

# FLAME ADJUSTMENT



**LEAN**



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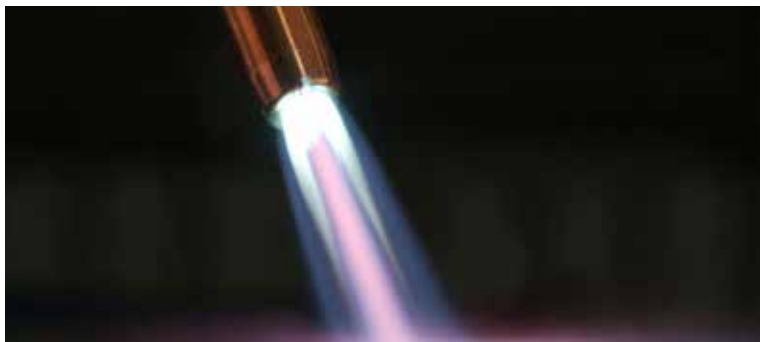
**LEAN**



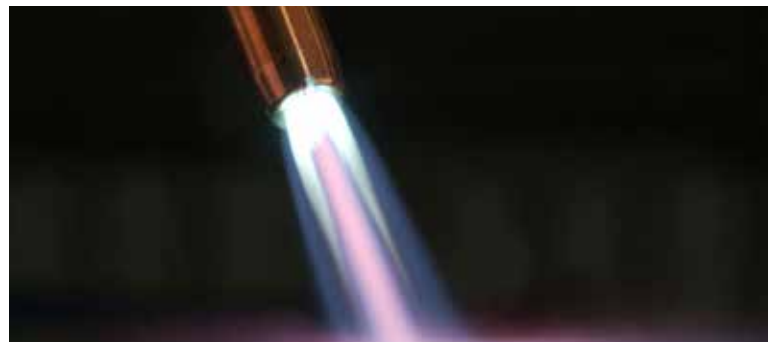
**CORRECT**



**CORRECT**

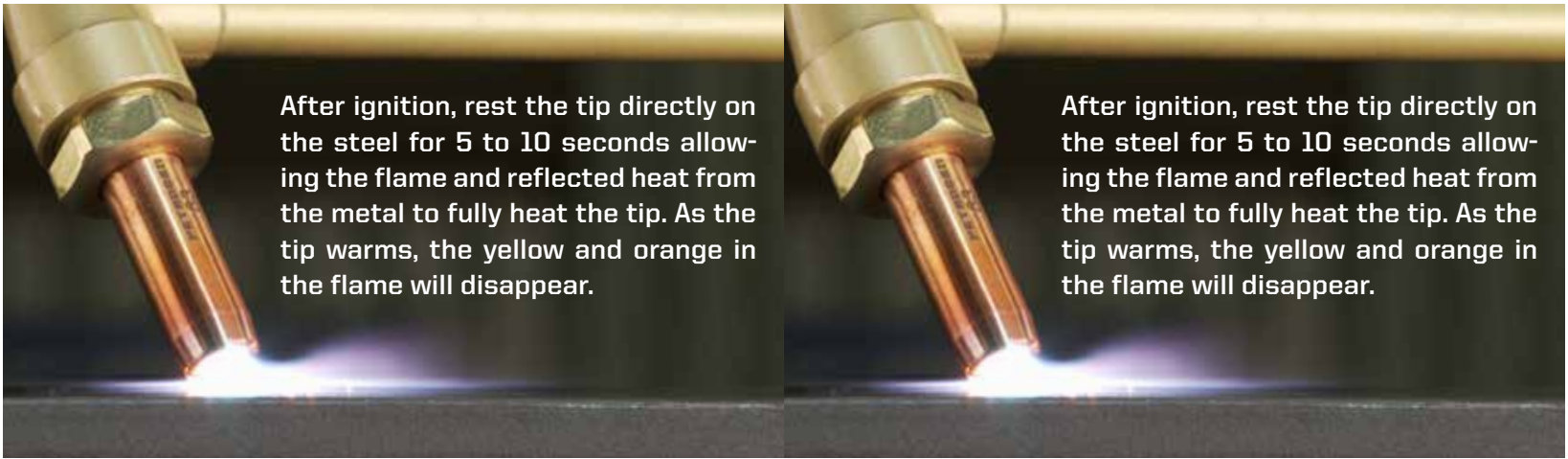


**TOO RICH**



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After ignition, rest the tip directly on the steel for 5 to 10 seconds allowing the flame and reflected heat from the metal to fully heat the tip. As the tip warms, the yellow and orange in the flame will disappear.

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## FLAME ADJUSTMENT

With the tip still touching the steel, use the Fuel Control Knob to make the final adjustment.

**LEAN (Too little fuel)** - **CAUTION:** Using a flame adjustment that is too lean will cause overheating of the tip and mixer and may result in a reduced part life. A lean flame may go out, will have a weak appearance and a wispy sound.

**CORRECT (Balanced)** - A correctly adjusted Petrogen flame will appear larger and more aggressive than that of other oxy-fuel torch systems. The slightly richer setting will unlock the full performance range as well as extend tip and mixer life. This setting will produce a strong appearance and a deep roaring sound. The individual preheat jets should slightly undulate indicating that the flame adjustment is rich.

**TOO RICH (Too much fuel)** - A rich flame adjustment will reduce cutting performance however it will not damage the system. This setting will produce an overly large flame with orange and purple streaks and have a rushing sound.

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