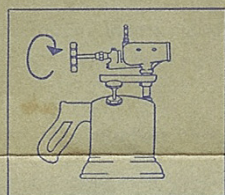


CRAFTSMAN

REG. U. S. PAT. OFF.

OPERATING DIRECTIONS

For Craftsman Blowtorches Nos. 5544 and 5547 With Filler Plug in Bottom of Tank



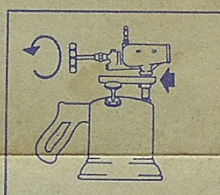
Valve handle turns OFF to right; ON to the left.

(A)



Remove plug. Fill torch through hole in bottom.

(B)



Open valve to left to fill drip cup below burner.

(C)

HOW TO FILL BLOWTORCH

1. Close burner valve by turning valve handle to right. See figure (A). Close valve tightly and firmly, but do not force.
2. Unscrew and remove filler plug in bottom of tank. See figure (B).
3. Fill tank three-fourths full—no more. Use clean, fresh gasoline from a clean container. Do not use old gasoline! Old gasoline has lost its volatile elements and will not burn properly. Do not use Ethyl or leaded gasoline—it will not give the results you have a right to expect.
4. Replace filler plug. Screw it in tightly, using pliers, wrench or by inserting screwdriver through the hole provided.
5. Wipe any excess gasoline from outside of torch. This is important.

HOW TO LIGHT BLOWTORCH

6. Pump 25 to 30 full strokes of pressure into tank. (Use pump TA-110; see diagram on other side). Important: 25 to 30 strokes will give enough pressure—more pressure will make lighting more difficult.
7. After pumping pressure into tank, inspect torch for any leakage of gasoline. All CRAFTSMAN torches are inspected and are known to be leak-tight before they leave the factory, but there is always a possibility they may have been damaged in transit. Always observe this safety measure.
8. Fill drip cup three-quarters full of gasoline for use in pre-heating burner. See figure (C). Most convenient way to fill drip cup is to place your hand over the front end of the burner and open valve handle. Close valve when cup is three-quarters full and before lighting drip cup.

9. If gasoline spills out of drip cup, wipe up before igniting.

10. Light gasoline in drip cup with match. Keep torch out of draft while gasoline in cup is burning. Flame must burn against burner to do an efficient job of pre-heating, and will not do so if torch is left in draft and flame blows away from burner.

11. When gasoline in drip cup is nearly burned away, open valve slightly to allow gasoline to ignite inside of burner. If this does not

take place, light with match from slot near rear of burner.

12. When gasoline in drip cup is completely burned out, the burner flame will change to a blue color. The blue color indicates correct combustion. Open valve for flame size wanted.

13. If you want more flame, you can now add more pressure to the tank. **DO NOT PUMP MORE THAN 20 ADDITIONAL STROKES**, because after that point additional pressure will not increase the amount of flame. **Note: If excessive pressure is built up in the tank by an unreasonable amount of pumping a dangerous condition can be created.**

14. If flame remains yellow after the gasoline has burned out of the drip cup, then either the burner has not been sufficiently pre-heated or incorrect fuel has been used. Check by carefully repeating the pre-heating process (after burner has been allowed to cool) and if flame is still yellow replace the fuel being used. Be sure to follow fuel recommendations given under "How to Fill Blowtorch." Remember, this torch has been given a thorough burning test at the factory, and functioned perfectly at that time.

SAFETY FIRST OPERATION OF BLOWTORCHES

1. Never leave a blowtorch before it is generated and operating with a steady blue flame.
2. Do not point the flame against a flat surface, and leave in that position. This will reflect heat back against the tank, overheating it, and possibly causing internal pressure in the tank to be built up to the danger point.
3. Always inspect a blowtorch for overflow gasoline or for leaks before lighting. Observing these two safety precautions EVERY TIME will eliminate the possibility of a serious accident.

USEFUL OPERATING POINTERS

A. Fill the blowtorch properly. If a filler plug is provided in the bottom as on our Craftsman Torches, use it exclusively and never remove the pump except for repairs. Pumps on Craftsman Torches are cemented in place and if removed must be recemented with white lead, any pipe joint compound, or laundry soap on the threads. Avoid getting compound or soap in tank. Tighten with a wrench.

If there is no filler plug, the blowtorch must be filled from the top. To do this, unscrew the pump. Before replacing it, drop some oil on the pump gasket to keep it soft. Screw pump down tight.

B. Oil the pump leather occasionally by running a little fine oil down the plunger rod.

C. DO NOT CLOSE VALVE TOO TIGHTLY. Merely turn far enough to extinguish flame. Damage to the valve seat may result from too tight closing while burner is hot.

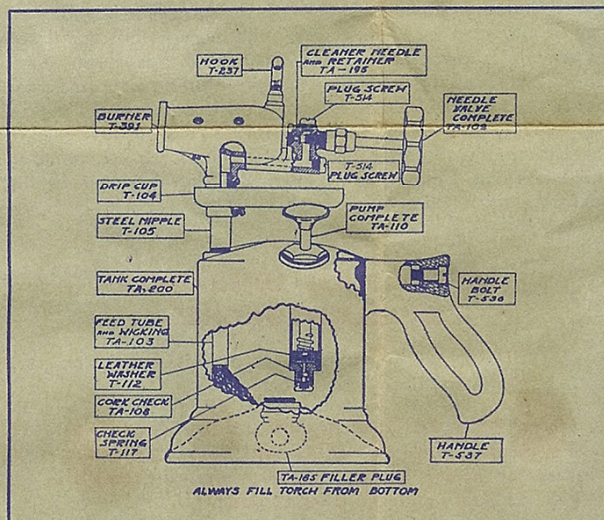
D. If, after 50 strokes of pumping, there is only a small flame, the burner is clogged and must be taken apart and cleaned.

E. Keep packing nut on valve stem tight enough to avoid leakage.

F. If too much pressure is put in the tank, the flame may be blown away from the front of the burner. Avoid excessive pressure by using the pump only when necessary, and with not more than a total of 50 strokes.

TO CLEAN BURNER

1. Unscrew packing nut holding valve stem of needle valve TA-109. See parts diagram below.



2. Unscrew and remove plug screws, T-514.

3. Unscrew steel nipple, T-105, from tank retaining burner assembly intact.

4. Pull feed tube, TA-102, up far enough to grip with wrench and unscrew it from steel nipple, T-105.

5. Be careful to pull feed tube out until wicking is exposed, so feed tube will not fall back into tank.

6. It is not necessary to separate burner from nipple.

7. Soak burner, valve stem and plug screws in vinegar for several hours—this softens carbon.

8. After soaking clean undervein and vertical vein of burner with stiff wire or drill. Work through the holes from which plug screws came.

9. If necessary re-soak in vinegar and reclean.

10. Clean valve stem and needle carefully.

11. Blow out veins and parts with compressed air if available. Make sure they are free of particles of carbon or dirt.

12. DO NOT attempt to clean needle hole in burner except with needle point of valve stem. Use of drill or wire may enlarge this hole and damage the burner.

13. When clean, replace plug screws tightly. Screw valve stem into place with packing nut. Tighten packing nut carefully.

14. Put a little laundry soap on threads of feed tube and screw VERY TIGHTLY into nipple.

15. Put laundry soap on steel nipple threads and screw the steel nipple and burner assembly TIGHTLY into the tank.

16. Test carefully for leaky joints.

REPAIR PARTS LIST AND PRICES

T -237	Hook.....	\$.14
T -391	Burner Casting.....	1.06
T -514	Plug Screw.....	.10
TA-195	Cleaner Needle and Retainer.....	.14
TA-109	Needle Valve Complete.....	.60
T -104	Drip Cup.....	.16
TA-110	Pump Complete.....	1.00
TA-200	Tank Complete.....	1.90
TA-183	Feed Tube and Wicking.....	.22
T -112	Pump Leather.....	.10
TA-108	Pump Check.....	.12
T -117	Pump Check Spring.....	.10
TA-185	Filler Plug with Lead Washer.....	.24
TA-158	Burner Complete.....	2.10
TA-191	Packing Nut and Packing.....	.18

SOLD ONLY BY SEARS, ROEBUCK AND CO.