ST 1800C and ST 1900C Series Hand Cutting Torches

Torch Length | Model Number
-------------|----------------
15"          | SST 1800C, SST 1801C, SST 1900C, SST 1901C
21"          | ST 1800C, ST 1801C, ST 1802C, ST 1900C, ST 1901C, ST 1902C
36"          | ST 1830C, ST 1831C, ST 1832C, ST 1930C, ST 1931C, ST 1932C

⚠️ WARNING

Welding apparatus improperly operated, maintained or repaired can be dangerous. Some parts and accessories manufactured by others may fit VICTOR apparatus but not conform to VICTOR’s exacting standards. For your own protection, specify and use ONLY VICTOR-made parts and accessories with your VICTOR apparatus.

Service or repair of VICTOR apparatus should be performed only by a qualified technician. Improper service, repair or modification of the product could result in damage to the product or injury to the operator.
ST 1800C and ST 1900C Torches
(ST 1800C Illustrated, See DETAIL C for ST 1900C)

180° Head
0302-0118
(21° & 27° ONLY)

75° Head
0302-0096 (21° & 27°)
0302-0119 (Other Models)

90° Head
0302-0093 (21° & 27°)
0302-0117 (Other Models)

Oxygen Tube
See CHART 1

Fuel Coupling Nut
0309-0065
DETAIL A

Diffuser
0313-0141
(21° & 27° ONLY)

† Ferrule
0316-0007

† O-Ring
1407-0192

† Gasket
1406-0075

Tube Support
0306-0123
(21° & 27° ONLY)

Mixer Assembly
See CHART 1 (21° & 27°)
See DETAIL D

† O-Ring
1407-0013

† Mixer Spring
0320-0110

Head & Tube Assembly
See CHART 1
See DETAIL A

† O-Ring
1407-0005

† O-Ring
1407-0016

† Internal Check Valve Kit
0690-0027

Valve Cap Assembly
0320-0111
See Detail B

0309-0069 (27°)

† Seat Bushing
0320-0108

† Seat Assembly
0320-0079

† Cap Bushing
0320-0112

† Washer
1406-0006

† Spiral Pin
1404-0002

† Valve Cap
0320-0109

DETAIL B

Valve Spring
0320-0024

† Valve Body w/Check Valve
0661-0206

† Valve Stem Assembly
0662-0014

† Valve Stem Assembly
0662-0014

† Valve Body w/Check Valve
0661-0206

† Valve Stem Assembly 0662-0014.

† Items most commonly required for torch repair and recommended for stock.

* Valve Assembly 0660-0233 consists of Valve Body 0661-0206 and Valve Stem Assembly 0662-0014.
CHART 1

<table>
<thead>
<tr>
<th>Model No.</th>
<th>Head</th>
<th>Head &amp; Tube Assembly</th>
<th>Oxygen Tube</th>
<th>Mixing Tube</th>
<th>Mixer Assembly</th>
<th>Inner Oxygen Tube</th>
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</tbody>
</table>
SERVICE INSTRUCTIONS

Recommended Tools and Supplies:
- Bench Vise
- Holding Fixture RT-147 (1420-0221)
- 5/8" and 3/8" Open-end Wrenches
- 5/32" Drift Punch
- Hammer
- 1/4"-20 Bolt
- Brazing Torch
- LOCTITE® #79 Threadlock (0028-0056)
- LIQUID O-RING® #151L (0034-0021)
- FLUOROLUBE® #12 Lubricant (1426-0003)
- 45% Silver Solder
- Silver Solder Flux

NOTICE

For additional information, refer to Apparatus Service and Testing Procedures (Form 56-0885) and Repair Tools Manual (Form No. 56-0121).

DISASSEMBLY PROCEDURE

Removing the Internal Check Valves
1. Screw the 1/4"-20 bolt, finger tight, into the threaded portion of the Internal Check Valve.
2. Place the shank of the bolt in the Bench Vise with the bolt head shouldered against the vise jaws. DO NOT tighten the Bench Vise (see Figure 1).

Figure 1: Removing the Internal Check Valve

3. Grasp the torch firmly and pull. The bolt head will catch on the vise jaws and the Internal Check Valve will pull out of the torch.
4. Repeat Steps 1 through 3 to remove the other Internal Check Valve.

Disassembling the Torch
5. Place the Holding Fixture in the Bench Vise. Place the torch in the Holding Fixture with the lever up.
6. Remove the Valve Stem Assemblies.
7. Remove the Oxygen Connection and the Valve Body.
8. Use a 5/32" Drift Punch and Hammer to remove the Spiral Pin from the Lever.

CAUTION

Always wear safety goggles when using a Drift Punch.

9. Remove the Valve Cap Assembly.
10. Remove and discard the Cap Bushing and O-Ring from the Valve Cap Assembly.
11. Remove the O-Ring, Washer, Valve Spring, Seat Assembly Bushing and Seat Assembly. Discard the O-Ring.
12. Loosen the Fuel and Oxygen Coupling Nuts. Remove the Barrel and Body Assembly from the Head and Tube Assembly.
13. Remove the Gasket from the Barrel and Body Assembly. Discard the Gasket
15. Remove the Mixer Assembly from the Mixing Tube. Remove the Mixer Spring and O-Ring(s) from the Mixer Assembly.

CAUTION

Discard the O-Rings, Cap Bushing, Gasket and Ferrule. Replace them each time you reassemble a torch.

Disassembling the Mixer Assembly
16. Disassemble the Mixer Assembly as shown in DETAIL D or DETAIL E.

Disassembling the Head and Tube Assembly
17. Heat the Tube/Head connection with a Brazing Torch. Remove the Tubes.
18. ST SERIES ONLY: Remove the Diffuser from the Mixing Tube.
20. Remove the Fuel Coupling Nut from the Mixing Tube.

Cleaning Parts

Clean all metal parts with a cleaner that is safe for use with high pressure oxygen. Contact a chemical/cleaning supply distributor for recommended cleaners for use with high pressure oxygen. Always use cleaning solvents in accordance with manufacturer's instructions.

WARNING

DO NOT allow nonmetal parts to come in contact with any cleaning solvent! Cleaning solvents cause elastomeric and plastic parts to swell and stress crack. If these parts require cleaning, use a mild soap solution, followed by thorough rinsing in water. Dry these parts completely before installing in the Torch. REPLACE NONMETAL PARTS THAT HAVE COME IN CONTACT WITH OIL, GREASE OR ANY OTHER PETROLEUM BASED SUBSTANCE!

ASSEMBLY PROCEDURE

Assembling the Head and Tube Assembly
1. Install the Fuel Coupling Nut and Diffuser on the Mixing Tube.
2. Insert the Mixing Tube and Oxygen Tube in the Head. Make sure the Tubes bottom out in the Head.
3. Place the Tube Support between the Tubes. Multiple Tube Supports may be installed if desired.
4. Silver braze the Tube and Head connections. Silver braze the Tube Support and Tube connections.
Assembling the Mixer Assembly
5. Assemble the Mixer Assembly as shown in DETAIL D or DETAIL E. Be sure to install the spiral end of the Inner Oxygen Tube into the Mixer.

Assembling the Torch
6. Lubricate the new O-Ring(s) with FLUOROLUBE® #12. Install the O-Rings(s) on the Mixer Assembly as shown in DETAIL D or DETAIL E.
7. Install the Mixer Assembly in the Mixing Tube. Install the Mixer Spring in the Mixer Assembly.
8. Install the Oxygen Coupling Nut and new Ferrule on the Oxygen Tube.
9. Install the new Gasket in the Barrel and Body Assembly.
10. Apply a small amount of LOCTITE® #79 to the second and third threads of the Oxygen and Fuel Coupling Nuts. Install the Head and Tube Assembly in the Barrel and Body Assembly. Tighten the Coupling Nuts.
11. Place the Holding Fixture in the Bench Vise. Place the torch in the Holding Fixture with the cutting oxygen port of the Body up.
12. Place the Seat Assembly, Seat Assembly Bushing, Valve Spring Washer and new O-Ring in the cutting oxygen port of the Body.
13. Lubricate the new Cap Bushing and O-Ring with FLUOROLUBE® #12. Install them into the Valve Cap.
15. Secure the Lever to the Body with the Spiral Pin. Make sure the lever tabs fit into the Seat Assembly groove.
16. Apply a small amount of LOCTITE® #79 to the second and third male threads of the Valve Body and Oxygen Connection. Install the Valve Body and Oxygen Connection in the Barrel and Body assembly. Tighten them to a torque of 14-18 ft.-lbs.
17. Apply a small amount of LIQUID O-RING® #151L to the end and first few threads of the Valve Stem Assemblies. Install the Valve Stem Assemblies.

Installing the Internal Check Valves
18. Press the Internal Check Valves into the Oxygen Connection and Valve Body. Thread hose connections onto the Valve Body and Oxygen Connection. Tighten the hose connections until the Internal Check Valves are properly seated.
19. Remove the hoses. The Internal Check Valves are properly seated when the ends of the Internal Check Valves are flush with the ends of the Oxygen Connection and Valve Body.

**TEST PROCEDURE**

**Recommended Tools and Supplies:**
- Plugged Cutting Tip (Type 1-101, see Figure 2)
- Large Container of Water
- 2-1-101 Cutting Tip
- 45 PSIG Source of Oil-free Air or Dry Nitrogen
- 50 PSIG Source of Oxygen
- 8 PSIG Source of Acetylene
- Spark Lighter
- Fire Brick

**WARNING**
Always perform the following test procedure after assembling a torch. If the torch does not perform properly during testing, refer to the Trouble-shooting Chart in the VICTOR Apparatus Service and Testing Procedure Manual for Cutting Torches, Cutting Attachments and Torch Handles (Form No. 56-0885).

**Leak Testing The Torch**
1. Attach the Fuel and Oxygen Hoses to the Torch.
2. Install the Plugged Cutting Tip (see Figure 2) in the Torch Head. Tighten the Tip Nut to 15 ft.-lbs. of torque.

![Plugged Cutting Tip](image)

**Figure 2: Plugged Cutting Tip for Leak Testing**
3. Close the Valve Stem Assemblies. Pressurize the oxygen and fuel systems to 45 PSIG with oil-free air or dry nitrogen.
4. Completely submerge the Torch in the container of water.
5. Open both Valve Stem Assemblies.
   a. Check for leaks around all external connections.
   b. Observe the Valve Stem Assemblies. If bubbles are escaping around the stem packings, tighten the Packing Nuts until 1¼ to 2 in.-lbs. of torque is required to turn the Valve Stem Assembly Knobs.
6. Close the Valve Stem Assemblies. Tighten to 7-8 in.-lbs. of torque.
7. Remove the Plugged Cutting Tip. Submerge the Torch in the container of water. Observe the Torch Head. If bubbles appear at the Torch Head, one or both of the Valve Stem Assembly Seats is leaking.

**Testing the Internal Check Valves**

**WARNING**
The ST 1800C and ST 1900C Series torches are equipped with Internal Check Valves to reduce the probability of gases mixing in the hoses or regulators. Mixed gases can result in fire or explosion. Such fires or explosions can result in serious injury to anyone in the area or serious property damage.

To ensure that Internal Check Valves are working properly, test them for leaks at least every six months. Test them more often if hoses are frequently disconnected from the torch.
1. Install the Plugged Cutting Tip (see Figure 2) in the Torch Head. Tighten the Tip Nut to 15 ft.-lbs. of torque.
2. Connect the Fuel and Oxygen Hoses to the Torch.
3. Either disconnect the Fuel Hose from the Fuel Regulator or disconnect the Oxygen Hose from the Oxygen Regulator.

4. Open both torch Valve Stem Assemblies (fuel and oxygen).

5. Open the Cylinder or Manifold Valve. Adjust the Regulator so that it is still connected to deliver 2-5 PSIG.

6. Place the loose end of the disconnected hose under water for at least ten (10) seconds.

7. Examine the hose end for bubbles. If there is more than two (2) bubbles in ten (10) seconds, replace the Internal Check Valve.

8. Repeat Steps 3 through 7 to test the other Internal Check Valve.

9. ALWAYS PURGE THE SYSTEM, as described below, after testing the Internal Check Valves. Purging removes dangerous mixed gases from the system.

**CAUTION**

For your safety, always purge the system in a well ventilated area.

- Adjust both Regulators to deliver 10 PSIG.
- Open the Fuel Valve Stem Assembly for ten (10) seconds. Close the Cylinder or Manifold Valve. When all fuel pressure is released from the system, close the Fuel Valve Stem Assembly. Turn the Fuel Regulator Adjusting Screw counterclockwise until all spring pressure is released.
- Repeat Step b, using the Oxygen Valve Stem Assembly and Oxygen Cylinder or Manifold.

**Flame Testing the Torch**

1. Install a Cutting Tip. Tighten the Tip Nut to 15 ft-lbs. of torque.

2. Attach the Fuel and Oxygen Hoses to the Torch Subassembly. Tighten the Hose Nuts to 15-17 ft-lbs. of torque.

3. Adjust the Oxygen Regulator to deliver 45-55 PSIG. Adjust the Acetylene Regulator to deliver 5-11 PSIG.

**WARNING**

Always purge the torch by opening the oxygen valve 1/2 turn and allow the gas to flow for ten (10) seconds for each 25 feet of hose in the system. Close the oxygen valve. Purge the fuel system in the same manner.

4. Open the Fuel Valve Stem Assembly about 1/4 turn. Ignite the gas with a Spark Lighter. Open the Fuel Valve Stem Assembly until all smoke and soot disappear from the flame.

5. Open the Oxygen Valve Stem Assembly. Adjust for a neutral flame (flame will have a sharp inner cone).

6. Press the Lever to apply cutting oxygen to the flame. Note that the preheat flames change slightly from neutral to a carburizing flame with a feather. With the cutting oxygen still flowing, adjust the Valve Stem Assembly until the flame is again neutral.

**CAUTION**

DO NOT operate the torch at excessively low gas pressures. Insufficient pressure may cause the torch tip to overheat, leading to damage.

7. Place the tip on a Fire Brick at approximately 10° from the vertical (see Figure 3). Press the Lever and rock the Torch from side to side (as shown) on the fire brick for five (5) to eight (8) seconds. The Torch will "pop" during the flame test.

![Firebrick](image-url)

**Figure 3: Flame Testing the Torch**

**WARNING**

If you experience a backfire or backflash (flame disappears suddenly and/or a hissing sound is heard when the flame is burning inside the torch), IMMEDIATELY turn off the Oxygen Valve first, then the Fuel Valve. Allow the torch to cool before using it again. If backfire or backflash reoccurs, disassemble the torch and replace any damaged parts.

8. After testing is complete, release the Lever. Shut off the Oxygen Valve Stem Assembly first. Then, shut off the Fuel Valve Stem Assembly. If this procedure is reversed, a loud "pop" may occur. The "pop" throws carbon soot back into the Torch. This may partially plug the torch after a period of time.

9. Close the Cylinder Valves or Manifold Valves.

10. Open the Oxygen Valve Stem Assembly and release the oxygen pressure in the Hose and Regulator. Close the Oxygen Valve Stem Assembly.

11. Turn the Adjusting Screw on the Oxygen Regulator counterclockwise until the Adjusting Spring pressure is released.

12. Repeat Steps 10 and 11 to release pressure from the fuel system.


**HEAD AND TUBE EXTENSION MODULES**

The ST 1830C and ST 1930C Series torches (36" torch length) are configured somewhat differently than illustrated in this bulletin. Instead of terminating at the Torch Head, the ST 1830C and ST 1930C Oxygen and Mixing Tubes terminate at the Extension Block. The desired Head Module (see below) is attached to the Extension Block forming the extended torch. Head Modules and parts for
the ST 1830C and ST 1930C Series torches are available as shown below.

**Head and Tube Modules**

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**Individual Parts**

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<td>Fuel Tube</td>
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<td>Tube Support</td>
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<tr>
<td>Torch Head</td>
<td>See illustration on page 2</td>
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These Head Modules and parts may also be fitted to existing ST 1800C and ST 1900C Series torches if desired. Service Instructions are given below.

**SERVICE INSTRUCTIONS FOR EXTENSION MODULES**

To install an Extension Block, Head and Tube Module to a standard ST 1800C or ST 1900C torch, perform the following procedures:

1. Remove the Head and Tube Assembly from the Barrel and Body Assembly as described in DISASSEMBLY PROCEDURE.
2. Heat the Tube/Head connections with a brazing torch. Remove the Tubes.
3. Be sure that the Diffuser is properly in place and is firmly bottomed out in the Extension Block. The Diffuser must stay in its original position and MUST NOT be moved to the end of the Extension Tube.
4. Silver braze the Head and Tube Module into the Extension Block.

**NOTICE**

When repairs require installing a Head or Extension Block, be sure the Diffuser is properly in place and firmly seated in the Head or Extension Block.

**SERVICE INSTRUCTIONS FOR ST 1100 & ST 1200 SERIES TORCHES**

Some parts for the ST 1100 and ST 1200 series torches are no longer available. Therefore, they require special repair procedures.

1. When replacing an ST 1100 or ST 1200 Head, use an extra amount of silver solder during installation. This fills the Mixing Tube threads since the new Head has no threads.
2. ST 1100 and ST 1200 Head and Tube Assemblies are no longer available. The ST 1800C and ST 1900C Head and Tube Assemblies are replacements. However, they must be used in conjunction with the ST 1800C and ST 1900C Mixer and Inner Oxygen Tube Assemblies. Proper seating of the Mixer and Inner Oxygen Tube Assembly requires the Mixer Spring.
3. The ST 1100 and ST 1200 Mixer and Inner Oxygen Tube Assemblies are no longer available. The ST 1800C and ST 1900C Mixer and Inner Oxygen Tube Assemblies are replacements. However, The Head and Tube Assembly must also be replaced with ST 1800C or ST 1900C Head and Tube Assemblies. Proper seating of the Mixer and Inner Oxygen Tube Assembly requires the Mixer Spring.

**REPAIR TOOLS**

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