

Lily Pond Products

Division of Glaser Ceramics

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BIG PUDDLE / SUPER PUDDLE ASSEMBLY INSTRUCTIONS - Page 1

Models: BP / SP

Congratulations on your purchase of the LilyPond Products Big Puddle Series. We are justifiably proud of our products, not only for the fine materials used, but for their record of long productivity.

**PLEASE READ ALL OF THE INSTRUCTIONS CAREFULLY
BEFORE OPERATING THIS MACHINE!**

Your LilyPond Product has been preassembled to save you time and energy. Some parts have been disassembled for shipping purposes. To assemble your new Heavy-Duty Slip Casting Pour Table follow the step-by-step instructions.

Tools needed:

- 1/8" Allen wrench (included)
- Flathead Screwdriver

Parts included:

- 4 Hex Nuts
- 4 Slotted Head Bolts
- 4 Hex Head Screws
- 1 Loop Bolt with Hex Nut



Big Puddle

1. **Frame.** There are 8 pieces to the frame. Each side uses 3 pieces with a floor bracket in between the two sides. Important: With a shim or wedge, create a 1/8" - 1/4" space under the body of the Big Puddle before assembly. (Image 1). This is key in lining up the holes of the machine. The Big Puddle is designed so that the weight of the slip combined with the frame uses gravity to create a solid base form. If frame is not assembled first, the weight of other attachments cause holes to be misaligned.
 - Using the longest frame piece first, slide it under the tank making sure the holes are to the outside facing you. **Notice: there is a right side and a left side of the frame.**
 - Next, using one of the shorter side pieces with the slotted stainless steel bolt, fasten the end with the Tab to the underside corner of the drain board matching up the pre-drilled hole with the hole in the frame. (Image 2). **The tab should be facing you.**
 - Assemble the base corners. (Image 3). Fasten the bottom end of side piece to the end of the longest frame piece matching up the holes. Line up the floor bracket with the corner holes, and insert the bolt. Make sure the flat head on the bolt is to the inside of the tank and the nut is to the outside of the tank and frame. (Image 4). Repeat this step for all four sides.



Gap space 1/8" - 1/4".

Image 1.



Image 2.

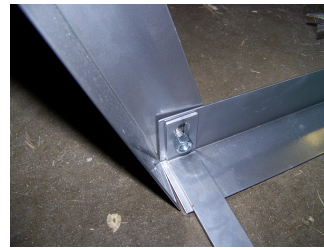


Image 3.

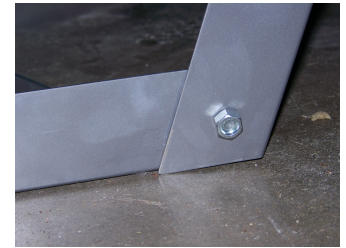


Image 4.

2. **Gate Valve Drain Assembly.** Refer to Gate Valve Drain Assembly Diagram. Unscrew the male fitting (100-34) and 2" washer (100-33) from Gate Valve (100-32). Insert the Gate Valve into the pre-drilled hole at the base of the tank. Secure tightly by re-attaching the male fitting to the Gate Valve inside the tank. **(Rubber 2" Washers (100-33) go inside the tank).** Pre-attached Screen (100-35).

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3. **Pumping Unit.** Place Pumping Unit at the base of the tank in-line with the Gate Valve Drain Assembly. Attach pump inlet to the Connection Tube (100-31). Connect the other side of the Connection Tube to the Gate Valve Drain Assembly (100-32). Tighten both Hose Clamps (100-30) securely with a screwdriver, one on each side of the Connection Tube.
4. **Bypass Assembly.** Screw the plastic 'T' Bypass Tee (100-17) onto the Pump Head (M100). Facing the front of the pump, the small end should be pointing to the right. Pull the 1/2" Plastic Adapter (100-27) off of the Bypass Hose (100-26) and place it into the pre-threaded hole at the base of the container securely. Place the Bypass Hose back into the Plastic Adapter. Attach the other end of the Bypass Hose to the Pump Bypass Tee Assembly. Secure Clamps (100-28) at both ends of the Bypass Hose with a screwdriver.
5. **Clear Hose / Nozzle.** Attach the 1" by 6' Reinforced Clear Hose(200-31) to the Bypass Tee (100-17). Tighten the Hose Clamps to the Clear Hose with a screwdriver. Attach Nozzle Adapter and Nozzle.
6. **Switch & Cord.** Attach switch and cord (200-2) to the underside of the drain board with the Eye Bolt (200-30) into the pre-drilled hole on top of the tank. The Cap Nut from the Eyebolt goes inside the top of the machine.
7. **Reinforcement Rods.** Slide a Stainless Steel Reinforcement Rod (200-23) through each set of the pre-drilled holes on the side of the Tank. On the outside of the Tank, place a washer on the Reinforcement Rod followed by a 1/4" Nut at each end of the Reinforcement Rods and tighten.
8. **Wooden Rack.** Place Wooden Rack (200-25) on top of Tank.
9. **Mixer.** Use the Stainless Steel Coupler with the Set Screw (200-4) to attach the Mixer Shaft (200-28) to the Mixer Motor (200-34). Make certain that the set screw in the Coupler (200-4) is placed on the flat surface of the Motor Shaft. Tighten screw with a 1/8" Allen Wrench. Place Mixer on top of Wooden Rack, at the center, between the two wooden dowels that are the furthest apart. Mixer Bracket (200-29) is already attached.
10. **Plastic Cover.** Place a protective plastic drop cloth over your table to keep your slip from drying out. If you are planning to not use your table for some time, remove the mixing unit and rack. Then, place the cover over the table and replace the rack. This will help give an air tight seal. Read *Mixing Slip with LilyPond Mixers* for additional ways to keep your slip from drying out.

YOU ARE NOW READY TO MIX GREAT THINGS!

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BIG PUDDLE / SUPER PUDDLE OPERATING INSTRUCTIONS

Models: BP/SP

Tools needed: Pliers

**PLEASE READ ALL OF THE INSTRUCTIONS CAREFULLY
BEFORE OPERATING THIS MACHINE!**

- **MOTOR BEARINGS ARE PRE-OILED AND SEALED.**
- **BEARINGS ONLY NEED TO BE OILED ONCE A YEAR.**
- **DO NOT OVER OIL MOTOR BEARINGS.**

- *The pump motor should not be left running or turned on when machine is empty or unattended.*
- *This may burn up the motor and void any and all warranties on the entire machine automatically.*

1. **Pull up on the handle to open the Gate Valve.** The Gate Valve in the Gate Valve Drain Assembly has been specially designed and valve must be open at all times while pouring.
Exceptions to this rule are:
 - When mixing Slip.
 - When it is necessary to remove the Motor or Pump Head for any reason.
 - * In such cases, simply close the Gate Valve and loosen the Hose Clamp from Pump Inlet.
 - * Be very careful and make certain that all electrical current is disconnected.
2. **How to Mix Slip in your Lily Pond Big Puddle and Super Puddle.**
 - *Check that the Gate Valve is closed when you start to mix slip. This will keep clay powder from lodging in the Pump Head.*
 - *Open the Gate Valve after the liquid has been initially mixed and well blended. Follow the included recipe and instructions for: *Mixing Slip with LilyPond Mixers.**
4. **Adjust the Mixer Bracket to fit snugly on the Wooden Rack.** This will cut down on any vibration that you may have. Find the tab that fits around the wooden dowel. Use a pair of pliers and bend one side of the tab inward until snug.
5. **To Reclaim Scraps or Trimmings.** In a separate container, place scraps and trimmings with just enough water to cover the top of your scraps and trimmings. This will keep them moist. At day's end, place trimmings in the mixer. Using only your Mixer, mix for 15-20 minutes until blended. Pour back into the main tank. Reweigh your slip before your next pour.
6. **The ByPass Assembly** is designed to relieve pressure from the Pump while you are pouring. This also creates a steady flow of slip from the nozzle.

DO NOT LEAVE MOTOR RUNNING AT ANY TIME WHEN MACHINE IS NOT IN USE OR UNATTENDED.

YOU ARE NOW READY TO GO! GOOD LUCK AND GOOD MIXING!

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MIXING SLIP WITH LILYPOND MIXERS FORMULA AND INSTRUCTIONS

Models: Mixers, Big Puddle, Super Puddle

**PLEASE READ ALL OF
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CAREFULLY BEFORE
MIXING SLIP!**

Formula:

Dry Clay Blend	Water	Soda Ash (by weight)	Silicate (by liquid volume)
50 lb. Mix	11 ½ Qt.	½ Oz.	2 Oz.
100 lb. Mix	5 Gal. 3 Qt	1 Oz.	4 Oz.

* One 50 lb. bag or Dry Clay is equivalent to 5 gallons of slip.

* For Big Puddle: It is best to start with 300 lbs. of clay for your first time use. Simply multiply above formula by three.

Procedure for Mixing Slip:

Correct measurements are **very important**.

1. Mix Chemicals (Soda Ash, Silicate) and Water together.
2. Add and mix Dry Clay Blend, one bag at a time.
3. Mix until well blended (10 minutes = 50 lb. bag, 30 minutes = 100 lb. bag). **It is not necessary to overmix your Slip. The enzyme in Slip will start to grow quicker if you allow your Slip to set.** It is difficult for this process to start while your Slip is still moving.
4. Let Slip set overnight to soak. Remix in morning (10 minutes = 50 lb. bag, 20 minutes = 100 lb. bag).
5. Weigh one Liquid Quart. Slip should weigh 56 oz. a quart, minus the weight of the container. This is the correct weight for pouring Ceramic, Porcelain, or Stoneware Slip. **DO NOT ADD ADDITIONAL CHEMICALS.** *If the slip is too heavy, add small amounts of water. If the slip is too light, add small amounts of clay.*

Notes:

- New slip can be mixed on top of old Slip. Not need to empty your mixer to mix slip. Remember you can move the propellers up and down on the shaft by loosening the set screws. Be sure to re-tighten them.
- Slip can stored in your **Heavy Duty Mixer** indefinitely. To keep slip from drying out on top, pour a couple cups of water on each drain board so that water will run down and lay on top of slip. This process keeps air from drying out the Slip. *(This procedure is similar to the one used in preserving jelly by sealing it with wax.)* For the **6 Gallon Mixer**, turn faucet to off position to close. Pour a cup of water on top of your slip and cover with a plastic drop cloth.
- The amount of water you should use will be determined by: 1. The length of time unused, 2. The humidity, and 3. The temperature.

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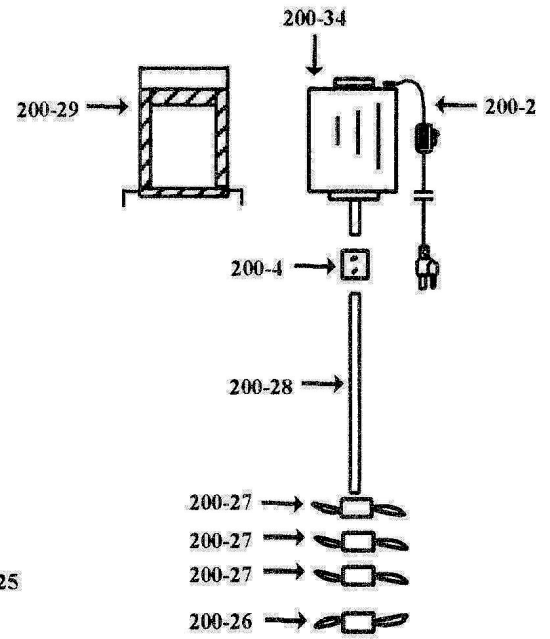
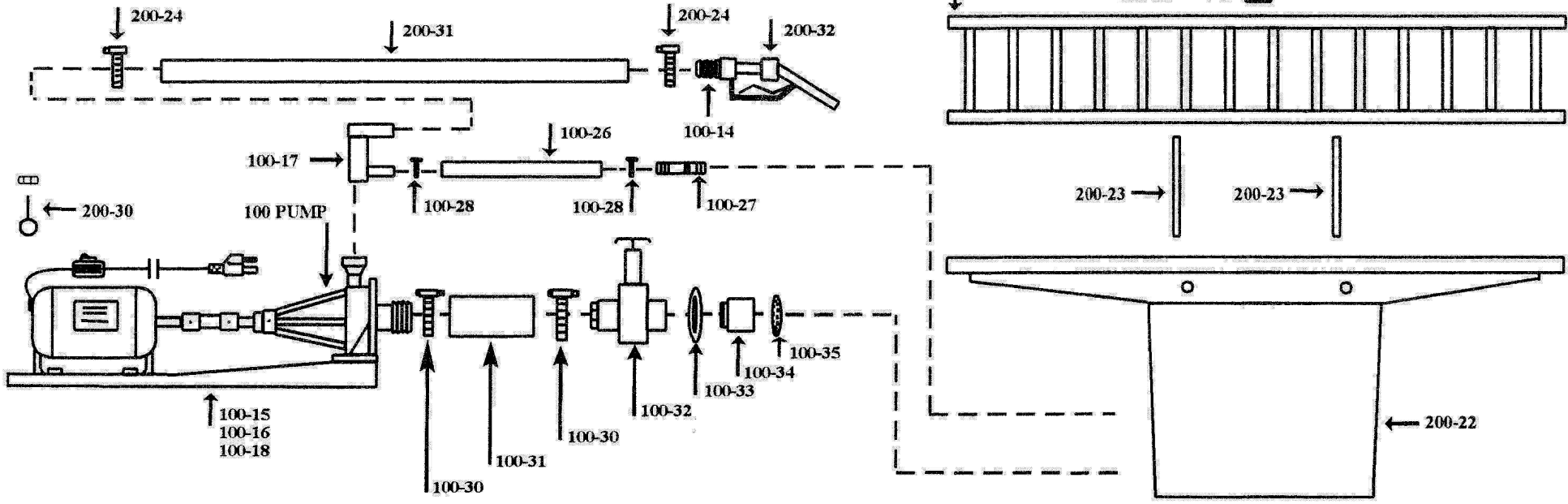
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BIG PUDDLE ASSEMBLY

Model:



Part #	Qty	Description	Part #	Qty	Description
M100	1	MODEL 100 PUMP	M200-50	1	Portable Mixing Unit
M100-14	1	1" Plastic Nozzle Adapter	200-34	1	1 / 2 HP Motor
M100-15	1	(Optional) Flex Coupling	200-2	1	Cord with Switch
M100-16	1	(Optional) Pump Base	200-4	1	SS Coupler with Set Screws
M100-17	1	(Optional) Bypass Tee	200-22	1	Big Puddle Form
M100-18	1	(Optional) 1/3 HP Motor	200-23	2	Reinforcement Rods
M100-2	1	Face Plate	200-24	2	#16 Hose Clamp
	1	Impeller + Shaft	200-25	1	Big Puddle Wood Rack
M100-4	2	Gasket	200-26	1	Bottom Mixer Blade
M100-7	3	Packing	200-27	2	Top Mixer Blade
M100-8	2	Bushing	200-28	1	Stainless Steel Shaft
M100-9	1	Packing Gland	200-29	1	Mixer Bracket with Handle
M100-10	2	#10-24 x 3/4 Screw	200-30	1	Eye Bolt with Nut
M100-11	1	Bushing Stand-Off	200-31	1	Reinforced Hose 1"
M100-12	1	Set Collar	200-32	1	1" Nozzle Flow Regulated
			200-35	1	Allen Wrench 1/8"

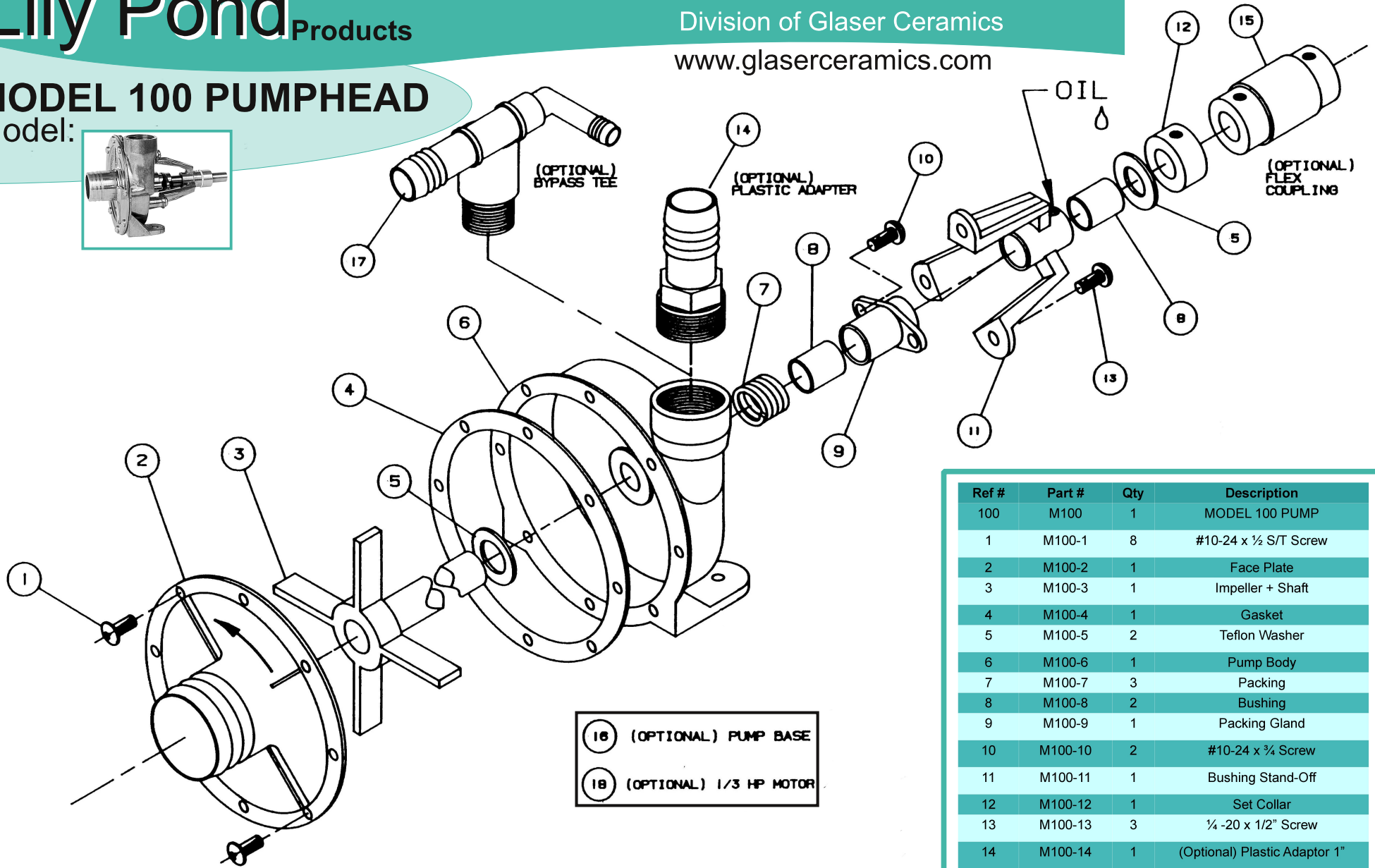
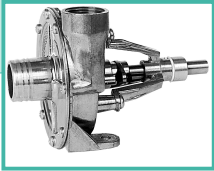


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MODEL 100 PUMPHEAD

Model:



16 (OPTIONAL) PUMP BASE
19 (OPTIONAL) 1/3 HP MOTOR

Ref #	Part #	Qty	Description
100	M100	1	MODEL 100 PUMP
1	M100-1	8	#10-24 x 1/2 S/T Screw
2	M100-2	1	Face Plate
3	M100-3	1	Impeller + Shaft
4	M100-4	1	Gasket
5	M100-5	2	Teflon Washer
6	M100-6	1	Pump Body
7	M100-7	3	Packing
8	M100-8	2	Bushing
9	M100-9	1	Packing Gland
10	M100-10	2	#10-24 x 3/4 Screw
11	M100-11	1	Bushing Stand-Off
12	M100-12	1	Set Collar
13	M100-13	3	1/4 -20 x 1/2" Screw
14	M100-14	1	(Optional) Plastic Adaptor 1"
15	M100-15	1	(Optional) Flex Coupling
16	M100-16	1	(Optional) Pump Base
17	M100-17	1	(Optional) Bypass Tee
18	M100-18	1	(Optional) 1/3 HP Motor
19	M100-RK	1	Rebuild Kit

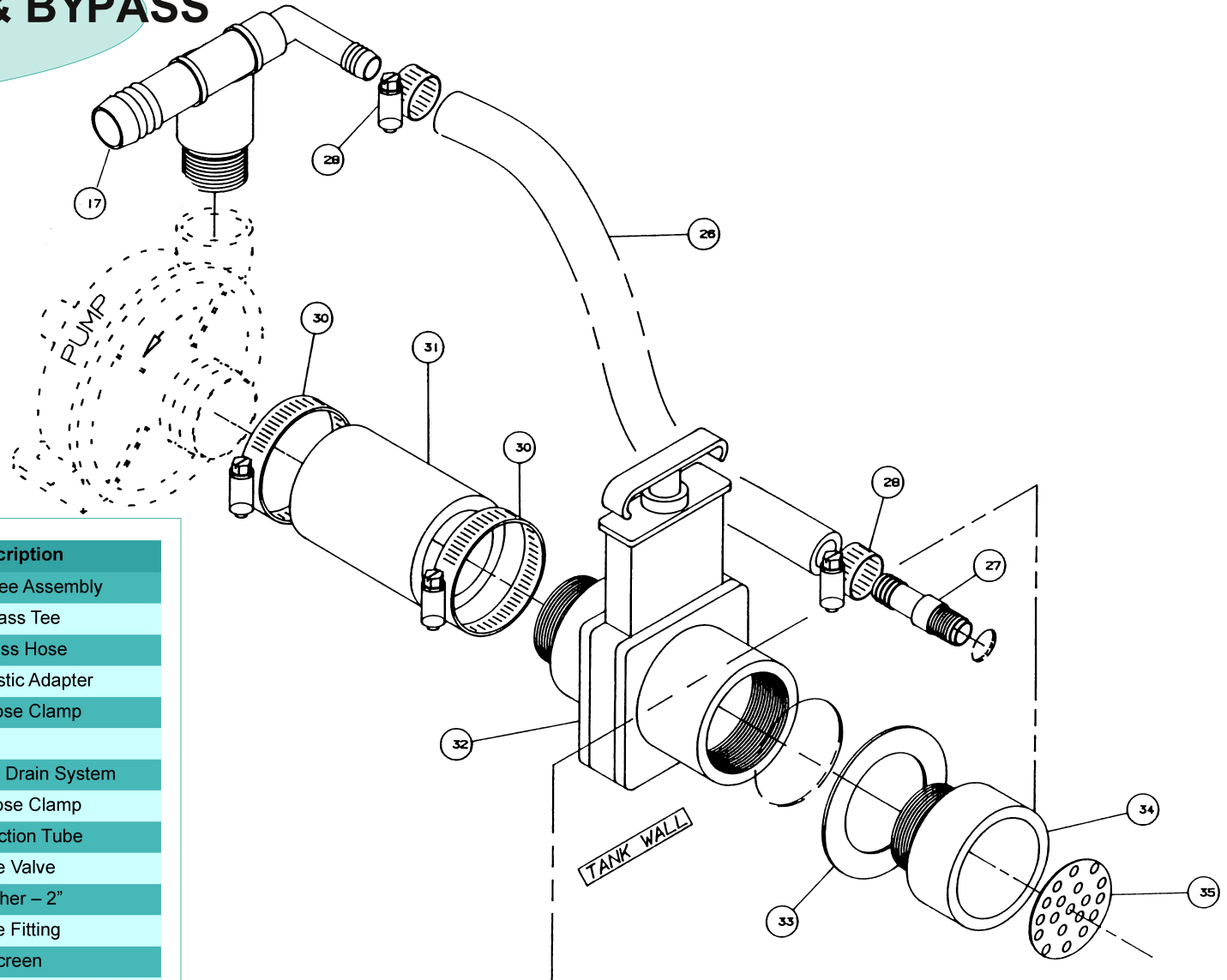
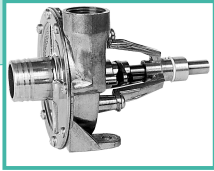
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GATE VALVE DRAIN & BYPASS

Model:



Ref #	Part #	Qty	Description
25	M100-25	1	Bypass Tee Assembly
17	M100-17	1	Bypass Tee
26	M100-26	1	Bypass Hose
27	M100-27	1	1/2" Plastic Adapter
28	M100-28	2	#10 Hose Clamp
29	M100-29	1	Gate Valve Drain System
30	M100-30	2	#24 Hose Clamp
31	M100-31	1	Connection Tube
32	M100-32	1	Gate Valve
33	M100-33	1	Washer - 2"
34	M100-34	1	Male Fitting
35	M100-35	1	Screen
14E	M100-14E	1	(Optional) Plastic Adaptor Elbow