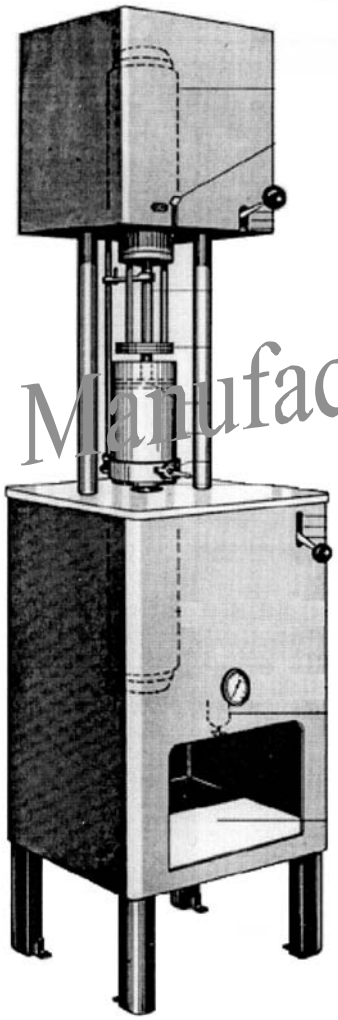
Model #1378
Pressure Mixer



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Semco® Pressure Mixer
Model 1378

The SEMCO® Pressure Mixer is designed for blending two or more liquid or viscous materials into one homogeneous mixture, without the possibility of air being admitted. Any quantity from a full quart (Model 1350), to 5 quarts (Model 1378) of materials may be mixed in a few minutes and the mix delivered, while still under pressure, into a polyethylene cartridge for use with the SEMCO® Sealant Gun. The action of the mixer is provided by two double acting air cylinders. The lower cylinder first forces entrapped air through an air bleeder and seal at the top of the container and then holds the container under pressure while the upper cylinder forces a dasher through the material with an involved motion that gives you a thorough mix and blend.

An automatic reversing mechanism has been provided for the dasher. This feature guarantees full stroke, making positive contact between dasher and container, top and bottom, regardless of the amount of material in the container; otherwise space left either top or bottom would leave some material unmixed.

A counter registers the dasher cycles assuring positive uniformity of batches. The number of cycles necessary to give a thorough mix is determined by experiment, or by material manufacturer's recommendation. The cabinet is stainless steel. The pot and dasher readily disassemble for easy cleaning. Unit Model 1350 measures 18" x 16" at the base and is 66" high. Shipping weight is approximately 325 lbs. The air consumption for the Model 1350 is 5.92 cfm (20 strokes). Model 1378 measures 24" x 18" at the base and is 80" high, shipping weight is approximately 685 lbs., and the air consumption for the Model 1378 is 19.3 cfm (20 strokes).

CAUTION: Always wear safety glasses when operating or cleaning equipment.

SET UP:

(A) Connect a ½" ID air line, using a fitting that will not restrict air flow.

(B) Assemble the seal unit and dasher unit on the machine. See 228075 items 16, 17, 18, 19, 20, and 21 for Model 1378. See 228024 items 25, 26, 27, 28, 29, 30 and 31 for Model 1350.

(C) With the dasher control lever in the up position and the pressure control lever in the down position, adjust the air pressure regulator to 25 psi.

(D) Bring the dasher control lever down until the dasher reaches full stroke and stops. Raise the pressure control lever up. As the ram raises, check to see if the dasher rod is aligned with the ram.

LUBRICATION:

Lubricator must be filled with oil up to level indicated on lubricator. Then, adjust the adjusting cap to allow approximately one drop of oil per every 60-90 seconds, while mixer is in operation. Use No. 10 weight non-detergent oil or equivalent.

USE CAUTION – KEEP FINGERS CLEAR – MACHINE WILL CYCLE IN THIS POSITION.

LOADING:

(A) Open the filler valve so no air will be trapped in the bottom of the container.

(B) Butter, (meaning to coat evenly) the outer seal ring and filler valve opening inside the bottom of the container with premixed material of the type to be mixed. This will alleviate unmixed material, causing streaks.

(C) Place all base material in the container, be careful not to fold in any air. Close filler valve and shake the material down to pull vacuum on container.

(D) Place the catalyst into a cartridge utilizing a 4" or 6" nozzle, and inject the catalyst into the center of the base material.

(E) Place the container on the ram and rotate about 45 degrees. The container will drop over the bayonet lug of the ram. Reverse the container until the filler valve is in a forward position.

(F) Raise container slowly by raising pressure control lever. When container comes to a stop, raise pressure lever all the way.

(G) Preset the counter by opening protective cover and hold reset button in, while selecting the number of strokes required. Note: Once this is accomplished, you need only to push the reset button in and release for the next batch.

(H) Pull dasher control lever down, this starts the mixing cycle.

(I) Adjust the air regulator to approximately 20 strokes per minute. This will vary depending upon the viscosity of the material. The best pressure setting will be determined by tests, or may be obtained from the material manufacturer.

UNLOADING:

(A) The dasher will stop when the counter registers the pre-determined number of strokes
Terminating the mixing cycle.
(B) Raise the dasher to the top of its stroke by holding dasher control lever down and
release when dasher reaches the top of its stroke.
(C) Place Sealant Gun cartridge with plunger inserted over the filler valve and open filler valve.
(D) While filling, squeeze the cartridge slightly to allow any air to be forced out past the
plunger.
(E) When the container will no longer move upward, it is empty.
(F) To remove the container, move the pressure control lever all the way down.

KEEP FINGERS CLEAR!!!

CLEAN UP:

(A) Remove container by turning counter-clockwise approximately 45 degrees, lift to separate from ram. Fill container ½ full of solvent. Be sure filler valve is in the closed position.
(B) Place container back on ram.
(C) Raise the container slowly so as not to create pressure inside the container, causing solvent to squirt out the seal plate area. Continue raising until dasher is about level with the solvent.
(D) Place pressure control lever in a neutral position holding container in a fixed position.
(E) Reset counter by pressing bottom in, then release.
(F) Pull dasher control lever down starting mixing cycle.
(G) When the counter registers the pre-determined number of strokes, the mixing cycle will terminate.
(H) Raise the dasher by holding dasher control lever down and release when dasher reaches the top of its stroke.
(I) Holding a waste rag, open the filler valve, raise the container until solvent forces the material in the filler valve out. Close the filler valve and lower the container.
(J) Remove the container and pour the solvent out.
(K) Remove filler valve from the container and clean thoroughly.
(L) Reset counter and hold the dasher control lever down until dasher stops.
(M) Unscrew dasher, remove seal plate assembly. A slight twist allows buttons to go through slots.
(N) Remove seals and wipe them clean with a rag soaked in solvent. Never soak seal in solvent. All parts should be cleaned in solvent as soon as possible to prevent material from curing on them.
(O) Inspect parts to be sure all material has been removed. Any material or solvent spilled on the machine should be cleaned as soon as possible.

NEXT RUN:

(A) Assemble the seal unit and dasher unit on the machine. See SET UP (B).
(B) Raise pressure control lever until mixer cycles.
(C) Raise dasher control lever up terminating cycle at top of stroke.
(D) Lower pressure control lever all the way down.
(E) Repeat instructions, begins at LOADING.

NOTE: When counter registers any number but zero, dasher rod may drift down. Either reset to zero or cycle machine to hold dasher at top of stroke.

CAUTION: Disconnect air supply when equipment is not in use, and before servicing.

MODEL 1378 PRESSURE MIXER

Dasher and Seal Cover Assembly

ITEM	*PART NO.*	*DESCRIPTION*
24	*228084*	*Dasher Rod*
	*228032**	*Seal Cover Assembly*
	228691	*Dasher Assembly*

Components for the Seal Cover Assembly, which are listed below, may be purchased separately:

	228087	*Inner Seal Ring*
	228088	*Outer Seal Ring*
	228086	*Seal Plate*
	228089	*Seal Disc*
	228090	*Leveling Screen*

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RECOMMENDED SPARE PARTS

QUANTITY	*PART NUMBER*	*DESCRIPTION*
1	*228079*	*POPPET CONTROL ROD*
1	*228061*	*FILLER VALVE ASSEMBLY*
1	*228083*	*POT ASSEMBLY*
1	*228691*	*DASHER ASSEMBLY – S.S.*
1	*228086*	*SEAL PLATE ASSEMBLY*
2	*228090*	*LEVELING SCREEN*
2	*228087*	*INNER SEAL*
2	*228088*	*OUTER SEAL*
4	*221342*	*POPPET VALVE*
2	*228089*	*SEAL DISC*
2	*286285*	*O-RING (FILLER VALVE)*
1	*228084*	*DASHER ROD*

REPAIR PARTS 1378 MIXER

232537	*COUNTER*
228134	*DASHER ROD ARM*
APN071	*PILOT VALVE REPAIR KIT*

UPPER AIR CYLINDER

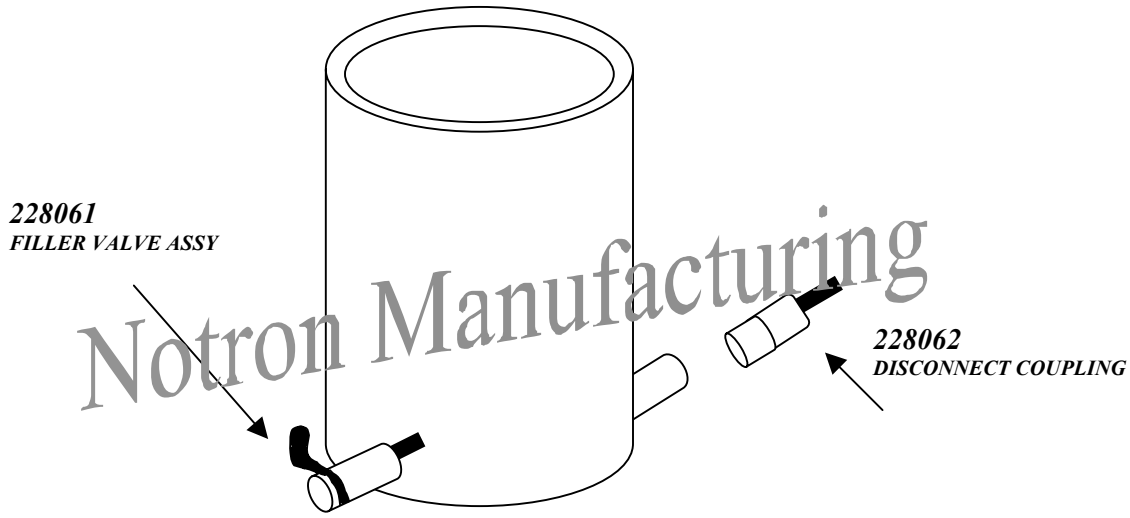
233042	*PISTON SEAL KIT*
233044	*ROD BUSHING SEAL KIT*
233006	*CUSHION SEAL KIT*

LOWER AIR CYLINDER

233005	*PISTON SEAL KIT*
233004	*ROD BUSHING SEAL KIT*

CONTAINER ASSEMBLY

1350 AND 1378 CONTAINERS ARE JACKETED FOR WATER COOLING



227966 ONE QUART WATER COOLED POT
228083 FIVE QUART WATER COOLED POT

SEAL & DASHER ASSEMBLY
MODEL 1378