder heads and tighten tip nuts with proper wrench.
- b. Install holder in torch loosely, position fixed arm head to desired position and tighten tip nut with wrench. Do NOT loosen lower nut for fixed arm adjustment; use tip nut.
- c. Slightly loosen bottom locknut just enough to adjust swivel arm to desired position and retighten (locknut also compresses O-rings to seal the swivel joint).
- d. Position tips over plate edge so both cuts will start simultaneously.

OPERATION

Adjust gas pressure regulators the same as for standard tips BUT add 5% more cutting oxygen pressure. Avoid small flames which may cause tip overheating and backfiring.

CAUTION

**DO NOT adjust arms or loosen locknut while gases are flowing.
Avoid heat deflection onto swivel joint.**

SERVICE

IMPORTANT

Checking or repair of this equipment may be undertaken only by persons experienced in similar equipment repair.

CAUTION

Shut OFF gas supplies and remove Holder from torch before attempting service.

Maintenance Tips

- a. Keep swivel joints clean.
- b. If joints leak, check O-rings for damage or wear. Replace if necessary.

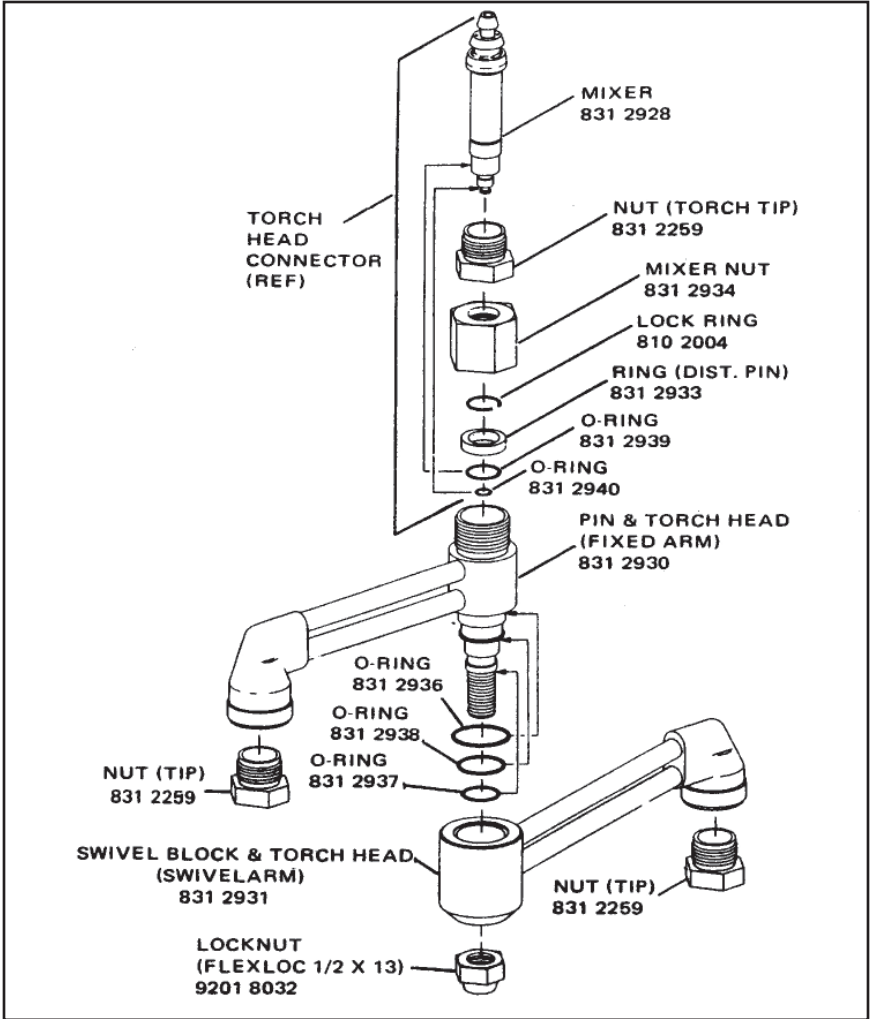
Parts Replacement

Use parts illustration to aid in parts replacement disassembly:

- a. Remove locknut to remove swivel arm.
- b. O-rings should be seated in three shoulders in bottom swivel shaft cavity. **DO NOT** lubricate PTFE O-rings.
- c. Remove mixer nut (below tip nut) for replacement of torch head connector parts or fixed arm assembly.
- d. Be sure parts are clean before reassembly.

CUSTOMER SERVICE

In the event of equipment failure, call the CONCOA Customer Assistance Line: 1-800-225-0473. Please be prepared to provide the model number and serial number of the equipment involved, in addition to some details regarding its application.



Replacement Parts



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