

oxikit

555C - 555CA12 - 555D - 555DA12
555K - 555KA12 - 555KM
555KMA12 - 555H400 - 555H400K



MANUALE PER L'UTILIZZATORE • NOTICE D'UTILISATION
USER MANUAL • РУКОВОДСТВО ПО ЭКСПЛУАТАЦИИ
GEBRUIKSAANWIJZING • NUTZERHANDBUCH
NÁVOD K POUŽITÍ • MANUAL DEL USUARIO
KÄYTTÖOHJE • MANUAL DO USUÁRIO
KASUTUSJUHEND • NAUDOTOJO VADOVAS
ANVÄNDARHANDBOK • BRUKERHÅNDBOK
PODRĘCZNIK UŻYTKOWNIKA • LIETOŠANAS PAMĀCĪBA
MANUALUL UTILIZATORULUI • KORISNIČKI PRIRUČNIK
ΕΓΧΕΙΡΙΔΙΟ ΟΔΗΓΙΩΝ - ІНСТРУКЦІЯ З ЕКСПЛУАТАЦІЇ



KEMPER
G R O U P

IT

FR

GB

RU

NL

DE

CZ

ES

FI

PT

EE

LT

SE

NO

PL

LV

RO

HR

GR

UA

	GAS		OXYGEN	
				
555C - 555CA12*	580 - Novacet		571 (M10x1) - l 110 *571A12 (M12x1) - l 110 non-rechargeable	 594 - Ø 0,65 593 - Ø 0,50
555D - 555DA12*	575 - Supergas			
555K - 555KA12* 555 KM 555KMA12*	581 - Kemap			
555H400	580 - Novacet		585H400 - 400 l rechargeable	
555H400K	581 - Kamap			

GAS						
						
	580 (330g)		575 (330g)		581 (385g)	
594	7h	47 g/h	7h	47 g/h	8 h	47 g/h
593	9h 30'	35 g/h	9h 30'	35 g/h	11 h	35 g/h

OXYGEN				
				
	571 (100 l) - 571A12 (110 l)		585H400 (400 l)	
594	1h	120 l/h	4	120 l/h
593	1h 30'	80 l/h	6	80 l/h

USER MANUAL

PLEASE READ CAREFULLY THESE INSTRUCTIONS BEFORE USING THE EQUIPMENT. REFER TO THIS MANUAL WHEN NECESSARY.

The appliance must not be tampered. The installation and the adjustment carried out at the plant must not be modified. It can be dangerous trying to modify, remove parts or use components different from those recommended. The appliance must be used by competent personnel and in compliance with safety regulations in force.

Our appliances are supplied complete with one oxygen cartridge and one gas cartridge both charged and ready for use.

Recommendations:

- It is strongly recommended to use only original KEMPER items (see table at the beginning).
- Using different types of gas containers can be dangerous.
- Switching on the device only after having prepared the material to be welded.
- Work with a correct mixing of oxygen and gas in order to optimize consumption.
- Do not connect containers before reading instruction and recommendation mentioned on them.
- If you work in close proximity to other people, point out the working area.
- DO NOT smoke during all the operations of preparation, use, and maintenance.
- Connect the containers in a well-ventilated area, free from flames or fire sources, and away from other people.

Before connecting containers:

- Place the equipment in a stable position and appropriate in order to avoid falls.
- Check that the seals of the connecting joint, if are present, are placed correctly and are not damaged.
- Ensure that flexible hoses are not damaged.
- Do not use a machine with any damage or has damaged components.
- Close the valves of the device before connecting containers.

HOW TO CONNECT AND USE THE EQUIPMENT

1. Verify that welding torch stopcocks are safely closed before starting:
 - **for oxygen** ensure that: on models 555C – 555CA12 – 555D – 555DA12 – 555K – 555KA12 – 555H400 – 555H400K: regulator is completely tightly closed by turning the adjusting screw anticlockwise; on model 555KM - 555KMA12 (with manometers): regulator is completely tightly closed by turning the adjusting screw clockwise;
 - **for gas (on all the models)**: ensure that regulator is tightly closed by turning the orange adjusting screw clockwise;
1. Screw the two reducers on related cartridges (clockwise rotation), after they have been removed from the support; replace the cartridges when operation took place; CAUTION: It is recommended to screw the regulator of gas on the GAS cartridge **without forcing tightening**. The two seals (one positioned on the cartridge and one on the adaptor) guarantee a perfect seal without effort. An excessive tightening involves a deformation of the valve with consequent resulting missing emission of gas. Fig A and B, in condition B the cartridge is no longer usable)



2. Open the oxygen, by turning clockwise, to its end point, the adjustment handwheel placed on the oxygen cylinder. Turn on the gas, by turning anticlockwise, the orange handwheel placed on the gas cylinder;
3. At this point, open the torch screw with the word "GAS", bring the lance close to a flame and adjust it so that the flame that comes out from the spout remains attached to it.
4. Slowly open the oxygen screw until the flame becomes light blue. An excessive emission of oxygen can cause the flame to detach. If this happens, close the oxygen and gas stopcocks and repeat steps from point (3).

IMPORTANT NOTE: before turning on the flame ensure all necessary parts have been properly connected. Check for hose leaks by using appropriate bubble detectors (see items no. 1726) or a solution of water and soap

(DO NOT CHECK FOR LEAKS BY USING A FLAME). Repeat this check procedure every time a cylinder is replaced. Do not use the appliance when leaking, damaged or malfunctioning. If you detect a leak in the equipment (gas smell), bring it immediately outside, in a well-ventilated area with no flammable sources, where you can find and stop the leak.

DURING USE:

- Always extinguish the flame before placing torch on a surface.
- Ensure that flexible hose is not bent.
- NEVER point the flame towards containers (they should never get hot), flexible hoses (they can burn) and to yourself or other people.
- Do not operate the equipment in space-constrained sites.
- The structure of the device must work on a horizontal surface.
- Use the equipment outside or in a well-ventilated place.
- Work only in a safe and clean area, away from oily and combustible materials, and fire hazards.
- Wear necessary equipment for eyes protection.
- Do not wear clothes greasy dirty.
- Avoid inhaling welding/brazing fumes.
- It is recommended to wear protective gloves that avoid burns when handling hot materials and equipment; allow the welded material and the components to cool down before touching or moving them to a different location.
- Given the possibility of projection of overheated material, it is recommended to use gowns or aprons for the protection of the body.
- Do not try to move the equipment by pulling the hoses.

Some instructions on how to use cylinders:

Cylinders are pressure containers of flammable material and special attention needs to be paid when using them, in particular:

- Do not expose to direct sun rays and temperatures over 50°C.
- Do not pierce or burn after use.
- Discard only when completely empty.
- Do not spray over hot or incandescent material.
- The oxygen cylinders 571 and 571A12 are disposable units, so DO NOT refill them.
- The oxygen cylinder 585H400 is rechargeable. It must therefore be recharged only by the supplier; filling done differently can lead to serious accidents.

EXTINGUISHING THE FLAME:

For temporary interruptions of work:

- To extinguish the flame, always close the gas stopcock first, then close the oxygen stopcock located on the torch grip.
- Do not maintain the pipes under pressure.
- Allow the torch to cool down before touching it or placing it on a surface; always place the nozzle on appropriate non-flammable stand.

For storing the equipment for a long time:

- To stop gas flow, close the screw located on the gas cylinder inlet valve.
- Close the gas stopcock located on the torch grip.
- Close the oxygen stopcock.
- Disconnect containers.
- Maintain cylinders always in vertical position.

STORAGE AND TRANSPORT CONDITIONS

- Disconnect containers if the equipment is not used for a long time period or in case of transport with vehicle.
- Ensure containers are always in a vertical position during storage and transport operations.
- Keep away from children.

MAINTENANCE

- Use only original replacement parts.
- Never use the equipment if any components appear damaged.
- IMPORTANT NOTE: do not carry out any type of operations on single parts of the appliance; it may result in serious risks for the user. If the equipment does not function properly, contact your local sale representative or KEMPER's support service – Via Prampolini 1/Q – 43044 Lemignano di Collecchio (PR) – Tel +39 0521 957111 – Fax +39 0521 957195.

- Carefully follow instructions provided during maintenance operations.
- For maintenance and storage of protective glasses, see the instructions for use provided with them.
- To replace oxygen and gas cylinders it is recommended to:
 - a. Ensure that the cartridge is empty before replacing it;
 - b. **For oxygen**
 on items 555C – 555CA12 – 555D – 555DA12 – 555K – 555KA12 – 555H400 – 555H400K: close completely the regulator by turning the adjusting screw anticlockwise;
 on item 555KM - 555KMA12 (with manometers): close completely the regulator by turning the adjusting screw clockwise;
 - c. **For gas (on all the models):** close completely the regulator by turning the orange screw clockwise;
 - d. Unscrew the empty cylinder;
 - e. Screw the new cylinder and repeat steps from point (3) of the instructions for use;
- To replace the tip of the torch, unscrew the mounted tip and screw in the desired one.

Important note: NEVER use grease or oil on parts that come into contact with oxygen

Consider the following cases of malfunctioning:

1. The flame suddenly extinguishes and you can hear a loud blast due to a sudden obstruction of bit nozzle, this blast is generated by the ignition of gas blend within the bit. The easiest solution is to allow the corpuscle to come out from the nozzle by rubbing the bit on an appropriate tablet. If this is not successful, you should allow the torch to cool down, then remove the bit and clean its inner part with proper material that does not scratch its brass surface. Scratches can alter the nozzle material characteristics.
2. You hear several consecutive blasts, this is due to bit overheating after a long use of the equipment. High temperature causes the gas blend to pre-ignite within torch. You should stop your work until bit has completely cooled down. If you cannot interrupt your work, close the acetylene stopcock to allow oxygen flow and quick torch cooling.
3. In case of a leaks, check that all stopcocks are closed; check that all components are properly connected and repeat all start-up operations. If leakage persists, disconnect gas and oxygen cylinders and replace them with appropriate replacement parts.
4. If flame is unsteady or detached, adjust gas supply by closing the oxygen stopcock and repeating all steps from point (3).

Important note: if filler metals are used, joint has to be deoxidized with specific materials.

SAFETY

Welding equipment regulators ensure supply at a low and constant pressure. In addition, the equipment has two non-return valves that ensure equipment safety.

WHAT TO DO IN THE EVENT OF A FIRE

Immediately close oxygen cylinder, this should be enough to extinguish the flame.

Close gas cylinder as well and extinguish fire with appropriate fire-fighting equipment.

RU

РУКОВОДСТВО ПО ЭКСПЛУАТАЦИИ

ВНИМАТЕЛЬНО ПРОЧИТАЙТЕ ДАННУЮ ИНСТРУКЦИЮ ПЕРЕД ТЕМ, КАК НАЧНЕТЕ ПОЛЬЗОВАТЬСЯ ИНСТРУМЕНТОМ. ПЕРЕЧИТЫВАЙТЕ ЕЕ, ЕСЛИ ЭТО НЕОБХОДИМО.

Не повреждайте оборудование. Изменение, удаление компонентов и / или использование частей, не рекомендованных производителем, может быть очень опасно.

Убедитесь в том, что оборудование используется только квалифицированными специалистами, а также соблюдаются все законы безопасности труда.

Данное оборудование поставляется с одноразовыми кислородными баллонами (белый, арт. 571 или 571A12) и газовым баллоном NOVACET (красный, арт. 580), газовым баллоном SUPERGAS (оранжевый, арт. 575), а также газ. бал. KEMAP 58, все заправлены и готовы для работы.

Строго рекомендуется использовать только оригинальные сменные части KEMPER, арт. 571 или 571A12 (кислородный баллон), арт. 580 (баллон NOVACET), арт. 575 (баллон SUPERGAS), арт. 581 (баллон KEMAP), а также оригинальные запчасти. Использование различных видов газовых баллонов может быть опасно.