

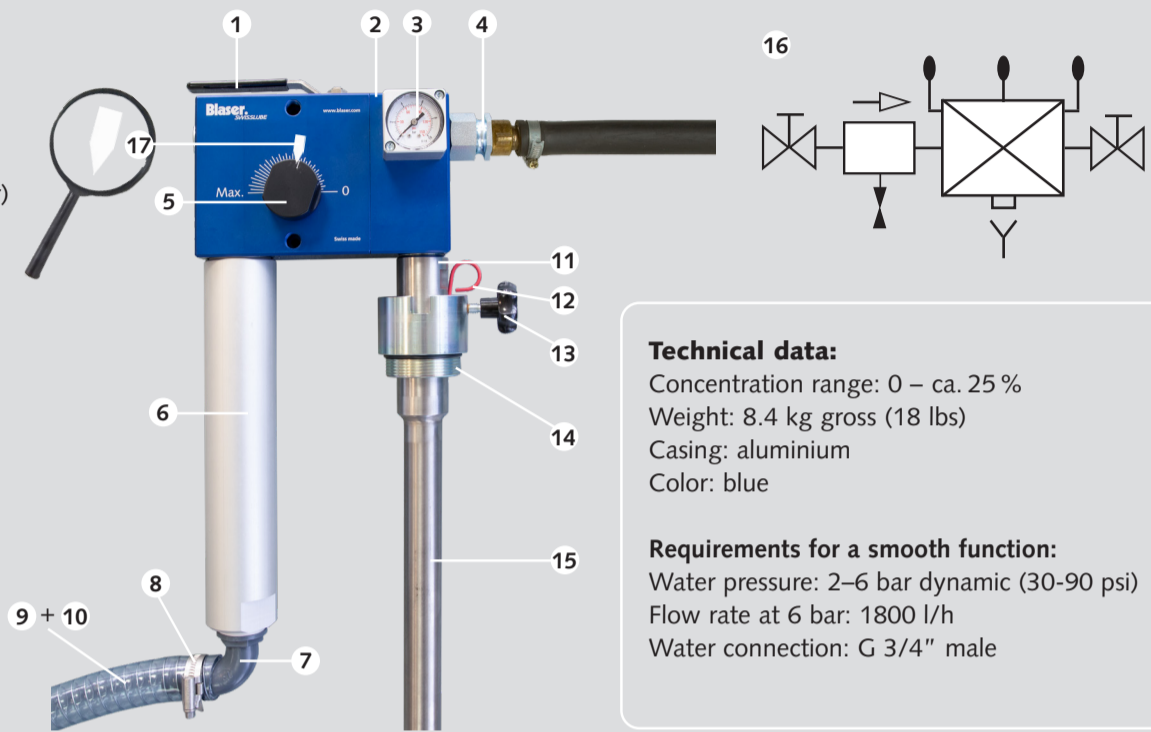
Jetmix drum mounted

Art. 09275-01

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 the concentration
- 6 Jet pipe (with wrench size 46 mm)
- 7 Pipe elbow 90°
- 8 Hose clip
- 9 Emulsion outlet hose 1" (25 mm) with
- 10 hook or outlet spout
- 11 Seal
- 12 Measuring rod
- 13 Clamping screw
- 14 Threaded flange to fix on the drum
- 15 Suction pipe with check valve
- 16 System separator type BA according to EN 1717
- 17 Marking sticker (for reorder)



Technical data:

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

Requirements for a smooth function:

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

Before startup:

The recommended water hose has a 3/4" diameter over the whole length and a dynamic water pressure of at least 2 bar (30 psi). 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. In Europe, the water connection must be protected by a system separation device of the BA type 16 according to the EN 1717 standard.

Assembly:

1. Screw concentrate suction pipe 15 to Jetmix with Seal 11
2. Mount emulsion outlet hose 9 with the hose clip 8 to the pipe elbow 7

Startup:

3. Screw threaded flange 14 into bung hole of drum
4. Insert measuring rod 12 in the hole of the flange
5. Check ball of the check valve on the bottom of suction pipe 15 to be sure it is moving freely
6. Insert suction pipe with the mounted Jetmix into the flange on top of the drum and fix it with clamping screw 13
7. Place the outlet hose over the coolant tank of the machine. The hose should not exceed 10 m (30 feet) and must be free of kinks. The elevation of the hose end should be within 2 meters (6 feet) 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 pipe elbow 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

Possible reasons for trouble:

- Insufficient dynamic water pressure (not enough pressure or water quantity)
- Blocked suction tube
- Suction of air instead of concentrate (seal thread)
- Blocked or clogged nozzle
- Incorrect modification of Jetmix (disassembling, fitting on strange objects, etc)
- Turning knob set to 0
- Concentrate drum is empty



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