

Acrylic Flame Polishing Basic Instruction Manual

Norrie Industries, Inc.

www.acrylicflamepolishing.com



2500.350 hydrogen regulator &
2500.540 oxygen regulator



How To Use Your Acrylic Flame Polishing Kit

Make sure every piece is included. Each kit comes with the following:

- 3H Torch
- RB-0 and RB-2 polishing tips
- 2500.350 oxygen regulator
- 2500.540 hydrogen regulator
- Both FA-30P flash back arrestors
- CT-12-3AB hose kit

Set Up Instructions:

READ CAREFULLY FOR YOUR SAFETY

1. Before doing anything, make sure that the valves on both gas tanks are closed. This is particularly important for the hydrogen tank, because hydrogen in an enclosed space could cause an explosion.
NOTE: The hydrogen tank valve and most parts associated with the hydrogen tank have left-hand threads. This means that a hydrogen valve will close to the left, whereas oxygen and most other valves will close to the right. This is to prevent wrong parts from being attached to one or the other gas tank.
2. Remove the packaging from each pressure-reducing gas regulator. Make sure that the regulator valves are closed to zero pressure. To do this turn both valves as far as possible counter-clockwise.
3. Attach gas regulators to their respective gas tanks with a 10in. crescent wrench. The hydrogen regulator will tighten to the left, and the oxygen regulator will tighten to the right.
4. Remove packaging from each flash back arrestor and use an 8in. crescent wrench to attach them to their respective regulators. Again, these arrestors will tighten in opposite directions, the hydrogen to the left and the oxygen to the right.
5. Remove packaging from the hose kit. There are two hoses; one is green and one is red. On one end of each hose is a B-connection (larger) and on the opposite end is an A-connection (smaller). Using an 8in. crescent wrench, tighten the two B-connections to their respective tanks, hydrogen to the left and oxygen to the right.
6. Attach the A-connections to the torch, in their respective places.
7. CLOSE TORCH VALVES. Both tighten to the right.
8. Select which kind of tip is needed for the particular job at hand. Attach this tip to the torch.

Important Tips for Best Results

1. Clean acrylic surface thoroughly with soap and water. Failing to do so could embed impurities into the acrylic. Make sure there is no dirt, dust, oil, or residue of any kind on the surface of the acrylic as it will melt or burn into the piece. Avoid cleaners, especially those containing alcohol, because they can burn the surface.
2. To obtain the best finish one should machine or sand the edges to as high quality finish as possible prior to being flame polished.
3. Practice makes perfect. If you are new to acrylic flame polishing, be sure to try out the kit on several test pieces before polishing anything too important. The perfect technique takes some familiarity and practice.
4. For standard acrylics, use a bluish, almost invisible flame. Polishing is done with the heat of the flame tips, not the actual flame itself, so be careful to keep the flame at a slight distance from the acrylic.
5. Make sure to hold the torch at an angle and always direct the flame away from the work with a non-obstructed area for the flame to flow into.
6. If the finish is still not flawlessly clear after one brush with the torch, allow the plastic to cool before passing the torch closer or more slowly over the object.
7. Annealing the piece after flame polishing decreases the stress imparted and reduces the chance of crazing.

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