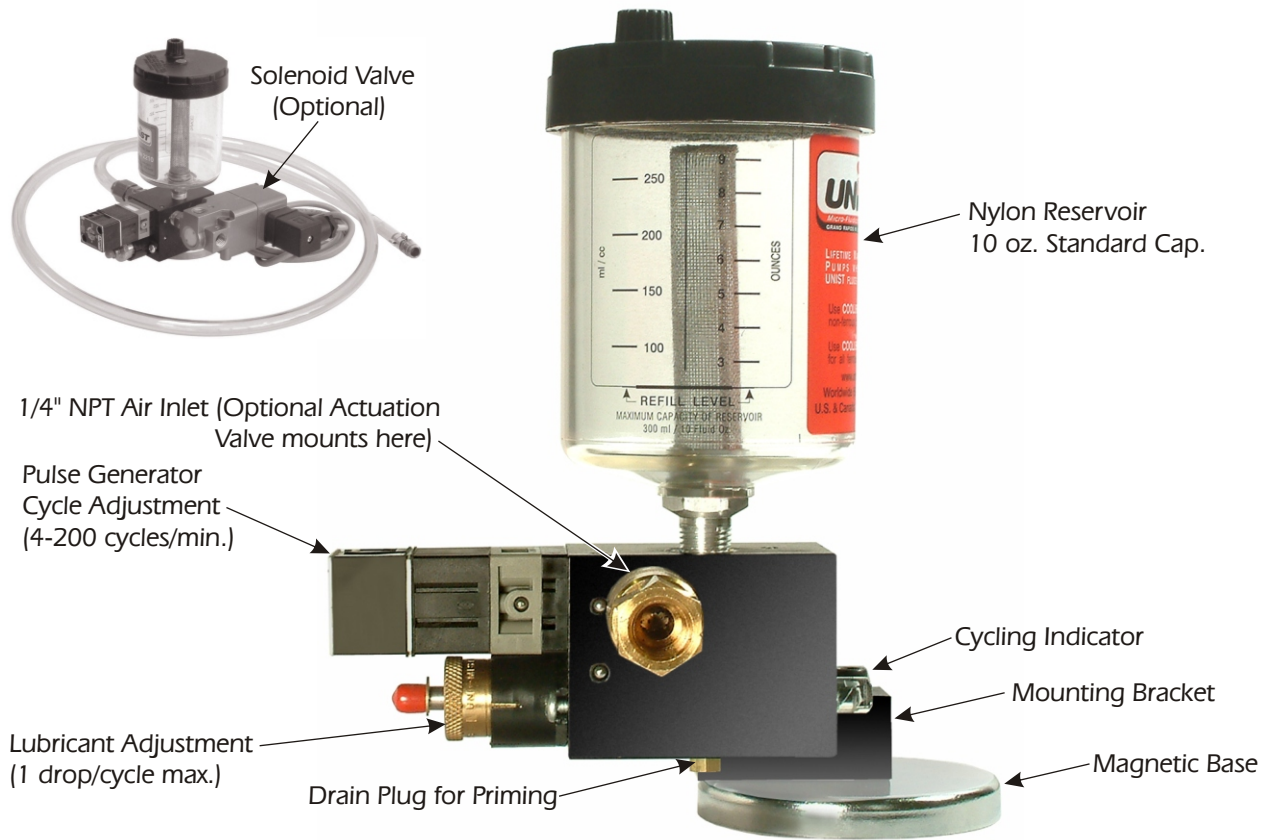


84-4020 TORNADO OPERATING INSTRUCTIONS

TECH BULLETIN 110106



SYSTEM SET-UP

1. The 84-4020 Tornado System is primed before shipment and is basically ready for use. Simply fill reservoir.
2. Connect air supply line to the solenoid, air pilot or manual actuating valve's 1/4 NPT port on the air inlet side of the manifold block.
3. Connect the solenoid valve's electrical leads or the air pilot valve's actuator line to the appropriate on/off trigger source from the machine tool.
4. Use of a quick connect coupling is suggested at the outlet end of the mist air hose.

SYSTEM ADJUSTMENTS

1. Adjust pulse generator with a regular slotted screwdriver to desired cycle/minute output. (4-200 cycles)
2. Liquid output = 1 drop, minimum = 0 drops. (1 drop = 0.033 cc) adjust lubricant output by rotating brass adjustment knob. Rotating clockwise increases output.

NOTE: Sufficient air flow restrictions are required at the mist outlet to provide adequate back-pressure for the pulse generator to cycle.

NEAR DRY MACHINING/MQL LUBRICATION

For Best Results and Lifetime Warranty use **COOLUBE 2210** or **2210EP**



UNIST Near Dry Machining Eliminates messy and expensive flood coolants in all Metalcutting applications and works best with COOLUBE.



Writing the book on non-friction™

UNIST, Inc. 4134 36th St. SE Grand Rapids, MI 49512 • 616-949-0853 • 800-253-5462 • FAX: 616-949-9503