

# CIMCOOL® CIMFLO® MIX REGULATOR

Drum mountable proportioning unit to accurately maintain concentration of water soluble metalworking fluid mixes



*To safely operate and maintain the CIMFLO® Mix Regulator please follow the instructions contained within this document and retain for future reference.*

## INSTRUCTIONS FOR USE:

Thank you for purchasing the CIMFLO® Mix Regulator. When used as instructed, the CIMFLO® Mix Regulator will provide many years of accurate fluid dispensing. Maintaining the optimum concentration is the most important factor in maximizing sump life, reducing MWF related problems and controlling cost.

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## BASIC OPERATING PARAMETERS:

- Mix proportion: 0 - 25% (by refractometer reading)
- Drum Flange: ¾"
- Operating water pressure: > 2Bar
- Mix efficiency: >2,000L/hr under 6Bar operating water pressure
- Pipe material: aluminium alloy and GF-PVC
- Packaging weight: 6.0 kg

## INSTRUCTION FOR USE:



1. Check the received parts against list



2. Insert Adjustable suction pipe (5) into the drum flange (4).



3. Fully extend the adjustable suction pipe (5) by pulling as shown.



7. Insert the CIMFLO® Regulator into the drum and screw the flange into the bung (Do not over tighten).



8. Attach and tighten hoses and clamps. Other hoses of comparable size can be used. (Not supplied).



9. Slowly turn the water control valve to commence mix supply.

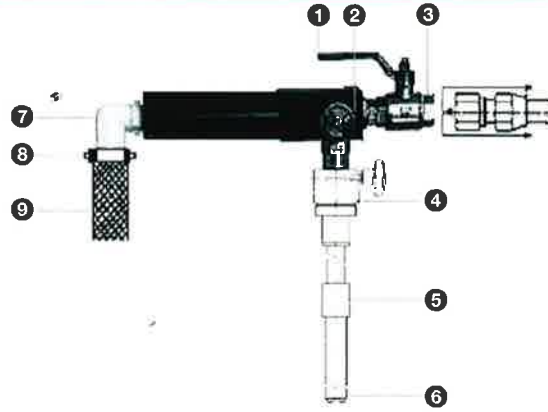
## CONCENTRATE ADJUSTMENT METHOD:

1. Connect water supply
2. Turn on water control valve (1)
3. MWF mix will flow in approximately 3 seconds.
4. Check mix concentration via the refractometer
5. The proportion of water to concentrate can be adjusted using the mix regulator knob (+) to increase and (-) to reduce the concentration
6. Once the desired mix has been achieved, tighten the grub screw located in the mix regulator knob to prevent inadvertent adjustment.

**Note:** Fresh mix and top up rates are different. Other factors effecting the optimum setting include fluid type (soluble, semi synthetic or full synthetic), seasonal temperature changes, operating conditions, carry off and selective depletion. Please speak with your CIMCOOL® Fluid Technology Representative who can guide you in determining the correct setting.

## CIMFLO® MIX REGULATOR COMPONENTS:

1. Water control valve
2. Concentration regulator
3. Water pipe inlet 12.5mm (0.5")
4. Drum flange ¾" Diameter
5. Adjustable concentrate suction pipe
6. Spill prevention valve
7. Elbow Bend 25mm (1")
8. Hose Clamp x 2
9. Mix discharge hose



4. Ensure the O ring is correctly positioned as shown.



5. Screw the CIMFLO® Regulator body to the adjustable suction pipe (5).



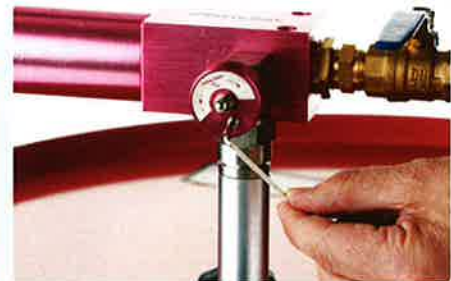
6. Remove the drum bung.



10. Check the concentration, use a refractometer or alternative method of determination.



11. Using the concentration regulator (2). Adjust + or - to achieve the recommended concentration.



12. Using a hex or Allan Key (not supplied) tighten the grub screw to lock in the set mix.

## PRECAUTIONS AND WARNINGS:

The CIMFLO® Mix Regulator is designed for water soluble metalworking fluid concentrates. The parts and materials used in the Mix Regulator are designed for minimal maintenance over long periods. Never use any fluid mixture except for metalworking concentrated fluids.

Do not use high-pressure water supplies in excess of those stated in the operating parameters. Excessive water pressure into the inlet hose can cause the hose to burst and cause injury. Water pressure should not exceed the maximum rating for any hose connected to the mix regulator.

Limit the length of the mix discharge hose (9) to 1.5 metres. The Mix Regulators inlet and outlet hoses should not be bent or extended. Excessive force may slow the flow velocity of liquid mixture and cause the internal jet to be blocked. This may affect the consistency of mixture.

The CIMFLO® Mix Regulator is a factory-sealed unit. Do not disassemble. Disassembly of the main unit will void warranty and risk damage to the internal seals and parts.

## TROUBLESHOOTING AND MAINTENANCE GUIDE:

### FAILURE: FAIL IN THE REGULATION OF FLUID MIXTURE CONSISTENCY

| Failure                                                                                                         | Solution                                                                 |
|-----------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------|
| 1. Ensure if the water pressure is above 0.2 Mpa                                                                | 1. Increase water pressure to 0.2Mpa, add a booster pump if necessary    |
| 2. Ensure the mix regulator is not completely turned to the (-)                                                 | 2. Turn mix regulator in a counter clockwise rotation                    |
| 3. Check to see if the drum is empty or the concentrate is sufficient to reach the foot of the suction pipe (5) | 3. Top up the fluid or replace the drum                                  |
| 4. The regulating dial cannot deliver the required concentration (low or high)                                  | 4. Ensure the grub screw is not restricting the motion range of the dial |

### FAILURE: FAIL IN MIX PROPORTION

| Failure                                                                                   | Solution                                                              |
|-------------------------------------------------------------------------------------------|-----------------------------------------------------------------------|
| 1. Ensure if the water pressure is above 0.2 Mpa                                          | 1. Increase water pressure to 0.2Mpa, add a booster pump if necessary |
| 2. Ensure the mix regulator is not completely turned to the (-)                           | 2. Turn mix regulator in a counter clockwise rotation                 |
| 3. Check for hose blockages                                                               | 3. Clean the hoses                                                    |
| 4. Ensure concentrate transfer pipe has not been bent or constricted or has become loose. | 4. Tighten all components,.                                           |



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The CIMCOOL® CIMFLO® Mix Regulator is covered by a 3 month replacement warranty covering defective materials and workmanship. The warranty does not cover hoses, hose clamps, damage to drums or external equipment.

CIMCOOL® Fluid Technology will not be held responsible for the misuse of this equipment and subsequent damage caused. Any updates on product design or functions or the information contained in this instruction are subject to change without notice. The data and experience enclosed within is based on long-term tests under proper use and handling. For any questions please contact your nearest CIMCOOL® Fluid Technology Representative.