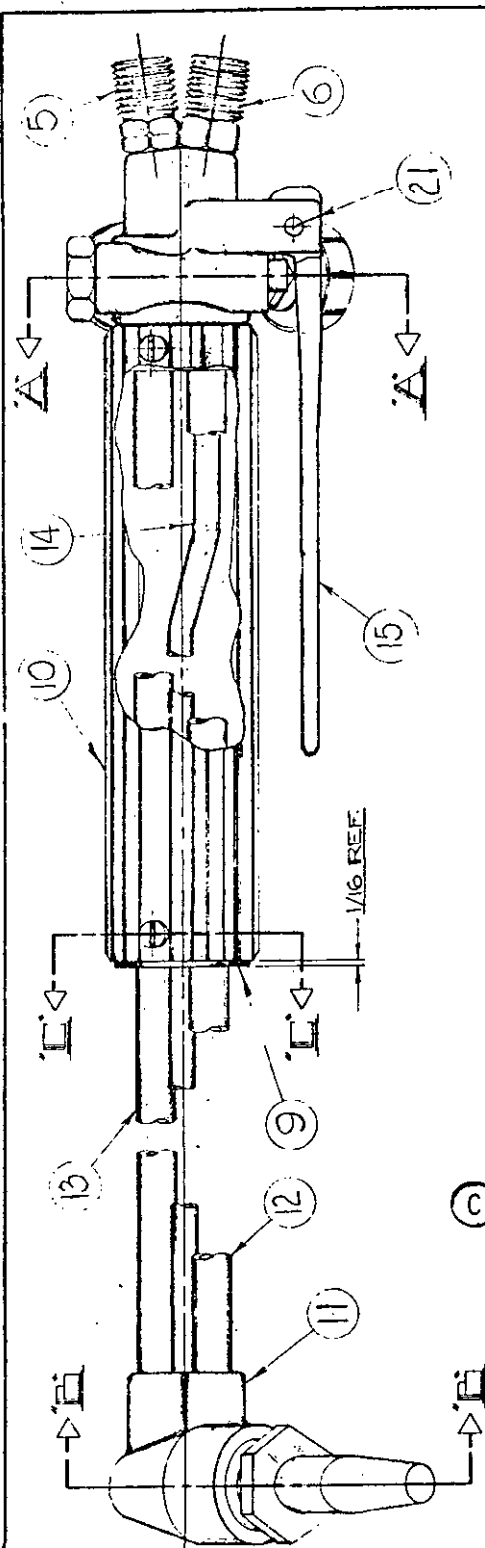


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Ⓒ CANCELED

Ⓔ REVISED AND REDRAWN

P.A. - YD

Other Cust
ARMY - WC
AIR FORCE - 84
NAVY - YD

PROCUREMENT SPECIFICATION
MIL-T-16193 B

TITLE

TORCH, CUTTING, ASSEMBLY OF

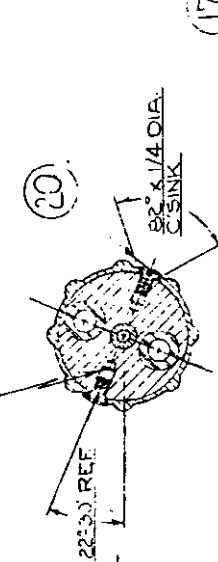
SUPERSEDES:

MILITARY STANDARD

MS 15008

SHEET 1 OF 2

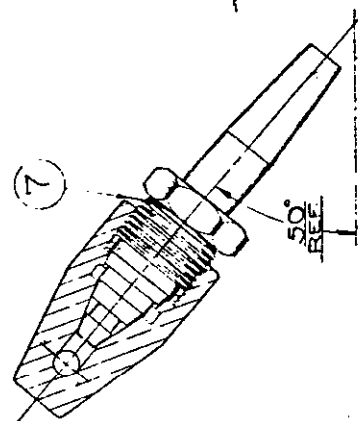
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SECTION 'I-I'

NOTE

1. ASSEMBLE O-RING, GASKET (PC NO. 22), AND VALVE PACKING NUT (PC NO. 3) TO VALVE STEM (PC NO. 2).
2. PRESS VALVE WHEEL (PC NO. 4) TO STEM, PEEN AND GRIND SMOOTH.
3. PRIOR TO FINAL JOINING OF TUBING (PC NOS. 12, 13, AND 14) TO TORCH HEAD (PC NO. 11) AND VALVE BODY (PC NO. 1), SLIDE OVER THE RESPECTIVE TUBES THE ASSEMBLY OF THE HANDLE (PC NO. 10) AND TUBE SUPPORT (PC NO. 9).
4. NON-GAS-CARRYING SPACES IN HANDLE'S SHALL BE VENTED.



SECTION 'E-E'

SECTION 'A-A'

FED. SUP CLASS
3433

APPROVED 28 SEPT 1981 REVISED Ⓔ 15 SEPT 1971 Ⓒ 2 FEB 79

3433

QTY.	NAME	MATERIAL	ASTM	SHT.
1	REAR BODY	NAVAL BRASS FORGING	B21	1-2
2	VALVE STEM	NI-CU-ALLOY ROD	B164	3
3	VALVE PACKING NUT	BRASS ROD	B16	3
4	VALVE WHEEL	BRASS ROD (EXTRUDED)	B16	3
5	ACETYLENE CONNECTOR (L.H.)	BRASS ROD	B16	3
6	OXYGEN CONNECTOR (R.H.)	BRASS ROD	B16	3
7	TIP NUT	NAVAL BRASS ROD	B21	3
8	HI-PRESSURE NUT	BRASS ROD	B16	3
9	TUBE SUPPORT	BRASS ROD	B16	4
10	HANDLE	BRASS TUBE (EXTRUDED)	B135	4
11	TORCH HEAD (90°)	NAVAL BRASS FORGING	B21	4
12	HI-PRESSURE OXYGEN TUBE	CRES	A554	5
13	ACETYLENE TUBE	CRES	A554	5
14	LO-PRESSURE OXYGEN TUBE	BRASS	B135	5
15	VALVE LEVER (H.P. OXY.)	BRASS FORGING	B21	5
16	VALVE (H.P. OXY.)	BRASS ROD	B16	5
17	VALVE SPRING (H.P. OXY.)	MUSIC WIRE - CAD. PLATE	A228	5
18	VALVE SEAT ("O" RING)	NEOPRENE (7/16 OD x 5/16 ID)		5
19	PACKING ("O" RING)	BUNA "N" (5/16 OD x 3/16 ID)		5
20	VALVE HEAD MACHINE SCREW	BRASS (1/8-32NF2 x 1/4)		5
21	ROLL PIN	CRES (3/16 DIA. X 5/8)		5
22	GASKET ("O" RING)	BUNA "N" (3/8 OD x 1/4 ID)		5
23	TORCH HEAD (75°)-OPTIONAL	NAVAL BRASS FORGING	B21	4

Q

1. ALL TUBE CONNECTIONS SHALL BE SILVER BRAZED.
2. NO CASTINGS SHALL BE PERMITTED WHERE APPLICABLE. MATERIAL SHALL BE FORGED OR WROUGHT
3. THE 50° HEAD SHALL BE STANDARD. THE 75° HEAD SHALL BE AVAILABLE ON REQUEST
4. ALL VALVES SHALL CLOSE GAS TIGHT WITH FIVE INCH POUNDS TORQUE MAXIMUM.
5. SEE MILITARY STANDARD MS-15000 FOR DETAILS.
6. REFERENCED SPECIFICATIONS AND STANDARDS OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BIDS SHALL APPLY.
7. MATERIAL FOR VALVE SEAT (PC NO. 18) SHALL BE MOLDED NEOPRENE OR EQUAL.

APPROVED 28 SEP 1951 REVISED 15 SEP 1971

CUSTODIANS	OTHER INT.
ARMY-WC	A-
AF-84	N-
NAVY-YD	AF-

MILITARY STANDARD

TORCH, CUTTING, ASSEMBLY OF

MS 15008

Procurement Specification
MIL-T-16183 B

SUPERSEDES:

SHEET 2 OF 2