



Carlisle Machine Works, Inc.

WildCat Burner Instruction Sheet

The WildCat Burner uses propane, natural gas, or hydrogen with oxygen to create a wide range of flame characteristics for flameworking applications. This instruction sheet is designed to provide the user with a working knowledge of the burner to allow for safe and educated use. This instruction sheet is not intended to be a guide for flameworking, but rather a guide for use of the WildCat Burner. Please take the time to thoroughly read through this instruction sheet to help ensure the proper use and maintenance of the burner. This instruction sheet provides information about the WildCat Burner.

Options and Accessories:

- **In-Line Disposable Filters Option:** This is a highly recommended option to filter the fuel gas (except hydrogen) and oxygen gases prior to the burner to reduce the possibility of contaminants from the feed piping and supply sources.
- **Hose Options:** There are three types of hosing recommended for CC Series burners, Welding hose, Tygon hose, and Stainless Steel Braided hose. Please refer to Bulletin 24D for more information regarding these products.

Surface Mixed:

The WildCat Burner is surface mixed. Surface mixed burners deliver the gas and oxygen to the face separately so that the mixing of gases happens as they exit the burner face. This produces a safe flame for working with most flameworking applications. Surface mixed burners have a much lowered possibility for combustion to take place inside of the burner (this is commonly known as Flashback) since the gas and oxygen are not mixed until they exit the burner. However, certain conditions (such as an internal leak) could cause a Flashback to occur. **Always use flashback safety devices (i.e. flashback arrestors or fire checks) with any flameworking system.**

Control Valves:

Standard models require two valves which are, located on the back of the WildCat Burner. One control valve has a red handle and is used for metering the fuel gas flow to the burner. One control valve has a green handle and is used for metering the oxygen flow to the burner.

Carlisle Machine Works, Inc.,
P.O. Box 746, 412 S. Wade Blvd., Bldg. #5, Millville, NJ 08332
Toll Free Phone : (800) 922 - 1167 Local Phone : (800) 825 - 0627
Fax: (856) 825 - 5510
Website: carlislemachine.com Email: carlisle@carlislemachine.com



These control valves are finely threaded and thus require several full turns to become fully open or fully closed. **When using these valves to control the flames, it is best to make small incremental adjustments rather than full turns.** Quick or large adjustments could cause the flame to become unstable and even blow off of the face of the burner. In time, the user will learn the best way to control the burner for their application.

The valve stems are threaded and secured into the valve body via a nut. This nut is threaded onto the valve body and the brass stem extends through this nut. Depending on how tightly this nut is threaded down onto the valve body, the brass stem will be harder or easier to turn. If the nut is tightly threaded down onto the valve body, the stem will have more resistance to movement. By loosening this nut, the stem will become easier to adjust. Loosening the nut may also cause a leak to form around the stem from the nut sealing area. Be sure to check for leaks (see *"Checking for Leaks"*) anytime that this nut is adjusted.

When closing the control valve, the valve should be adjusted only until it seats and stops turning. The valve should not be forced or "torqued" down any further. By turning the valve handle with force, beyond its seal positioning, once it has seated, great pressure may be placed on the seat. This will cause the seat or valve stem to become deformed and will result in a leak that can not be fixed and will require the replacement of the valve.

Checking for Leaks:

Before operating the WildCat Burner for the first time and once a month (see *"Maintenance"*) the burner should have the control valves and all connections checked for leaks. Follow the procedure below to check for leaks.

1. Connect air at 25 PSI to the burner.
2. Dip the head of the burner into a bucket of water.
3. Cycle through the control valves turning each one on and then shutting it off. When the control valve is opened there should be a rush of bubbles in the water. After shutting the control valve off, wait about 30 seconds to watch for any new bubbles. If bubbles appear at any rate, this would indicate a leak in the control valve.
4. Remove the head from the water and use the air pressure to blow out any residual water.
5. Mix soap (liquid soap is best for this) and water to form a bubbly mixture for leak detection.
6. Turn on both control valves.
7. Apply the soapy mixture to all threaded connections, solder joints, and valve stems. If any of these areas produces bubbles after applying the soapy mixture, the connection may have a leak.
8. Close all control valves and disconnect the air.

If a leak is detected, contact a Carlisle Representative for assistance.

Carlisle Machine Works, Inc.,
P.O. Box 746, 412 S. Wade Blvd., Bldg. #5, Millville, NJ 08332
Toll Free Phone : (800) 922 - 1167 Local Phone : (800) 825 - 0627
Fax: (856) 825 - 5510
Website: carlislemachine.com Email: carlisle@carlislemachine.com



Startup and Shutdown:

To startup the WildCat Burner, follow the procedure below.

1. First open the gas control valve and ignite the gas with either an open flame or a striker. Be sure that your hands, clothing, and other flammable objects are not near the face of the burner while igniting the flame.
2. Then open the oxygen control valve to produce a blue focused flame.

To shutdown the WildCat Burner, follow the procedure below.

1. Reduce flow of all gases to burner
2. First close off the oxygen control valve.
3. Then close off the gas control valve.

Heat Build-up and Carbon Build-up:

Some inappropriate working conditions can cause heat build-up in the burner. This heat build-up will cause damage to the burner and also present a danger to the user if a heated area of the burner is touched by the user.

Heat build-up is the cause for carbon build-up. Carbon build-up is the formation of carbon inside of the burner. This is a natural byproduct of fuel gasses. Please note that some fuel gasses, such as propane, contain more carbon content than others, leading to larger amounts of carbon build-up. This often results in degraded performance of the burner and possibly may cause carbon to expel out of the burner. Carbon that is present in the fuel gas (except hydrogen) effectively causes the flame to have more heat potential. If the stainless steel in the burner becomes heated to a significant level, the carbon from the fuel gas will bond to the walls of the stainless steel. When this occurs, the burner must be cleaned (see "*Maintenance*").

Below are some of the things the user can do to help retard heat build-up.

- Only use the recommended pressures, as other pressure settings may cause significant heat build-up.
- Flames that have higher oxygen content run cooler. Use this type of flame whenever possible.
- Do not run the burner without some oxygen flowing through the burner.
- Do not use short flames (1/4" long focal points or less) that burn close to the face of the burner and can cause the end of tubes to glow red.
- Do not use lazy flames that are not directed outward from the face of the burner.

Vortex™ Cooling Feature:

Built into the end of the WildCat burner is the Vortex™ cooling feature. This feature uses pressurized oxygen from the oxygen manifold to inspirate atmospheric air through the collar at the end of the burner. The mixture of oxygen and air both support the flame and cool the end of the burner. The more oxygen used, the more effective this cooling feature becomes. If the WildCat is found to be overheating, inspect the cooling feature's porting to ensure that there are no blockages.

Carlisle Machine Works, Inc.,
P.O. Box 746, 412 S. Wade Blvd., Bldg. #5, Millville, NJ 08332
Toll Free Phone : (800) 922 - 1167 Local Phone : (800) 825 - 0627
Fax: (856) 825 - 5510
Website: carlislemachine.com Email: carlisle@carlislemachine.com



Flame Atmospheres:

The WildCat has a very unique flame. Please note that based on the operator's prior burner experience, the flame settings may not look or sound as expected. The unique flame properties of the torch demonstrate superior performance. As such, until the operator becomes familiar with these unique properties, he/she should test out reactions with glass to determine whether the flame is reducing, neutral, or oxidizing.

Soft Glass: (COE 90 and higher)

For use with soft glass, Carlisle recommends a candle or focal length of 3/8". On a neutral setting, this will present a flame that is very hot and provides radiant heat around the flame. This radiant heat lessens the frequency of glass fractures due to temperature changes while moving in and out of the flame.

Hard Glass (aka Borosilicate COE 33):

For use with hard glass, Carlisle recommends a candle or focal length of 3/4". Please note that a neutral setting of this flame may produce orange tips on the candles. However, as long as the candles are all the same length, this should not produce reduction on borosilicate colors.

Oxygen Use:

Once a Neutral flame is achieved, adding more oxygen will produce the Oxidizing flame. An oxidizing flame will make a more narrow flame pattern that can be used for more delicate work. It is important to note that the extra oxygen also has a cooling effect in the flame and will lower the heat potential.

Maintenance:

Before any maintenance is performed, the user should be sure to use appropriate safety measures such as wearing safety goggles.

- If the WildCat Burner experiences carbon build-up (see *"Heat Build-up and Carbon Build-up"*), then the burner should be cleaned regularly. The tubes can be cleaned using a **CC cleaning kit**. When cleaning the tubes, it is important to be sure that the user is very careful and gingerly pokes at the carbon. **It is very possible to have the cleaning tool get stuck inside the burner.** Also, a light amount of air flow through the torch will cause the dislodged carbon to come out of the face of the burner rather than falling back into the body.
- The WildCat Burner should be checked for leaks in the valves, solder joints, and all threaded connections once a month (see *"Checking for Leaks"*).

Carlisle Machine Works, Inc.,
P.O. Box 746, 412 S. Wade Blvd., Bldg. #5, Millville, NJ 08332
Toll Free Phone : (800) 922 - 1167 Local Phone : (800) 825 - 0627
Fax: (856) 825 - 5510
Website: carlislemachine.com Email: carlisle@carlislemachine.com



Safety Requirements:

Below are the safety requirements for use of the WildCat Burner. These measures will help to ensure the safety of the user.

- Flashback safety devices (i.e. flashback arrestors or fire checks) should be used with the WildCat Burner. These devices deter a Flashback from traveling upstream through the lines.
- Didydium Glasses should be worn at all times, when working with the WildCat Burner. Check with the manufacturer of the glass you are using for their requirements, as different types of glass may have different safety requirements.
- Protective clothing should be worn when working with the WildCat Burner.
- Long hair should be tied back and loose clothing should not be worn when working with the WildCat Burner.
- The integrity of the burner casing should never be broken. This will cause an internal leak (until repair) that could potentially be very dangerous.

WildCat	Natural Gas	Propane	Hydrogen
Recommended Pressures for Fuel Gas	.25 (7" of water column) - 3 PSI	2 - 3 PSI	10 PSI
Recommended Pressures for Oxygen with use of listed gases	4 - 8 PSI	5 - 10 PSI	10 PSI

Warranty and Legal Notice:

This unit is under warranty for 12 months as per the terms and conditions located on the Carlisle Machine Works, Inc. website: www.carlismachine.com.

The manufacturer strongly objects to anyone but authorized Carlisle personnel breaking the integrity of the burner casing. The manufacturer will declare all warranties null and void and user will be liable for all injuries or damages occurring as a result of the user attempting or succeeding to disassemble, repair, or replace internal parts of the burner .

Carlisle Machine Works, Inc.,
P.O. Box 746, 412 S. Wade Blvd., Bldg. #5, Millville, NJ 08332
Toll Free Phone : (800) 922 - 1167 Local Phone : (800) 825 - 0627
Fax: (856) 825 - 5510
Website: carlismachine.com Email: carlisle@carlismachine.com

