

Lily Pond Products

Division of Glaser Ceramics

www.glaserceramics.com

33 GALLON HIGH-BOY^{with MIXER} Model: 33MPHBM

All-in-One Compact Machine!



Mixer unit shown removed

Pumping unit shown removed

Mixing, Pouring, Reclaiming Machine

This compact machine will Mix, Pour, and Reclaim your favorite Ceramics, Porcelain, or Stoneware Slip. The solid wooden rack allows molds to be drained directly into the tank. No waste. Store slip right in the tank. This machine includes casters allowing you to freely maneuver around your casting area. Complete with 1/3 HP Mixing unit and 1/3 HP Pumping unit. Trimmings can be easily reclaimed with the mixer. Use all scraps. New type of pump helps eliminate air bubbles. The tank will operate with a range from 1 to 33 gallons of your favorite slip. Molds with small pour openings are no longer a problem with the flow regulated nozzle. All this in one compact machine!

Carton contains:

- Compact Container: 24"x28", 35" in height
- 1/3 HP Mixer, Stainless Steel Mixing Shaft
- 1/3 HP Pump, Campbell Pump Head with Strainer
- Hardwood rack and Protective Lid
- Die-cast aluminum mixing propellers (not plastic)
- Casters for easy maneuvering
- Flow Regulated Nozzle
- 6' of 3/4" Clear Plastic Hose
- Strainer helps to eliminate lumps
- 1 to 33 gallon tank capacity
- Five year limited warranty

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33 GALLON HIGH-BOY^{with MIXER} ASSEMBLY INSTRUCTIONS

Model: 33MPHBM

Congratulations on your purchase of the LilyPond Products Mid Pumper 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 simply do the following :

Tools needed:

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



1. **Assemble Base.** Set the bottom section (small) on the casters. Remove the bolt hardware from the top section (large). Align the holes in the top section with the holes in the bottom section and insert the (4) bolts, with 1" rubber washers and large stainless steel washer, through the top holes. From the opening in the bottom section, install the plated washer, lock washer, and nut. Tighten bolts. *(A 2nd person may be necessary to hold the bolts from the top while being tightened from the bottom.)*
2. **Install Drain Assembly.** Drain Assembly is black with (2) pieces of clear hose and a gray elbow assembled in a plastic bag with other parts. Also find the white male adapter with a stainless steel screen and seal in the same bag. The male adapter is pushed through the drain hole from the top. Drain assembly is positioned from the opening in the bottom section. Align the (2) parts and tread the male adapter into the Drain Assembly until tight. Take care not to cross threads. *(A 2nd person may be necessary to assist.)*
3. **Attach Pump Adapter.** Screw pump adapter into outlet on pump. Attach nozzle with nozzle adapter to one end of clear hose. Then, attach other end of hose to pump adapter and secure with hose clamps.
4. **Pumping Unit.** Place Pumping Unit inside underneath into the opening. Slip the Pumping Unit into the plastic hose elbow of the Drain Assembly and secure with a hose clamp.
5. **Switch & Cord.** Attach switch and cord (200-2) to outside of container through Tank hole. Unscrew the Stainless Steel Cap-Nut. Slide the bolt through the pre-drilled hole on the front side of Tank. Re-attach the Cap-Nut on the inside of the Tank.
6. **Attach Mixing Shaft.** Place Wooden Rack on top of container. Attach Mixing Shaft to Motor Shaft and tighten Allen Screws. Place Mixing Unit on top of the Wooden Rack.

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33 GALLON HIGH-BOY^{with MIXER} OPERATING INSTRUCTIONS

Model: 33MPHBM

**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 Heavy-Duty Slip Casting Pour Table.**
 - *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
THE INSTRUCTIONS
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:

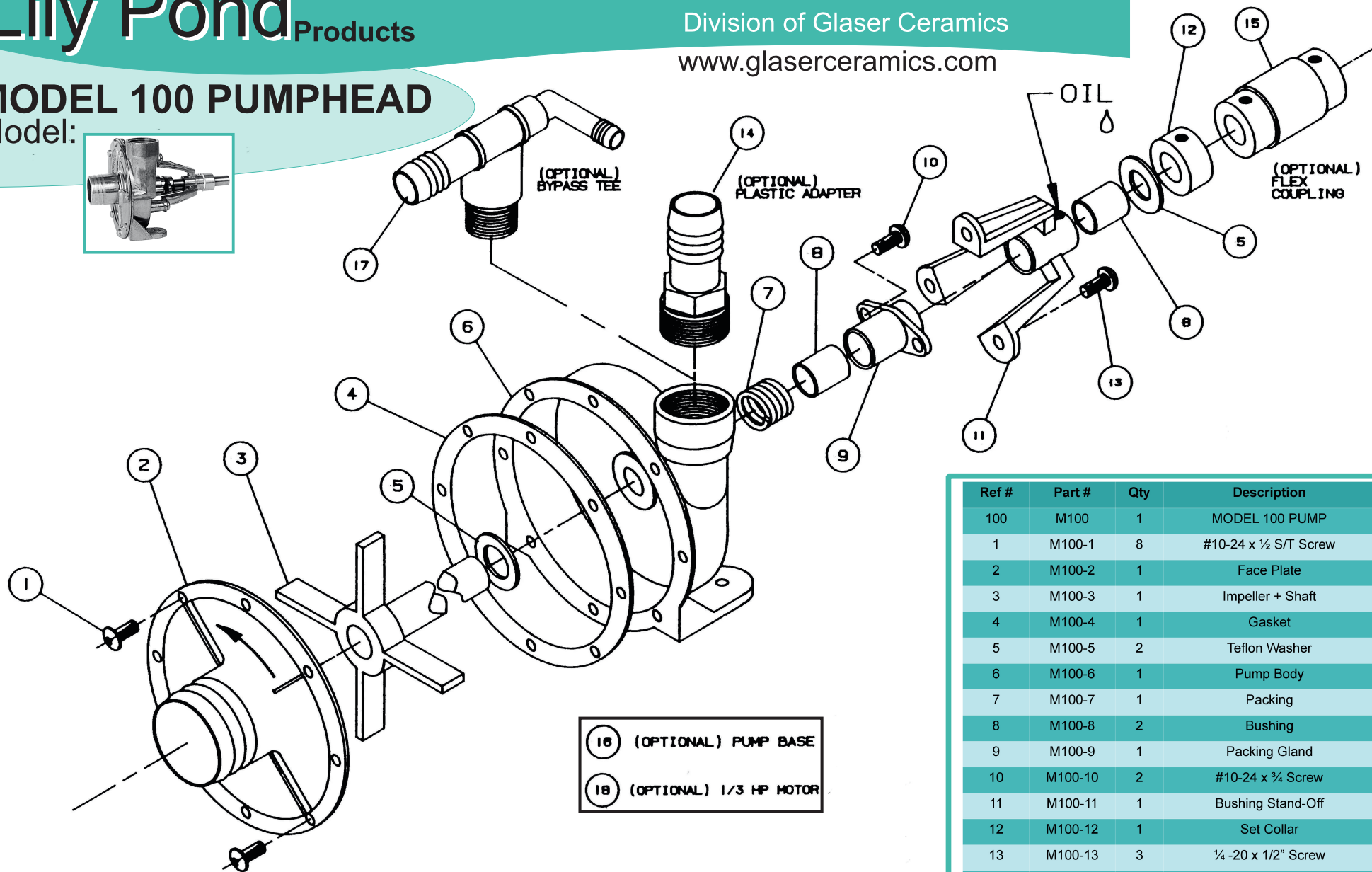
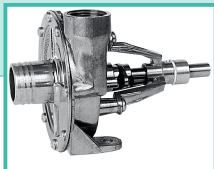
- New slip can be mixed on top of old Slip. Not need to empty your mixer to mix slip. Remember you can move the propellers up and down on the shaft by loosening the set screws. Be sure to re-tighten them.
- Slip can stored in your **Heavy Duty Mixer** indefinitely. To keep slip from drying out on top, 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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MODEL 100 PUMPHEAD

Model:



16 (OPTIONAL) PUMP BASE
18 (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	1	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

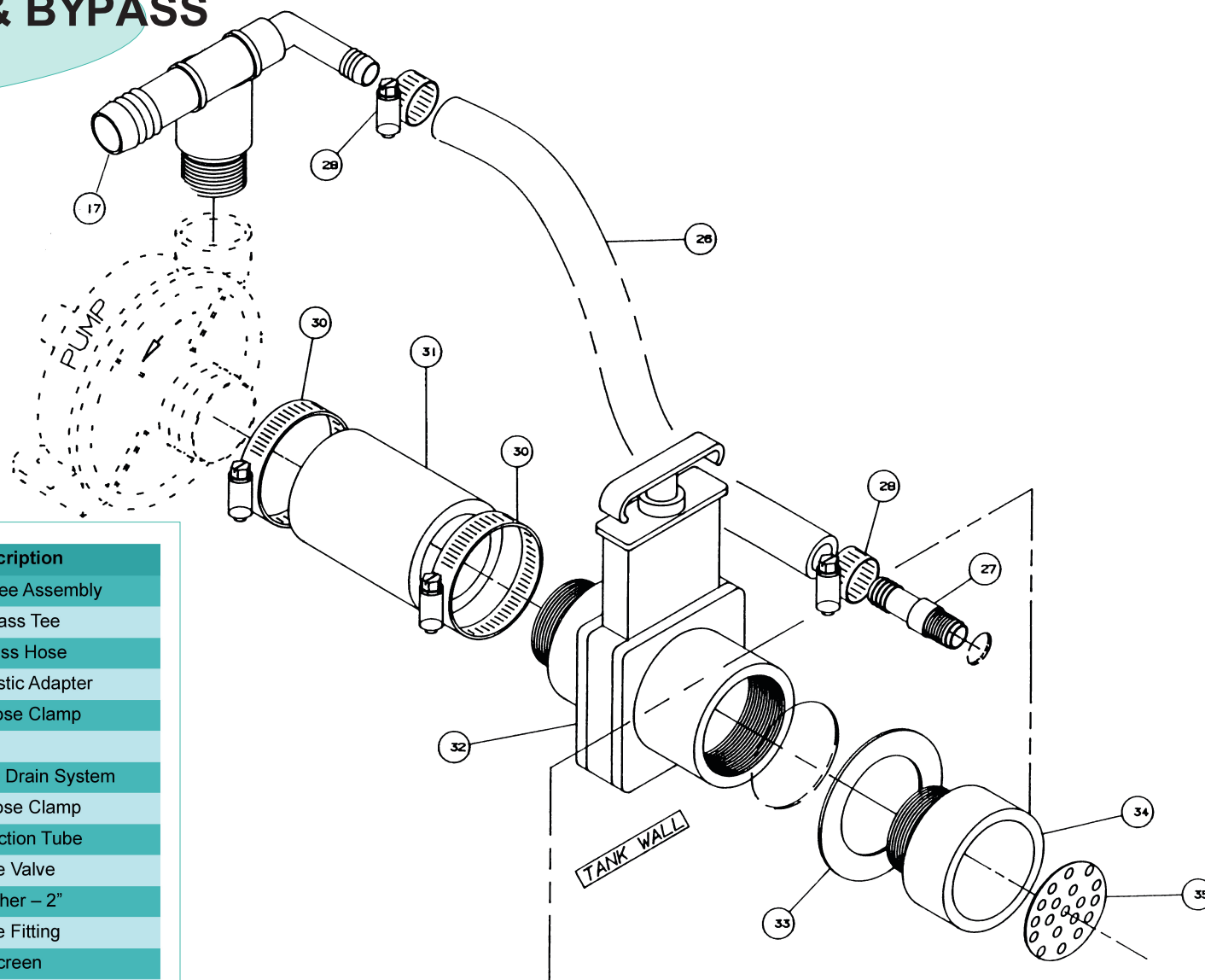
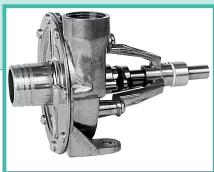
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GATE VALVE DRAIN & BYPASS

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

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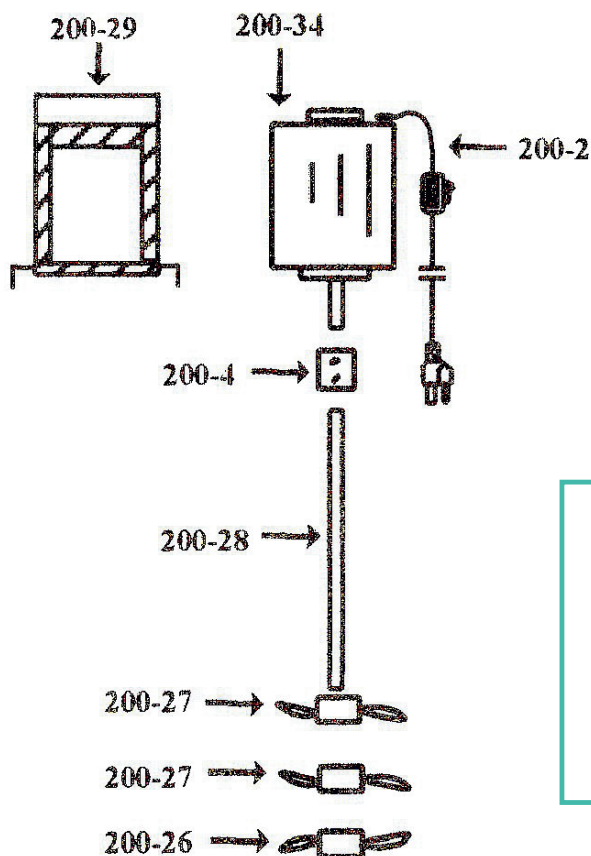
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MIXER ASSEMBLY

Model: 200-1



Part#	Qty	Description
200-1	1	1/3 HP DAYTON MOTOR PUMP
200-2	1	10 FT. CORD W/ SWITCH
200-4	1	COUPLER WITH SET SCREWS
200-28	1	1/2"-DIA STAINLESS STEEL SHAFT
200-27	2	TOP MIXER BLADES (AL) – 1/2"
200-26	1	BOTTOM MIXER BLADE (AL) – 1/2"