

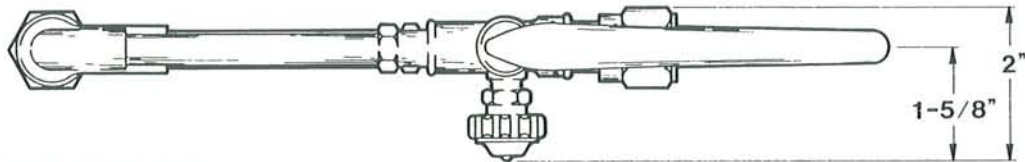
VICTOR[®]

PARTS AND SERVICE BULLETIN

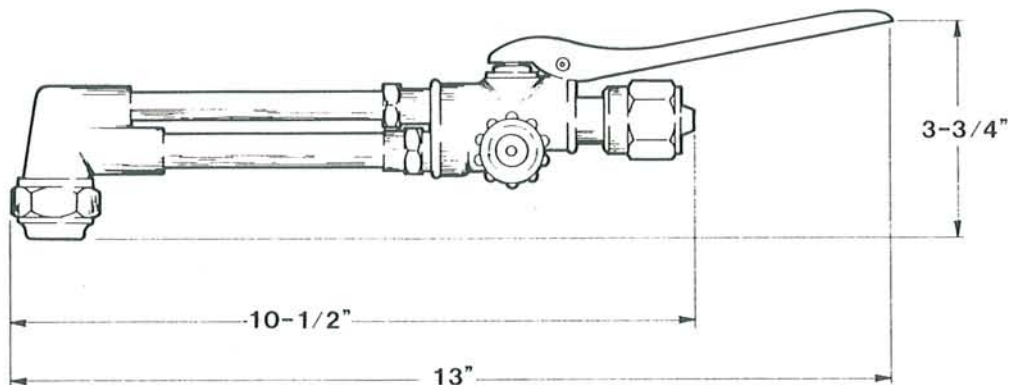
CA 1050/2050 &
CA 1060/2060 SERIES
CUTTING ATTACHMENT

FORM NO. 56-690

EFFECTIVE 6-87



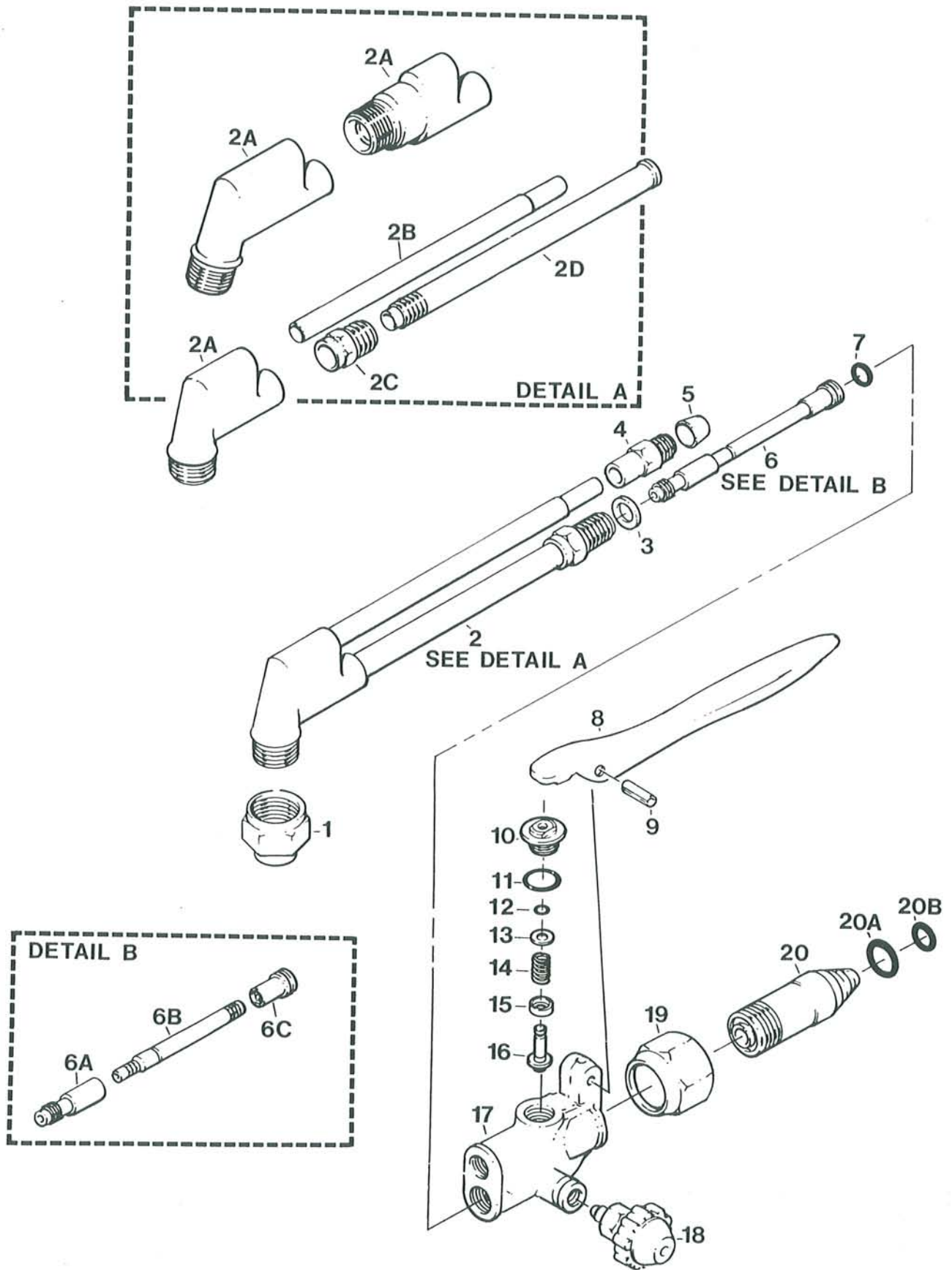
**THIS PRODUCT IS
DISCONTINUED
AND REPLACED BY
CA 2460**



WARNING

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 or repair, or modification of the product could result in damage to the product or injury to the operator.



PARTS LIST

REF. NO.	DESCRIPTION	CA 1050	CA 1051	CA 1052	CAN 1050	CAN 1051	CAN 1052	CA 2050	CA 2051	CA 2052
		90°	75°	180°	90°	75°	180°	90°	75°	180°
1	Tip Nut	0309-0018	0309-0018	0309-0018	0309-0018	0309-0018	0309-0018	0309-0003	0309-0003	0309-0003
2	Head and Tube Assembly	0340-0414	0340-0415	0340-0416	0340-0418	0340-0419	0340-0423	0340-0425	0340-0426	0340-0427
2A	Head	0302-0003	0302-0004	0302-0005	0302-0003	0302-0004	0302-0005	0302-0009	0302-0013	0302-0014
2B	Oxygen Tube	0303-0023	0303-0023	0303-0023	0303-0023	0303-0023	0303-0023	0303-0023	0303-0023	0303-0023
2C	Coupling Nut (Fuel)	0309-0016	0309-0016	0309-0016	0309-0016	0309-0016	0309-0016	0309-0016	0309-0016	0309-0016
2D	Fuel Tube	0313-0019	0313-0019	0313-0019	0313-0038	0313-0038	0313-0038	0313-0019	0313-0019	0313-0019
† 3	Gasket	1406-0075	1406-0075	1406-0075	1406-0075	1406-0075	1406-0075	1406-0075	1406-0075	1406-0075
4	Coupling Nut (Oxygen)	0309-0017	0309-0017	0309-0017	0309-0017	0309-0017	0309-0017	0309-0017	0309-0017	0309-0017
† 5	Ferrule	0316-0007	0316-0007	0316-0007	0316-0007	0316-0007	0316-0007	0316-0007	0316-0007	0316-0007
6	Mixer Assembly	0329-0004	0329-0004	0329-0004	0329-0017	0329-0017	0329-0017	0329-0004	0329-0004	0329-0004
6A	Mixer	0305-0003	0305-0003	0305-0003	0305-0004	0305-0004	0305-0004	0305-0003	0305-0003	0305-0003
6B	Inner Oxygen Tube	0303-0038	0303-0038	0303-0038	0303-0318	0303-0318	0303-0318	0303-0038	0303-0038	0303-0038
6C	Gas Separator	0316-0003	0316-0003	0316-0003	0316-0003	0316-0003	0316-0003	0316-0003	0316-0003	0316-0003
† 7	"O" Ring	1407-0013	1407-0013	1407-0013	1407-0013	1407-0013	1407-0013	1407-0013	1407-0013	1407-0013
8	Lever	0307-0004	0307-0004	0307-0004	0307-0004	0307-0004	0307-0004	0307-0004	0307-0004	0307-0004
9	Spirol Pin	1404-0002	1404-0002	1404-0002	1404-0002	1404-0002	1404-0002	1404-0002	1404-0002	1404-0002
10	Valve Cap/Bushing Ass'y.	0320-0111	0320-0111	0320-0111	0320-0111	0320-0111	0320-0111	0320-0111	0320-0111	0320-0111
† 11	O-Ring	1407-0016	1407-0016	1407-0016	1407-0016	1407-0016	1407-0016	1407-0016	1407-0016	1407-0016
† 12	O-Ring	1407-0005	1407-0005	1407-0005	1407-0005	1407-0005	1407-0005	1407-0005	1407-0005	1407-0005
† 13	Washer	1406-0006	1406-0006	1406-0006	1406-0006	1406-0006	1406-0006	1406-0006	1406-0006	1406-0006
† 14	Valve Spring	0320-0024	0320-0024	0320-0024	0320-0024	0320-0024	0320-0024	0320-0024	0320-0024	0320-0024
* † 15	Seat Assembly Bushing	0320-0108	0320-0108	0320-0108	0320-0108	0320-0108	0320-0108	0320-0108	0320-0108	0320-0108
* † 16	Seat Assembly	0320-0079	0320-0079	0320-0079	0320-0079	0320-0079	0320-0079	0320-0079	0320-0079	0320-0079
17	Body	0301-0005	0301-0005	0301-0005	0301-0005	0301-0005	0301-0005	0301-0005	0301-0005	0301-0005
† 18	Valve Stem Assembly	0662-0014	0662-0014	0662-0014	0662-0014	0662-0014	0662-0014	0662-0014	0662-0014	0662-0014
19	Coupling Nut	0309-0026	0309-0026	0309-0026	0309-0026	0309-0026	0309-0026	0309-0026	0309-0026	0309-0026
20	Cone End Assembly	0317-0003	0317-0003	0317-0003	0317-0003	0317-0003	0317-0003	0317-0003	0317-0003	0317-0003
† 20A	"O" Ring - Large	1407-0178	1407-0178	1407-0178	1407-0178	1407-0178	1407-0178	1407-0178	1407-0178	1407-0178
† 20B	"O" Ring - Small	1407-0177	1407-0177	1407-0177	1407-0177	1407-0177	1407-0177	1407-0177	1407-0177	1407-0177

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

* Items included in Seat Kit. Order PIN 0390-0035.

PARTS LIST

REF. NO.	DESCRIPTION	CA 1060	CA 1061	CA 1062	CAN 1060	CA 2060	CA 2061
		90°	75°	180°	90°	90°	75°
† 1	Tip Nut	0309-0018	0309-0018	0309-0018	0309-0018	0309-0003	0309-0003
2	Head & Tube Assembly	0340-0595	0340-0596	0340-0597	0340-0595	0340-0598	0340-0599
2A	Head	0302-0117	0302-0119	0302-0118	0302-0117	0302-0111	0302-0112
2B	HP Oxygen Tube	0303-0072	0303-0072	0303-0072	0303-0072	0303-0072	0303-0072
2C	Coupling Nut (Acetylene)	0309-0016	0309-0016	0309-0016	0309-0016	0309-0016	0309-0016
2D	Acetylene Tube	0303-0070	0303-0070	0303-0070	0303-0070	0303-0070	0303-0070
† 3	O-Ring	1407-0192	1407-0192	1407-0192	1407-0192	1407-0192	1407-0192
4	Coupling Nut (Oxygen)	0309-0017	0309-0017	0309-0017	0309-0017	0309-0017	0309-0017
5	Ferrule	0316-0007	0316-0007	0316-0007	0316-0007	0316-0007	0316-0007
6	Mixer Assembly	0329-0142	0329-0142	0329-0142	0329-0143	0329-0142	0329-0142
6A	Diffuser	0303-0388	0303-0388	0303-0388	0303-0389	0303-0388	0303-0388
6B	Mixer	0305-0201	0305-0201	0305-0201	0303-0202	0305-0201	0305-0201
6C	Inner Oxy. Tube	0303-0038	0303-0038	0303-0038	0303-0318	0303-0038	0303-0038
6D	Separator	0316-0022	0316-0022	0316-0022	0316-0022	0316-0022	0316-0022
† 7	O-Ring	1407-0013	1407-0013	1407-0013	1407-0013	1407-0013	1407-0013
8	Spring	0320-0110	0320-0110	0320-0110	0320-0110	0320-0110	0320-0110
9	Lever	0307-0004	0307-0004	0307-0004	0307-0004	0307-0004	0307-0004
† 10	Spirol Pin	1404-0002	1404-0002	1404-0002	1404-0002	1404-0002	1404-0002
† 11	Valve Cap/Bushing Ass'y.	0320-0111	0320-0111	0320-0111	0320-0111	0320-0111	0320-0111
† 12	O-Ring	1407-0016	1407-0016	1407-0016	1407-0016	1407-0016	1407-0016
† 13	O-Ring	1407-0005	1407-0005	1407-0005	1407-0005	1407-0005	1407-0005
14	Washer	1406-0006	1406-0006	1406-0006	1406-0006	1406-0006	1406-0006
15	Valve Spring	0320-0024	0320-0024	0320-0024	0320-0024	0320-0024	0320-0024

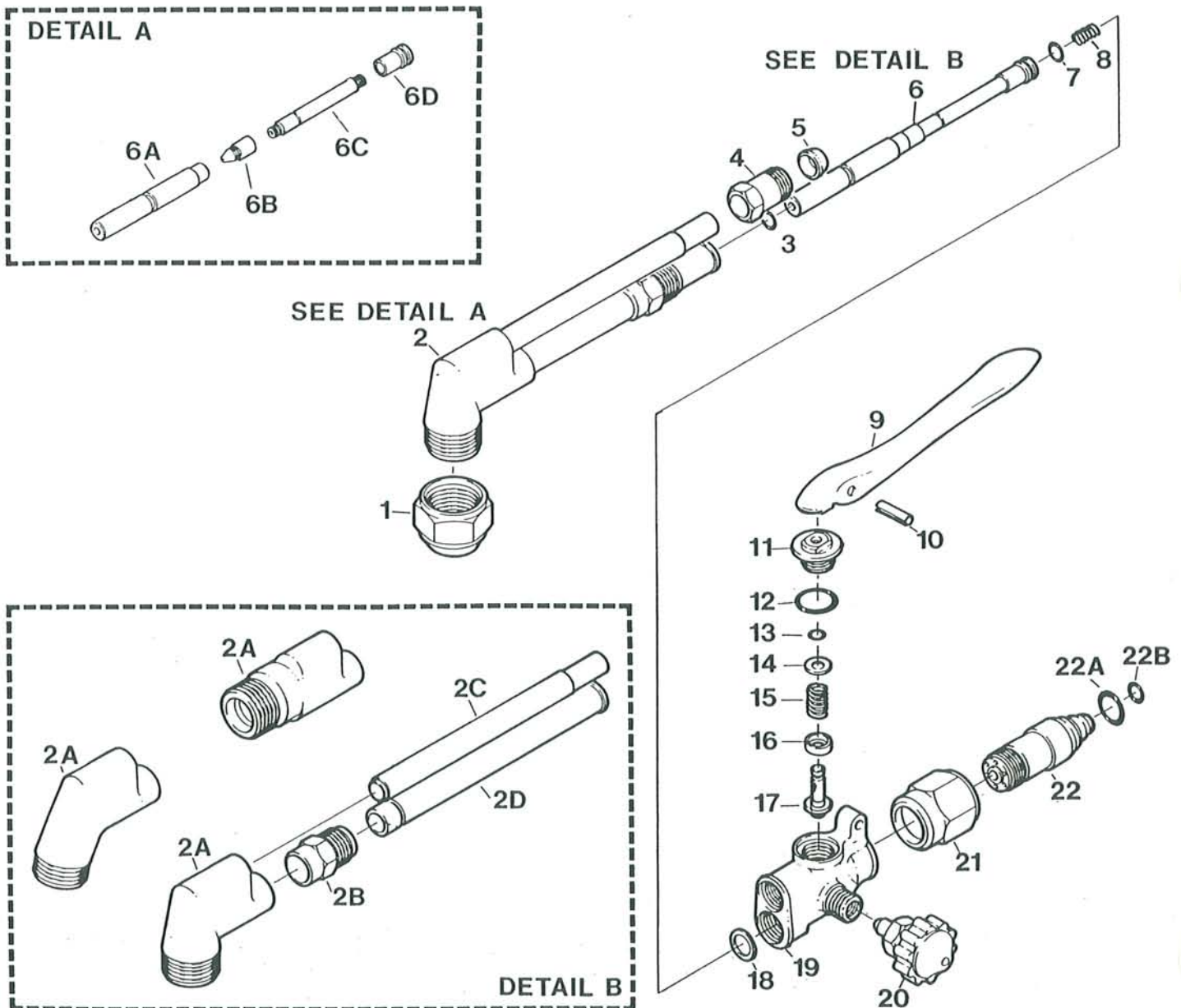
(cont.)

PARTS LIST (cont.)

REF. NO.	DESCRIPTION	CA 1060	CA 1061	CA 1062	CA 1060	CA 2060	CA 2061
		90°	75°	180°	90°	90°	75°
† 16	Seat Assembly Bushing	0320-0108	0320-0108	0320-0108	0320-0108	0320-0108	0320-0108
† 17	Seat Assembly	0320-0079	0320-0079	0320-0079	0320-0079	0320-0079	0320-0079
18	Gasket	1406-0075	1406-0075	1406-0075	1406-0075	1406-0075	1406-0075
19	Body	0301-0005	0301-0005	0301-0005	0301-0005	0301-0005	0301-0005
† 20	Valve Stem Assembly	0662-0014	0662-0014	0662-0014	0662-0014	0662-0014	0662-0014
21	Coupling Nut	0309-0026	0309-0026	0309-0026	0309-0026	0309-0026	0309-0026
22	Cone End Assembly	0317-0003	0317-0003	0317-0003	0317-0003	0317-0003	0317-0003
22A	O-Ring	1407-0178	1407-0178	1407-0178	1407-0178	1407-0178	1407-0178
22B	O-Ring	1407-0177	1407-0177	1407-0177	1407-0177	1407-0177	1407-0177

† Items most commonly required for torch repair and recommended for stock. Order Repair Kit P/N 0390-0032.

* Seat assembly bushing (16) and seat assembly (17) may be purchased under P/N 0390-0035, Seat Kit.



**IMPORTANT REPAIR NOTES
FOR NEW CA1060 CUTTING ATTACHMENTS**

1. The upper **and** lower tubes on the CA1060/2060 attachments use a **slip fit soldered joint** instead of a threaded connection. When repairing make sure tubes are bot-tomed out in the torch head before brazing.

When brazing tubes to the torch head, tube alignment can be simplified by finger tightening the coupling nuts to the torch body. (*NOTE — The mixer should not be installed in mixer tube while brazing.)

2. On the new CA1060 and CA2060's the **diffuser** and the **mixer assembly** can be removed as **one unit**. On the old CA1050 and CA 2050's the diffuser was per-manently staked to the mixer tube.
3. When assembling the new CA1060 mixer assembly and diffuser apply a small amount of Loctite #59 to threads and tighten to 30 inch lbs. to obtain a firm metal-to-metal seal.
4. Apply one drop of Flurolube lubricant to seat assembly bushing 0320-0108 (Ref. #16) and O-Ring 1407-0005 (Ref. #13) before installation in body.
5. Apply one drop of Flurolube lubricant to O-Rings 1407-0192 (Ref. #3) and 1407-0013 (Ref. #7) before installation in head and tube assembly.

NOTE: The following "New" parts may be used on the old CA 1050 Series attachments:

Ref. No.

2. Head and Tube Assembly ... will fit on 1050 Series, but requires Item 3, O-Ring (1407-0192) Item 6, Mixer and Inner Oxygen Tube Assy. (0329-0142) and Item 8, Spring (0320-0110).
 11. Valve Cap/Bushing Assy. ... will fit 1050 Series, and is recommended to replace old valve cap (0320-0017).
 17. Seat Assembly ... will fit CA 1050 Series, but requires Item 16, Seat Assy. Bushing (0320-0108). These two items are recommended to replace old seat assembly (0320-0008) See note above.
-

WORLD HEADQUARTERS: 101 S. Hanley Road • St. Louis, MO 63105 • 314-721-5573 • FAX 314-721-4822

THERMADYNE®

VICTOR®

Victor Equipment Company

**U.S.A.
Customer Service**
P.O. Box 1007
Denton, TX 76202-1007
800-426-1888
FAX 800-535-0557

International Customer Service
2070 Wyecroft Road
Oakville, Ontario L6L5V6
Canada
905-827-9777
FAX 905-827-9797

Canada
2070 Wyecroft Road
Oakville, Ontario L6L5V6
Canada
905-827-1111
FAX 905-827-3648

Europe
Europa Building
Chorley North Industrial Park
Chorley, PR6 7BX, England
44-1257-261755
FAX 44-1257-261756

Asia/Pacific PTE, Ltd.
Hillview House Units 401-403
1 Jalan Remaja
Singapore 668662
65-763-4022
FAX 65-763-5812

Mexico
Calle de Zaragoza #25
Col. Santa Cruz Atoyac
C.P. 03910 Mexico, D.F.
52-5-605-8408
FAX 52-5-604-9671