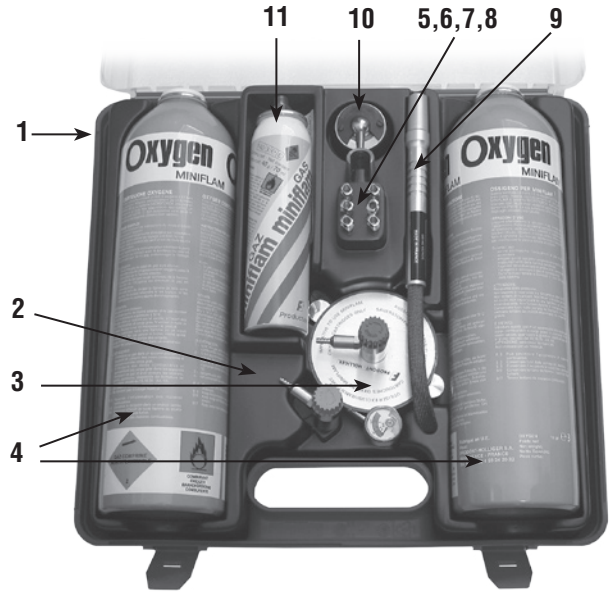


# MicroTorch II Kit Instructions

Thank you for purchasing the Microtorch II Kit. The Microtorch II has been especially designed for precision welding. A Flame can be as small as a character letter on this page. Very high temperatures (2750°C/5000°F) can be obtained. Supplied with a set of needles from 6 to 12/10ths, it is fully equipped for a wide range of applications in jewelry-making, optics, dental laboratories, electronics, scale models, precision engineering, etc.

## Each kit is shipped with the following:

1. A strong plastic case with a clear front cover and a solid red back cover offers a convenient way to carry and store the complete kit.
2. A vacuum formed plastic insert which holds all the accessories neatly within the case.
3. MTII Distributor which includes oxygen valve blue, a gas valve red, 2 oxygen fittings and an oxygen gauge
4. Two oxygen canisters
5. Two 6/10 nths needles
6. Two 8/10 nths needles
7. One 10/10 needle
8. One 12/10 needle
9. One pen with red tubing and blue tubing
10. Adjustable pen holder
11. GP 40 Vapor Gas



## Instructions for Use

1. Connect the pen red and blue tubing supplied with the Microtorch II to the distributor by pushing the ends of the tubes onto the small nipples protruding at the appropriate valves. The valve with the red knob and red tubing signifies the gas connections, and the valve with the blue knob and blue tubing signify the oxygen connection.
2. Make sure that GAS and OXYGEN valves are closed tight. (To close, turn both red and blue knobs clockwise. Do Not Overtighten!)
3. Keeping away from any flame, screw the Miniflam GP 40 vapor gas clockwise into the gas connection (red) making sure not to cross thread the brass fitting. It is normal that you will briefly hear the sound of gas escaping for a moment towards the end of this procedure. DO NOT PANIC! Continue to tighten all the way. DO NOT FORCE! (Please note that the Miniflam GP 40 Vapor Gas has its own internal valve and will reseal itself when unscrewed from the Microtorch distributor.
4. Tighten the two Oxygen containers (green) clockwise into the remaining two connections, making sure not to cross thread the fittings. It is normal that you briefly hear the sound of Oxygen escaping towards the end of this procedure.
5. Fit the needle into the front end of the pen and give it a twist clockwise to lock it.
6. Before lighting the torch, it is advisable to place the pen into the adjustable pen holder and to keep the assembly within easy reach.
7. Take care to position the Microtorch in such a way that the flame will not come into contact with the tubes, fuel containers, or any person or object.
8. In general, very little gas and oxygen is required to start the torch. It is recommended to operate the valves very slowly, in particular when using small diameter needles.
9. To light the Microtorch II: Slowly turn open the red knob gas valve counter-clockwise (see the arrow on top of knob) while providing a flame source or a striker **adjacent** to the end of the needle until ignited. Initially the lit flame will be yellow. Adjust the "yellow" flame depending on the size of the needle from a quarter of an inch for a 6/10 needle to one inch for a 12/10 needle. (Note: Placing the flame directly in front of the needle may cause your source of flame to be blown out.)
10. Gradually and patiently turn the Oxygen valve counter-clockwise (see the arrow on top of knob) until the flame starts to shorten and turns the flame from a yellow to the desired blue flame. If your yellow flame blows out during this procedure, cut back a bit on the oxygen and relight immediately (keeping hands away from tip). If too much time has gone by, cut off both oxygen and gas supplies (turn clockwise), and start again.
11. Avoid letting the needle become red hot at its tip. This can be accomplished by adding oxygen or reducing the intake of gas accordingly.

## Autonomy: Microtorch II, Product #: 2107802

For continuous use and depending on the needles:

Needles	1 Gas	2 Oxygen
6/10	20 hrs.	7 hrs.
8/10	6 hrs.	1hr. 30 m
10/10	4 hrs.	1 hr.
12/10	1 hr. 30 m	30 m

*It is recommended to unscrew gas and oxygen canisters when not in use over an extended period of time - such as overnight!*



**Sterngold™**

23 Frank Mossberg Drive • PO Box 2967  
Attleboro, MA 02703-0967  
Tel: 800-243-9942 • 508-226-5660

Fax: 508-226-5473

[www.sterngold.com](http://www.sterngold.com)