



master CHEMICAL CORPORATION

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SUMP SIDE COALESCER INSTALLATION AND ASSEMBLY INSTRUCTIONS

Manufactured for Master Chemical Corporation by:

The Andersons logo features the company name in a serif font, with a stylized leaf or branch graphic to the right.	The SED fluid recycling logo is a circular icon with a stylized 'S' and 'R' inside, representing a recycling process.
415 ILLINOIS AVE • PO BOX 119 • MAUMEE, OH 43537	
Phone: 419.891.2724 • Fax: 419.897.6785	



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SUMP SIDE COALESCER

A. INSTALLATION/ASSEMBLY INSTRUCTIONS (REFER TO FIGURE 1. FOR FURTHER DETAIL)

1. Connect one end of the 1/2" hose to the hose barb on top of the coalescer drum and attach the other end to the hose barb on the pump/skimmer assembly. Use the snap grip hose clamp (supplied) to make positive seal connections on both ends. **DO NOT CUT THE HOSE SHORTER. IF THE HOSE IS CUT SHORTER IT WILL INCREASE THE COOLANT FLOW THROUGH THE SKIMMER AND PUMP WHICH WILL IN TURN NOT ALLOW THE SKIMMER TOP TO FLOAT PROPERLY.**
2. Connect the 1" clear hose to the 90° hose barb on the side of the coalescer drum. Use the snap grip hose clamps (supplied) to make a positive seal connection.
3. Make sure the drum inner baffle is adjusted to the same height as the drum. Center the baffle in the drum and place lid on drum so that the 1/2" bulkhead in the lid fits inside the baffle. Tighten lid.
4. Elevate the coalescer drum to a point above the machine tool sump so that clean coolant can gravity flow out of the drum through the 1" clear hose and back into the sump. (See Figure 2. For further clarification).
5. Measure depth of sump.

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Before placing pump/skimmer assembly into the sump, adjust the skimmer height so that the skimmer cup is approximately 1 1/4" below the coolant level in the sump. (See Figure 3. for clarification).

NOTE # 1: If the sump depth is less than 5", modifications will need to be made to the skimmer. The skimmer must be trimmed so that the base and the cup are short enough to fit the sump. A band saw, cut off saw or hack saw can be used for this purpose. The length to trim the parts are explained in Figure 3.

NOTE # 2: Once the skimmer height is set as described, the skimmer will Maintain operation even with a sump level fluctuation of plus or minus 1 1/4".

NOTE # 3: For sump levels less than 3 1/2", the pump cannot be direct coupled to the skimmer. In these cases an optional hose kit is needed consisting of (2) hose barbs - one for the pump and one for the skimmer. A short piece suction hose is also included to connect the skimmer to the pump.

Sump Level	Trim Amount	Skimmer height after trim	Sump level range of trimmed skimmer
5-1/4" or greater	none	4-5/8"	+ 2-1/4" from initial level
4"	1-1/4"	3-3/8"	+1" from initial level
3"	2-1/4"	2-3/8"	0" from initial level
2-3/4"	2-1/2"	1-7/8"	0" from initial level
Less than 2-3/4"	Cannot do	N/A	N/A

- 6. Make sure filter screen is in skimmer base.

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7. Set pump/skimmer assembly into sump in an area where tramp oil tends to accumulate, or at an area of convenience. The base will sit on the sump bottom, keeping the pump/skimmer assembly upright. It is best to sit the skimmer as low as possible in the sump with the upper sets crew installed so the upper portion of the float will still stay within the lower portion of the skimmer base. This allows the upper portion to “bob” up and down a small amount, which helps keep the skimmer clean of solids.
8. Plug pump power cord into a GFCI plug adapter, and then into a 110 volt electrical outlet.

B. OPERATION

1. Once pump is operational, fluid will flow through the 1/2” hose and into the coalescer drum.
2. Initially, the time to fill the drum will be 6-8 minutes.
3. Once the drum is full, clean coolant will gravity flow through the underflow pipe, out the drum, and back into the machine sump. Tramp oil will float to the surface in the drum and will be contained in the drum until the drain spigot on the side of the drum is opened allowing oil to be drained from the drum. (**Note:** oil draining must be done when pump is de-energized).

C. MAINTENANCE

1. Drain oil from the drum as required. Time intervals between drainings will depend upon tramp oil levels in the machine sump.
2. Remove drum lid once a month to check for sludge buildup in the drum. It is important to remove sludge often as bacteria will breed in the sludge.
3. Check operation of skimmer daily. Make sure the skimmer float is skimming the surface of the machine sump.
4. Check skimmer screen for plugging once a week. If it is plugged, remove screen and clean.

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TROUBLESHOOTING		
PROBLEM	PROBABLE CAUSE	REMEDY
Pump not pumping	Electrical power disconnected	Reconnect power
	Skimmer obstructed or plugged	Remove obstruction
Not removing oil	Pump not pumping	See #1
	Skimmer float stuck below surface	Clean skimmer
	Skimmer screen plugged	Clean screen
Coolant discharges from drum before drum is completely full	1" clear return hose is submerged upon start up	Pull hose to an area above the surface. Crack drum spigot until drum is full

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