IOM manual

tapflo®

IBC Mixers

LBC, HBC series

2025 | 1

STOP

Read this instruction manual carefully,
before you install and operate the mixer.

CE

All about your flow®

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CONTENTS

EU DECLARATION OF CONFORMITY

Series: **IBC Mixers - LBC/HBC**

Model:

LBC037, LBC075, LBC150, LBC220

HBC037, HBC075

Serial number: **25. (from 001-...)**

Manufactured by Tapflo Sp. z o.o. Poland for.:

Tapflo AB
Filaregatan 4
S-442 34 Kungälv, Sweden

This declaration of conformity is issued under the sole responsibility of the manufacturer.

Object of declaration: **IBC mixers - High and Low Speed With Electric and Pneumatic Drives.**

The object of the declaration described above is in conformity with the relevant Union harmonisation legislation:

- Directive 2006/42/EC of European Parliament and of the Council of 17 May 2006 on machinery.

Signed for and on behalf of
Tapflo Group AB, 21.11.2022

Per Antonsson
Chief Executive Officer

1. GENERAL

1.1. Inspection

On receiving delivery of your IBC Mixer please inspect carefully to confirm that your mixer has been received un-damaged and to the correct specification. Report any shortages or damage immediately in writing to the carrier or supplier. Contact details can be found at the back of this manual.

1.2. Transportation

Mixers should be transported in full. Lifting arrangement via a hoise or a forklift truck is shown in fig.1. Before transport make sure that the lifting components are securely attached to the frame. Tighten any loose screws before lifting. Make sure the hook clamps are detached from the IBC frame.

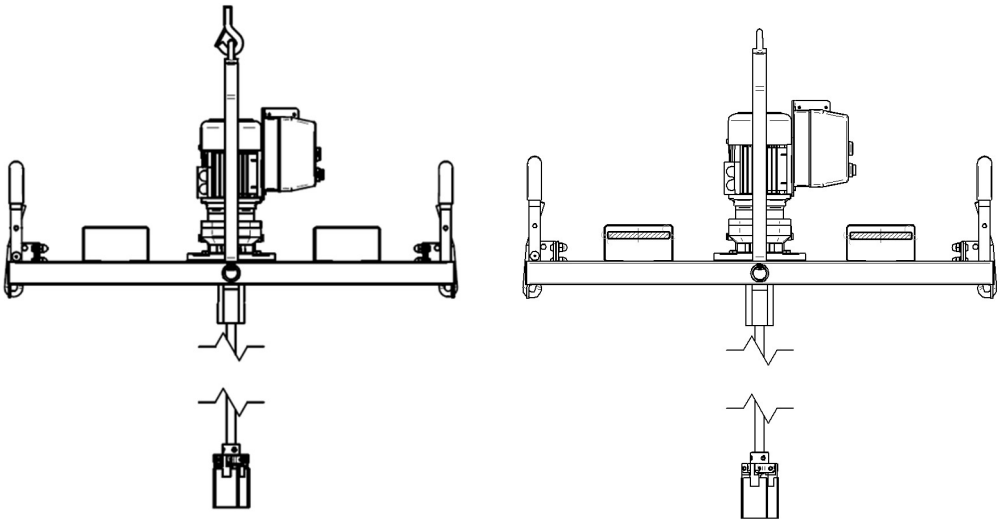


Fig.1: Correct ways to transport IBC mixers

1.3. Storage

IBC Mixers series LBC, HBC should be stored in an indoor, clean, dry location with a controlled temperature of 15°C to 40°C until the mixer is ready to be used.

1.4. Description

Tapflo IBC Mixers series LBC, HBC are designed for use on Industry standard Intermediate Bulk Containers (IBC) with a 150mm screw cap and are suitable for most container types.
The IBC mixers are designed for indoor use in a safe zone only and are equipped with a DOL starter, overload protection, a safety switch that prevents the mixer from operating if it is not securely mounted on the IBC, and 16A power outlets with IP44 (splash-proof) protection.
The mixer drive is supported on a lightweight stainless steel bridge which mounts directly onto the IBC and is held in place with quick action toggle clamps, standard lifting is an eye bolt for lifting with a hoist or optional fork lift module.

1. GENERAL

1.5. Safety

The following instructions are important.

- Observe all site safety procedures installing and operating your IBC mixer
- Familiarize yourself with the material being mixed in the IBC and obtain product safety data sheets, protective clothing and appropriate eye protection before proceeding.
- Use lifting equipment i.e. fork lift or hoist to install the mixer onto an IBC mixer. Mass in Kg is indicated on the mixer nameplate.
- Mount the mixer securely onto the IBC complete with shaft and impeller before connecting to the power supply.
- Disconnect from the power supply before moving the mixer or carrying out maintenance.
- Do not touch any moving / rotating parts.
- Do not touch the motor after use - Hot Surface

***WARNING!* Failure to observe safety instructions could cause severe personal injury.**

1.6. Hazard identification and risk analysis

Based on EN ISO 12100:2010, the following hazards have been identified:

- Mechanical hazards
  - Contact with rotating agitator parts is possible.
  - Risk of clothing, hair or limbs getting caught in the drive mechanism.
  - The agitator may tip over during assembly or operation.
- Electrical hazards
  - Risk of electric shock due to damaged cable insulation.
  - Risk of electrical short-circuit or overheating of the motor.
- Thermal hazards
  - Overheating of the electric motor, which can lead to burns.
- Chemical hazards
  - Contact with mixed chemicals (e.g. solvents, acids, alkalis).
  - Risk of chemical splashes.
- Hazards due to noise and vibrations
  - Noise emission exceeding the permissible standards.
  - Vibrations that can lead to user fatigue.
- Ergonomic hazards
  - Forced body position during assembly and operation.
  - High device weight making it difficult to operate.

1. GENERAL

A risk analysis was carried out for each identified hazard and appropriate countermeasures were proposed:

Possible hazard	Probability	Consequences	Risk reduction measures
Contact with the rotor	Medium	Serious injury	Protective covers, start-up lock (limit switch),
Electric shock	Low	Fatal injury	grounding, insulated cables
Contact with chemicals	Medium	Chemical burns	Personal protective equipment (gloves, goggles)
Equipment tipping over	Low	Physical injury	Stable construction, non-slip bases, installation on IBC container frame
Noise	Medium	Hearing damage	Hearing protection
Vibrations	Medium	Fatigue	Vibration dampers

2. INSTALLATION AND OPERATION

2.1. Installation

The mixers with electric drive are supplied pre-wired and fitted with a DOL starter, overload protection, safety interlock and appliance Inlet Plug.
The plug color indicates the power supply required.

- Red - indicates a 400v 3ph 50 Hz supply
- Blue - indicates a 220-240v 1ph 50 Hz supply
- Yellow - indicates a 110v 1ph 50 Hz supply

The mixers with pneumatic drives are supplied with a flow control valve to regulate the motor speed and an exhaust muffler.

1. Check that the motor / starter voltage requirements correspond with the supply or verify if compressed air supply system is suitable in case of mixer with air motor.
2. Check that the mixer shaft direction of rotation is clockwise when viewed from above.
3. Changes to reverse the direction of rotation must be done by qualified personnel only.
4. Fix the impeller on the mixer shaft and firmly tighten the set screws. Impeller placement is described in chapter 4.4.

5. Fit the mixer shaft into the drive head coupling and tighten the 2 set screws (Item 5) through the slot provided in the coupling guard.
6. Lower the mixer on to the IBC frame with a forklift truck or hoist using the eye bolt provided on the mixer.
7. Securely fasten the mixer onto the IBC frame with the 2 quick action clamps provided - adjust the clamps if necessary.

2. INSTALLATION AND OPERATION

8. When the mixer is securely mounted on the IBC frame the power supply or compressed air supply can be connected if safe to do so.

9. After use before moving the mixer - disconnect it from the power supply and remove the cable from the power plug of the device.
   In case of an air motor, it should be disconnected from the compressed air supply.

10. Check that the securing clamps have been released before lifting / removing the mixer from the IBC. The clamps are fitted with a locking plunger - pull the button to release as illustrated.

2.2. Operation

Tapflo Mixers series LBC, HBC can be driven by an electric motor with a DOL starter or gearmotor with a frequency inverter. Mixer shaft speed can be change by turning the potentiometer on the inverter - for more detailed instruction please refer to the instruction manual supplied with this mixer. Mixers can be also driven by an air motor equipped with exhaust muffler and a flow control valve to regulate the motor speed.
Always ensure access to the power supply or compressed air supply is kept clear.

2. INSTALLATION AND OPERATION

Before operation visually check that all components are in a serviceable condition and not damaged.

Before starting the mixer, it must be properly positioned on the IBC tank. The yellow limit switch is responsible for safety. Starting the mixer without securely mounting it on the pallet container is not possible. If the mixer is lifted during operation, it will automatically stop.

The mixer can be operated at any liquid level.

2.3. Safety interlocking switch

Electrically controlled mixer cannot be started if it is not correctly mounted on the pallet container. This is ensured by the safety limit switch with a dedicated mechanism with a spring. If the mixer does not start despite proper mounting, the safety switch may be mounted incorrectly.

When toggling the switch, a clicking sound should be audible. Mounting the switch too close to the edge will prevent the mixer from starting.

Check whether the system activates when the block mechanism with the spring is removed. After performing the check, the mechanism must be reassembled, and the switch and block alignment should be adjusted. Next, verify that the electrical connections have been made according to the electrical schematic. These tasks should be performed with the power off and only by qualified personnel.

2. INSTALLATION AND OPERATION

2.4. Operation

Run the mixer by pressing the START button located on the control box, provided it is correctly mounted on the pallet container.

The mixer will stop when the STOP button is pressed, in the event of motor overload, or if it is removed from the pallet container.

In the 400 VAC version, the direction of the motor rotation can be changed by swapping two power phases, without the need to disassemble the device.

For the version controlled by a frequency inverter, a detailed description of the control is provided in a separate document.

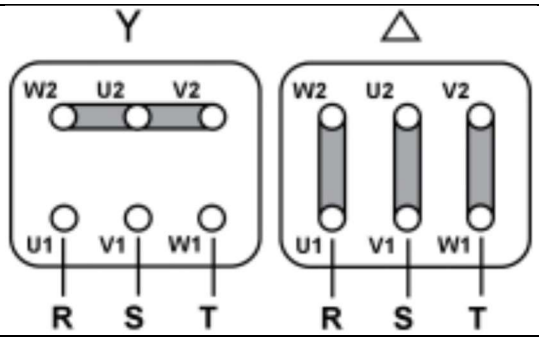
The electrical circuit diagrams are available as attachments to the documentation.

2. INSTALLATION AND OPERATION

2.5. Fault diagnosis

Fault	Possible cause	Action	Drive
Mixer motor runs but not mixing the IBC contents very well	Impeller rotating in the wrong direction	Check that the direction of rotation corresponds with the arrow on the mixer nameplate. Rotation is clockwise when viewed from above.	All drives
	Impeller rotating in the wrong direction	Check that the direction of rotation corresponds with the arrow on the mixer nameplate & that the flow control and muffler are on the correct ports. Rotation is clockwise when viewed from above.	Air drives
	Shaft loose in the drive coupling	Check shaft retaining grub screw are tight.	All drives
	Loose impeller on the shaft	Fix impellers according to chapter 4.4 and secure the set screws	All drives
	Folding impeller not opening	Check that the impeller is installed so the blades hang downwards when not operating. Check collision with other components.	All drives
	Product different - higher SG or viscous product being mixed.	Contact Tapflo or your local distributor for advice.	All drives
	Speed set is too low	Increase speed at VFD panel.	VFD drive
Motor does not run	Fault with mains supply	Check voltage at contactor input terminals	Electric and VFD drive
	Motor locked rotor	Check motor is free to turn	Electric and VFD drive
	Faulty contactor coil	Check if the contactor operates	Electric drive
	Loose connections	Check the wiring and connections	Electric and VFD drive
	Safety switch not releasing	Press the operating block and check whether the safety switch releases. Re-position the safety switch to release when the block is pressed. If the problem persists remove the block and check again.	Electric and VFD drive
	Air motor seized	Flush the air motor. Check that the air motor has a clean lubricated air supply. Check and top up the air line lubricator & adjust if required.	Air drive
Overload relay trips at start	Wrong overload relay fitted	Check overload relay rating	Electric drive
	Wrong wiring connections	Check wiring against the diagram	Electric and VFD drive
Overload relay trips after several minutes	Wrong overload relay fitted	Check overload relay rating	Electric drive
	Overload relay set to the wrong value	Check setting on overload relay	Electric drive
	Product different - higher SG or viscosity product being mixed	Contact Tapflo or your local distributor for advice	Electric drive
Motor starts but has low torque or does not reach full speed	3-phase motor is single phasing	Check that motor connections are correct. Check for loose connections in wiring and at motor terminals. Check that the voltage on each motor winding the correct value.	Electric and VFD drive
	Motor intended for Delta is connected in Star	Check motor connections.	Electric and VFD drive

2. INSTALLATION AND OPERATION

			
Air motor runs slowly	Poor air line lubrication	Check the air line lubricator top up and adjust if required.	Air drive
	Excessive dirt / wear particles inside the air motor	Flush the air motor. Check the air motor has a clean lubricated air supply. Check and top up the air line lubricator & adjust if required.	Air drive
	Flow control valve or fittings damaged	Check and replace	Air drive
	Exhaust muffler blocked	Clean muffler and replace the felt element	Air drive

3. MAINTENANCE

3.1. Routine maintenance

Every 6 months

Check the security of all nuts and screws, and ensure all components are in a serviceable condition and not damaged. Check that the mixer gearbox, electric motor or air motor muffler are kept clean.

Visually inspect electrical components, cables, air lines for damage and rectify before use. Electric motors do not require any internal maintenance and should be replaced if a fault occurs.

Every 12 months

In-service inspection and testing of electrical equipment - Formally inspect and test electrical components and cables in accordance with local regulations.

3.2. Lubrication

Electric motor bearings are sealed for life, and do not require any maintenance or re-lubrication.

The gearboxes are factory filled with ISO VG 220 food grade lubricant and sealed for life.

Air line lubrication - use SAE #10 motor oil or equivalent for the air line lubrication.

3.3. Tightening Torques

Tighten all fasteners to values shown unless specifically instructed to do otherwise. Lubricate all fasteners at assembly with grease, oil or an anti-seize material. Bolt threads and contact surfaces of bolt heads and nuts should be lubricated.

The assembly on un-lubricated stainless steel fasteners cannot be recommended.

(1) If fasteners cannot be lubricated, multiply table values by 1.25.

THREAD SIZE	STAINLESS STEEL (1)
	A2 / A4 – 70
	Nm
M6	7.0
M8	17.0
M10	33.0
M12	57.0
M16	140.0

3.4. Air Motor - flushing

Flush the motor if it is operating slowly or inefficiently. Flushing the air motor removes excessive dirt, foreign particles, moisture or oil that occurs in the operating environment and will help to maintain proper vane performance/motor efficiency.

Safety - Flush the air motor in a well ventilated area. Keep face away from exhaust port. Eye protection must be worn.

Use Gast # AH255B Flushing Solvent, or any non-toxic, non-flammable industrial cleaning solvent. DO NOT use paraffin or ANY other combustible solvents to flush this air motor.

3. MAINTENANCE

3.5. Material Disposal

Tapflo IBC mixers series LBC, HBC are designed for a long trouble-free life. At the end of the useful service life the lubricants and components can be recycled.
The IBC mixer, frame, shaft and impeller are manufactured from stainless steel and the gearbox and electric motor from aluminum and cast iron.
Properly dispose of all mixer and gearbox parts responsibly, in particular lubricants which must be collected for disposal or recycling in accordance with local authority guidelines.

3.6. Ordering Spare Parts

To maintain your IBC mixer only Tapflo genuine spare parts are recommended. To ensure safe reliable operation of your mixer please contact your local distributor for spare parts.

To order please state:

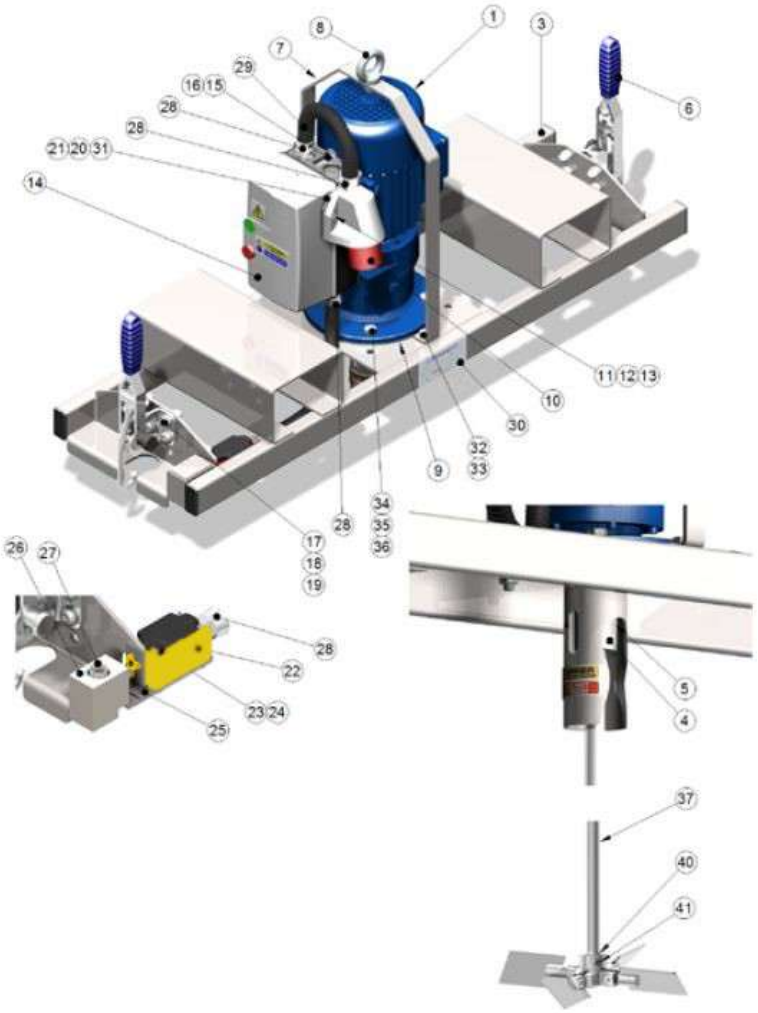
Serial number – indicated on the mixer nameplate.
Item number – description of the part and quantity.

4. SUPPLEMENTARY INSTRUCTIONS

4. SUPPLEMENTARY INSTRUCTIONS AND DRAWINGS

4.1. Mixer Assembly Drawing

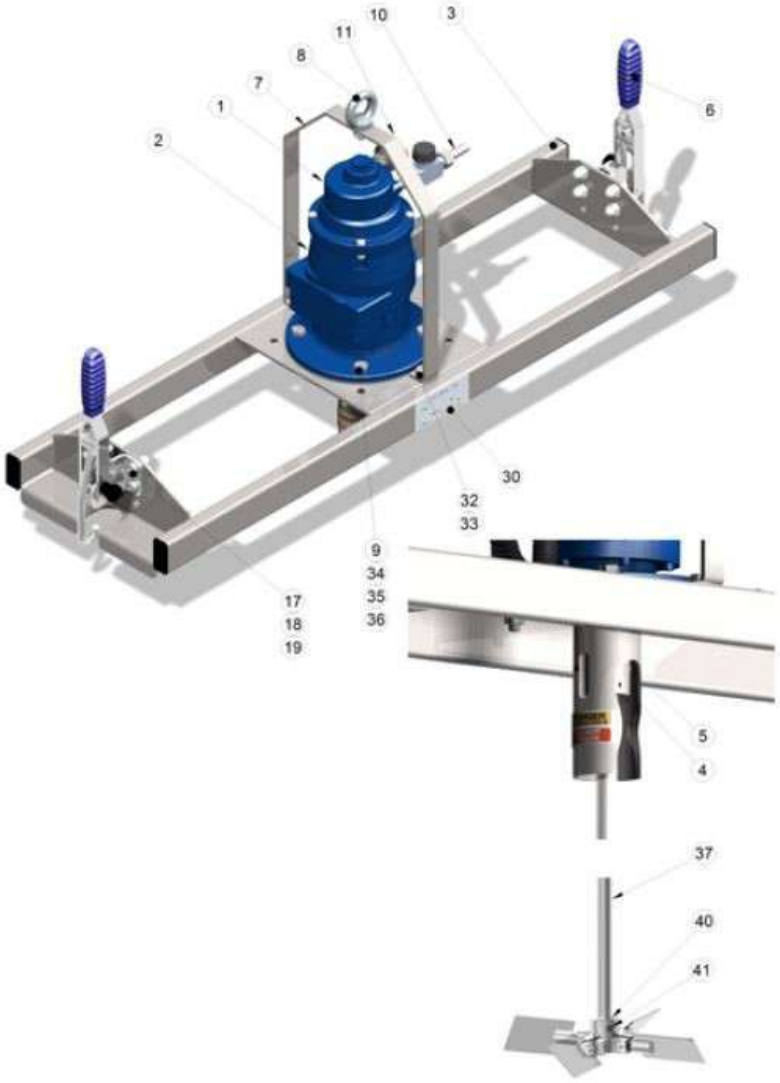
4.1.1. Mixer with Electric Drive



ITEM	Description	QTY	ITEM	DESCRIPTION	QTY
1	Electric motor/Gearmotor	1	21	Hexagon nut	3
3	Mounting frame	1	22	Bernstein safety switch	1
4	Drive coupling	1	23	Hex socket head setscrew	4
5	Hexagon socket setscrew	4	24	Hexagon nut	4
6	Quick action toggle clamps	2	25	Switch plate	1
7	Lifting strap	1	26	Spring operating block	1
8	Lifting eyebolt	1	27	Spring	1
9	Gasket	1	28	Cable gland	6
10	Appliance inlet	1	29	Cable covering	1
11	Hex socket head setscrew	2	30	Nameplate	1
12	Plain washer	2	31	Starter / Frequency inverter support bracket	1
13	Hexagon nut	2	32	Hex head screw	2
14	Start/Stop Unit/Frequency Inverter	1	33	Hexagon nut	2
15	Hex head screw	2	34	Hex head screw	4
16	Hexagon nut	2	35	Hexagon nut	4
17	Button head screw	8	36	Plain washer	4
18	Hexagon domed nut	8	37	Lower shaft	1
19	Plain washer	4	40	Impeller	1
20	Hex head screw	3	41	Hex socket screw	2

4. SUPPLEMENTARY INSTRUCTIONS

4.1.2. Mixer with Air Drive



ITEM	Description	QTY	ITEM	DESCRIPTION	QTY
1	Air motor	**1**	**18**	Hexagon dome nut	**8**
2	Gearbox	**1**	**19**	Plain washer	**4**
3	Mounting Frame	**1**	**30**	Nameplate	**1**
4	Drive Coupling	**1**	**32**	Hex head screw	**2**
5	Hexagon socket set screw	**4**	**33**	Hexagon nut	**2**
6	Quick action toggle clamps	**2**	**34**	Hex head screw	**4**
7	Lifting strap	**1**	**35**	Hexagon nut	**4**
8	Lifting eye bolt	**1**	**36**	Plain washer	**4**
9	Gasket	**1**	**37**	Lower shaft	**1**
10	Flow control valve and hosetail	**1**	**40**	E400 Folding impeller	**1**
11	Muffler	**1**	**41**	Hex socket set screw	**2**

4. SUPPLEMENTARY INSTRUCTIONS

4.2. Nameplate

Every mixer is supplied with a nameplate according to the scheme above. Individual positions are explained below:

Position	Description
Unit type	Complete codification for the mixer according to chapter 1.1
Code	Series type code
Unit ser. No.	Serial number of the unit in format XX.XXX
Speed	Mixer speed – LBC series: 236rpm, HBC series: 1450rpm or other for non-standard executions
Year	Manufacturing date

After the delivery of the mixer the nameplates should be checked whether they correspond with the order. Any inconsistencies should be reported to TAPFLO.

4.3. Air requirements

The air motor requires a clean dry lubricated shop compressed air supply. An Air Line Filter / Regulator & Lubricator is required in the supply line.
Adjust the air line lubricator to 1 drop of oil per minute. Regulate the line pressure to 7-bar max.
Noise - air motors by standard are supplied with a muffler on the exhaust side.

4.4. Impeller Installation

Folding impellers are normally mounted on the end of the shaft as illustrated, and are secured in place by two screws.

4. SUPPLEMENTARY INSTRUCTIONS

Dual Impellers - For viscous materials, Dual Impellers ensure a good top to bottom turnover in the IBC with the second impeller positioned approximately halfway up the shaft. Dual impellers should be placed in such a way that they can freely open during mixing without colliding with other components. The impellers can also be used for wetting powders with the upper impeller positioned in the top 15% of the liquid in case of light particles and at around half the volume with heavy particles.

Low-Level Impeller (Kicker) - A low-level radial flow fixed impeller can also be supplied for mixing the IBC contents at very low liquid levels, also for liquids containing solid particles. The kicker is to be installed below the folding impeller as illustrated. A 1000mm long shaft is available with this option to position the lower impeller close to the bottom of the IBC.

5. WARRANTY

5. WARRANTY

5.1. Returning parts

When returning parts to Tapflo please follow this procedure:

- Consult Tapflo for shipping instructions.
- Cleanse or neutralize and rinse the parts. Make sure there is no liquid or other media present.
- Pack the return articles carefully to prevent any damage during transportation.

Goods will not be accepted unless the above procedure has been complied with.

5.2. Warranty

Tapflo warrants products under conditions as stated below for a period of not more than 12 months from installation and not more than 18 months from date of manufacturing.

1. The following terms and conditions apply to the sale of machinery, components and related services and products, of Tapflo (hereinafter "the products").

2. Tapflo (the manufacturer) warrants that:
   a. its products are free of defects in material, design and workmanship at the time of original purchase;
   b. its products will function in accordance with Tapflo operative manuals; Tapflo does not guarantee that the product will meet the precise needs of the Customer except for those purposes set out in any invitation to render documents or other documents specifically made available to Tapflo before entering into this agreement;
   c. high-quality materials are used in the construction of the mixers and that machining and assembly are carried out to the highest standards.

   Except as expressly stated above, Tapflo makes no warranties, express or implied, concerning the products, including all warranties of fitness for a particular purpose.

3. This warranty shall not be applicable in circumstances other than defects in material, design and workmanship. In particular warranty shall not cover the following:

   a. Periodic checks, maintenance, repair and replacement of parts due to normal wear and tear;
   b. Damage to the product resulting from:
      b.1. Tampering with, abuse or misuse, including but not limited to failure to use the product for its normal purposes as stated at the time of purchase or in accordance with Tapflo instructions for use and maintenance of the product, or the installation or improper ventilation or use of the product in a manner inconsistent with the technical or safety standard in force;
      b.2. Repairs performed by non-skilled personnel or use of non-original Tapflo parts;
      b.3. Accidents or any cause beyond the control of Tapflo, including but not limited to lightning, water, fire, earthquake and public disturbances etc.;

5. WARRANTY

4. The warranty shall cover the replacement or repairing of any parts, which is documented faulty due to construction or assembling, with new or repaired parts free of charges delivered by Tapflo. Parts subjected to normal tear and wear shall not be covered by the warranty. Tapflo shall decide as to whether the defective or faulty part shall be replaced or repaired.

5. The warranty of the products shall be valid for a period in accordance to the current law from the date of delivery, under the condition that notice of the alleged defect to the products or parts thereof be given to Tapflo in written within the mandatory term of 8 days from the discovery. Repair or replacement under the terms of this warranty shall not give a right to an extension to or a new commencement of the period of warranty.

6. Repair or replacement under the terms of this warranty shall not give a right to an extension to, or a new commencement of, the period of warranty. Repair or replacement under the terms of this warranty may be fulfilled with functionally equivalent reconditioned units. Tapflo qualified personnel shall be solely entitled to carry out repair or replacement of faulty parts after careful examination of the mixer. Replaced faulty parts or components will become the property of Tapflo.

7. Installation, including electric and other connections to utility mains according to Tapflo drawings, is for the cost and responsibility of the customer unless otherwise agreed in writing.

8. Tapflo will not be liable on any claim, whether in contact, tort, or otherwise, for any indirect, special, incidental or consequential damages caused to the customer or to third parties, including loss of profits arising by any possible infringement of par. 3 above or by the customer or third parties being in the impossibility of using the products.

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