

# Lily Pond Products

Division of Glaser Ceramics

[www.glaserceramics.com](http://www.glaserceramics.com)

## 33 GALLON LOW-BOY

Model: 33MPL

***Fits under counter  
work spaces!***

***Low Profile  
Container!***



Submersible Pumping unit  
shown removed

### Submersible Pumping Machine

The Mid Pumper features a low profile tank which includes casters allowing you to freely maneuver around your casting area. Ceramic, Porcelain, or Stoneware Slip can be used with the submersible pump. The Mid Pumper is complete with a 1/3 HP Submersible pumping unit, hose and nozzle. Our new type of pump helps eliminate air bubbles and lumps with the pump strainer. The bypass system circulates slip in the tank while reducing pressure on the nozzle. The flow regulated nozzle pours a small stream or a larger stream for all types of mold openings. The tank has no seams and is one solid fiberglass mold body. Optional 1/3 HP portable mixer available.

Carton contains:

- Large Container: 24"x 28", 24" (low profile)
- Casters allow for easy maneuvering
- Hardwood Rack and Protective Lid
- 1/3 HP Submersible Pump Unit with Strainer
- Flow Regulated Nozzle
- 6' of 3/4" Clear Plastic Hose with Clamps
- Pump easily removed for storage
- Store slip in container
- Strainer helps eliminate lumps
- Optional: 1/3 HP Portable Mixer
- Five year limited warranty

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## 20 GALLON ASSEMBLY INSTRUCTIONS

Model: 20MP

**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



See *Submersible Pump Unit Assembly Drawing*.

1. **Attach Pump Adapter.** Screw Pump Adapter into outlet on Pump. Connect Nozzle to Nozzle Adapter. Connect Nozzle Adapter to one end of Clear Hose. Then, connect other end of Hose to Pump Outlet. Secure with Hose Clamps.
2. **Pumping Unit.** One dowel in the Wooden Rack is removable. Set the Wooden Rack on the Tank Container. Slide the dowel a few inches to one side. You can now place Pumping Unit inside down through the opening. Slide wood dowel back into place. Slip the Pumping Unit into the plastic hose elbow of the Drain Assembly and secure with a hose clamp.

## 20 GALLON OPERATING INSTRUCTIONS

Models: 20MP



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

- **MOTOR BEARINGS ARE PRE-OILED AND SEALED.**
- **MOTOR ONLY NEEDS TO BE OILED ONCE A YEAR.**
- **THERE ARE NO OTHER PARTS TO OIL.**

- *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. **Pump Unit.** Test your pumping unit with plain water first to insure proper operation.
2. **Slip.** All Slip must be mixed ready to pour prior to submerging the Pump into the Slip. For proper operation, Slip (Ceramic, Porcelain, or Stoneware) must weigh 56 oz. per Liquid Quart minus the container. Your Lil' Pumper is **designed to agitate and pump Slip**. It is not designed to mix dry clay or reclaim scraps.
4. **Storing Pump Unit.** If unused for more than **two days**, Pump Unit should be removed from slip and cleaned to insure no internal stoppage. Clean and allow Pump to dry thoroughly before storing. Set Pump in a bucket of clean water and pump water through unit until Nozzle pours clear water.
  - **Do not use detergents or soap to clean, this may contaminate your Slip.**
  - **Do not place Motor into the water.**

6. **Dried Out Slip.** *Do not start the Pump* if it has set for a long period of time in Slip that has dried out.

Remove the Pump Unit from the container of dried Slip. Remove Hose (200-16) from the 3/4" Elbow (200-15). Using a garden hose attach it to the 3/4" Elbow and back flush the Pump with warm water to free up the interior of the Pump. Flush the Hose (200-16) also.

7. **Storing Slip.** Remove the Pump from the 6-Gallon Container. Seal the slip by pouring about a 1/2 cup of water on top of the Slip. (This is a similar procedure used in preserving jelly by sealing it with wax.) Attach the other Half-Lid to the 6-Gallon Container. When you are ready to pour again, mix the water into the slip. Make sure that you weigh your slip to insure proper consistency.

**YOU ARE NOW READY TO GO! GOOD LUCK AND GOOD POURING!**

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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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## SUBMERSIBLE PUMP UNIT For Mid-Pumper Series

Models: 200-SP

Qty.	Description	Price Ea.
200-1	Motor 1/3 Hp.	
200-2	Cord W/ Switch	
200-3	3 1/4 n.c. x 1/2 Hex Bolts	
200-4	1 S S Coupler W/ Set Screws	
200-5	1 Connector Tube	
200-6	1 Aluminum Bushing	
100-7	1 Packing	
200-7	1 Pump Case	
200-8	1 Bushing 1" x 3/4"	
100-5	1 Teflon Washer	
200-9	1 Pump Shaft	
200-10	1 Impeller	
200-11	1 Face Plate (Cut)	
200-12	1 Filter Plate	
200-13	3 Screws 1/4 Self Tapping	
100-28	2 #10 Hose Clamp	
200-15	1 3/4 Elbow	
200-16	1 3/4 Clear Hose	
200-17	1 Nozzle	
200-18	1 3/4 Plastic Adaptor	
200-19	1 6 Gal Container	
200-20	1 Lid Half / No Hole	
200-21	1 Lid Half / With Hole	

Submersible  
Pumping Unit

