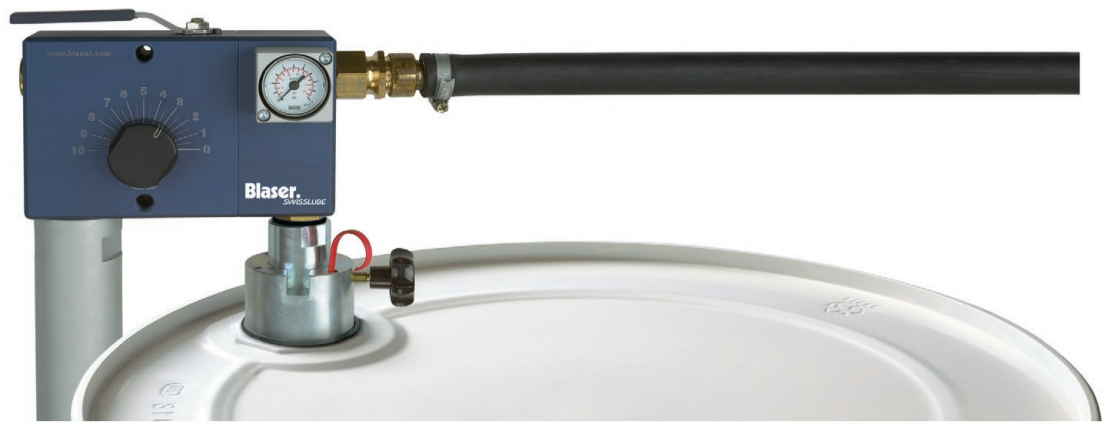


Jetmix drum mounted

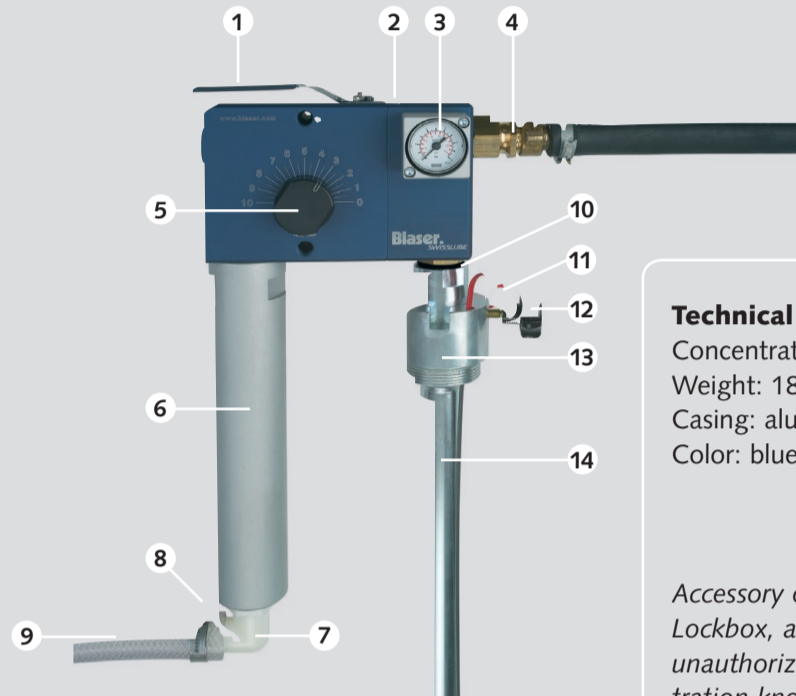
Art. 9275



Assembly and service manual

The Jetmix is the ideal mixing device for preparing homogeneous and finely dispersed emulsions of cutting-fluid concentrate into water. The Jetmix correctly mixes proper emulsions at constant concentration. Proper preparation of emulsions is required for the longevity and stability of cutting fluids.

- 1 Combined handle for both water and concentrate
- 2 Integrated backflow preventer (DIN 1988)
- 3 Manometer (water pressure)
 - Handle closed: static pressure
 - Handle open: dynamic pressure
- 4 G 3/4" (male thread plus 3/4" female garden hose adapter)
- 5 Turning knob for setting of concentration
- 6 Jet pipe (with wrench size 46 mm)
- 7 Plastic angle
- 8 Hose clamp
- 9 Emulsion outlet hose 1" (25 mm) with hook
- 10 Seal
- 11 Concentrate level dipstick
- 12 Clamping screw
- 13 Screwed flange to fix on the drum
- 14 Inlet pipe with check valve



Technical data:

Concentration range: 0 – ca. 25 %
 Weight: 18 lbs (8.4 kg gross)
 Casing: aluminium
 Color: blue

Accessory on request:
 Lockbox, art. 9277 to prevent unauthorized turning the concentration knob 5

Before startup:

The recommended water hose has a 3/4" inner diameter over the whole length and a dynamic water pressure of at least 30 psi (2 bar). The hose and connections must be leak free. The water connection must be protected according to the regional regulations, so that a back-flow of emulsion into the water network is prevented in all cases.

Assembly:

1. Screw concentrate inlet pipe 14 to Jetmix with seal 10
2. Fix emulsion outlet hose 9 with the hose clamp 8 to the plastic angle 7

Startup:

3. Screw flange 13 into bung hole of drum
4. Insert dipstick 11 in the hole of the flange
5. Check ball of the check valve on the bottom of inlet pipe 14 to be sure it is moving freely
6. Insert inlet pipe with the mounted Jetmix into the flange on top of the drum and fix it with clamping screw 12
7. Place the outlet hose over the coolant tank of the machine. The hose should not exceed 30 feet (10 m) and must be free of kinks. The elevation of the hose end should be within 6 feet (2 meters) higher or lower to Jetmix. Make sure end of the hose is not submerged to prevent possible syphoning of concentrate
8. Calibrate Jetmix with refractometer. The required position on the knob depends on the concentrate viscosity and the water pressure
9. Set the desired concentration by the turning knob 5
10. First apply water pressure to the line before turning on the combined handle 1
11. To turn it off: combined handle 1 must always be turned off first (before water supply). After water is turned off, relieve the pressure in the hose by opening the handle 1.



Important – please note:

- Always operate (on-off) the Jetmix by the combined handle 1 another valve in the water supply system alone is not recommended
- Do not deform, kink or enlarge outlet hose 9
- All threaded connections have to be sealed
- Do not remove the plastic angle 7
- When the device is not in use, the pressure should be released from the water hose and it is recommended to separate it from the main line or allow slack in the hose well below level of the Jetmix

Requirements for a smooth function:

Water pressure: dynamic 30 – 90 psi (2 – 6 bar)
 Flow rate at 90 psi: 1800 l/h
 Water connection: G 3/4" male

Possible reasons for trouble:

- Insufficient dynamic water pressure (not enough pressure or water quantity)
- Blocked inlet pipe
- Suction of air instead of concentrate (seal thread)
- Contaminated mixing chamber
- Unqualified manipulation of Jetmix (disassembling, fitting on strange objects, etc)
- Concentration set at 0
- Concentrate drum is empty