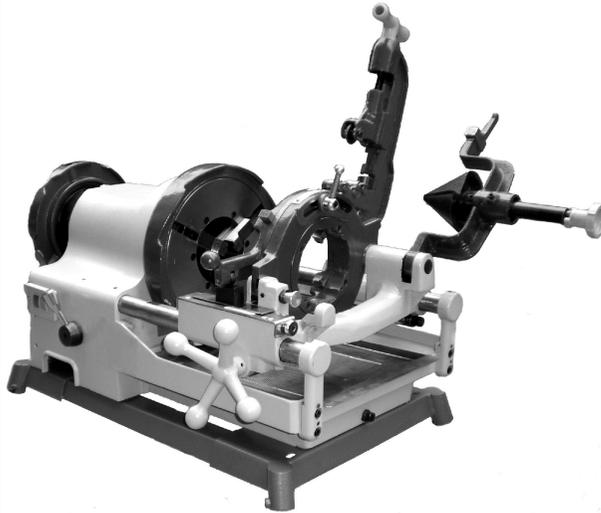




Please read this operation manual carefully before use.



QINGYANG Pipe Threading Machine

Contents

I General Safety Instructions	1
1. Safety Rules for Work Site.....	1
2. Electrical Safety.....	1
3. Personal Safety.....	1
4. Operation and Points for Attention of Electric Machine.....	2
5. Repair Service.....	2
6. Safety Operation of Pipe Grooving Machine.....	2
II Operation Explain	3
1. Function.....	3
2. Main Parts	3
3. Main Technical Parameters.....	4
4. Operation Installation.....	5
5. Electrical Principle and Safety	8
6. Maintenance And Lubrication.....	8
7. List Of Spare Parts and Accessories (Packing List).....	9
8. Part Number Of Parts.....	10

I General Safety Instructions



Warning! Please read and follow all the safety rules for operation, any violation of the safety rules may cause electric shock, fire or personal injury.

1. Safety Rules for Work Site

1.1 Keep the work site clean and bright, disordered and dark site may cause accident.

1.2 It is not allowed to operate the electric machine in an environment with flammable liquid, gas or dust, which may easily cause explosion. The spark generated by the electric machine will light up the dust or gas.

1.3 Unrelated personnel, children and visitors should be kept far away from the site of the electric machine. Absent-minded operation will make the operator lose control of the machine.

2. Electrical Safety

2.1 The plug of the electric machine must be matched with the socket. It is prohibited to refit the plug in any way. It is not allowed to use any adaptor plug for the electric machine which needs grounding. The original plug and matched socket could reduce the risk of electric shock.

2.2 It should be avoided that human body gets contact with the grounding surface, like pipe, heat sink . Human body grounding will increase the risk of electric shock.

2.3 It is not allowed to expose the electric machine in the rain or in the humid environment. It will increase the risk of electric shock in case water enters the electric machine.

2.4 It is not allowed to abuse the power line. It is forbidden to use the electric wire to carry or haul the electric machine or remove the plug by pulling the wire. Keep the power line away from the heat source, oil, sharp edge or moving parts. The damaged or winded flexible line will increase the risk of electric shock.

2.5 When operating the electric machine in the open air, please use the external flexible line which is suitable for use in the open air. It will reduce the risk of electric shock.

2.6 If it is inevitable to operate the electric machine in a humid environment, the residual current protector device RCD (leakage protector) should be used to reduce the risk of electric shock.

2.6.1 For single 220V electric machine, 2-pol 2-line RCD should be used in priority.

2.6.2 For 3-phase 4-line 380V electric machine, 3-pol 4-line RCD or 4-pol 4-line RCD should be used in priority.

2.6.3 For 3-phase 3-line 380V electric machine, 3-pol 3-line RCD should be used in priority.

3. Personal Safety

3.1 Keep alert. When operating the electric machine, pay close attention to the operation and keep clear-minded. When you feel tired, or have a drug, alcohol or treatment reaction,

do not operate the electric machine. In the operation of electric machine, momentary negligence may cause serious personal injury.

3.2 Please use personnel protective device. Wear goggles during operation. Dust mask, antiskid shoes, safety helmet and hearing protection device must be used in corresponding situation.

3.3 Prevent unexpected start-up. Insure the switch is off when connecting the power supply, lifting up or moving the machine. It may cause danger if putting fingers on the alive switch or inserting the plug when the switch is on.

3.4 Before the electric machine is turned on, take off the tools (such as spanner, etc.) left on the rotary components of the electric machine to avoid personal injury.

3.5 Do not stretch your arms too far. Watch your foothold and keep body balance, so that the electric machine is well controlled in case of unforeseen circumstances.

3.6 Dress properly. It is not allowed to wear gloves, loose clothes or decorations. Keep clothes and hair away from the moving parts. Gloves, loose clothes, decorations or long hair may get involved in the moving parts to cause serious personal injury.

4. Operation and Points for Attention of Electric Machine

4.1 Do not abuse the electric machine, use the proper electric machine according to your application. Choosing the properly designed electric machine will make your work more efficient and safer.

4.2 If the power can not be turn on or turn off by the switch, it is not allowed to use the electric machine. The electric machine which can not be controlled by the switch is dangerous, it must be repaired.

4.3 The power plug must be removed from the socket before any adjustment, or replacement of accessories, or storage of the electric machine. These protective measures will reduce the risk of unexpected start-up of the machine.

4.4 Store the unused electric machine out of the reach of children. And the person who is not familiar with the electric machine or does not understand the instructions is not allowed to operate the electric machine. If there is damage, the electric machine should be repaired before use. A lot of accidents are caused by poorly maintained machines.

4.5 Keep the cutting tools sharp and clean. The well maintained cutting tools with sharp edge is not easy to get stuck and easy to control.

4.6 Use the electric machine, its accessories and cutting tools according to the operation manual with consideration of the operation conditions and practical work. It may cause danger if the electric machine is used for the purpose other than its designed application.

5. Repair Service

Send the electric machine to professionals for repaired with the original spare parts. This will ensure the safety of the repaired electric machine.

6. Safety Operation of Pipe Grooving Machine

6.1 The pipe threading machine is used for pipe threading and cutting, please comply with the instructions of the operation manual. It will increase the risk of injury if it is used for other purposes.

6.2 Please fix the machine on the flat round or working bench to prevent the machine from turnover.

6.3 Please use the pipe stand to support longer and heavier pipe to prevent the machine from turnover.

6.4 It is not allowed to wear gloves and loose clothes. Please do not bend over the machine because the clothes may get involved in the rotary parts to cause winding and injury.

6.5 Please tighten the chuck before turning on the machine to prevent the pipe from swinging.

II Operation Explain

Manufactured as per Q/20193365-9.05

1. FUNCTION

QINGYANG pipe threading machines are mainly used to make external taper pipe threads with 55° teeth angle in conformity with GB/T 7306 standard. They are designed with pipe threading, cutting and reaming functions. In case they are equipped with specially-made grooving tool, they can be used for grooving operation. They are ideal tools for improving labor productivity and reducing construction cost.

2.MAIN PARTS

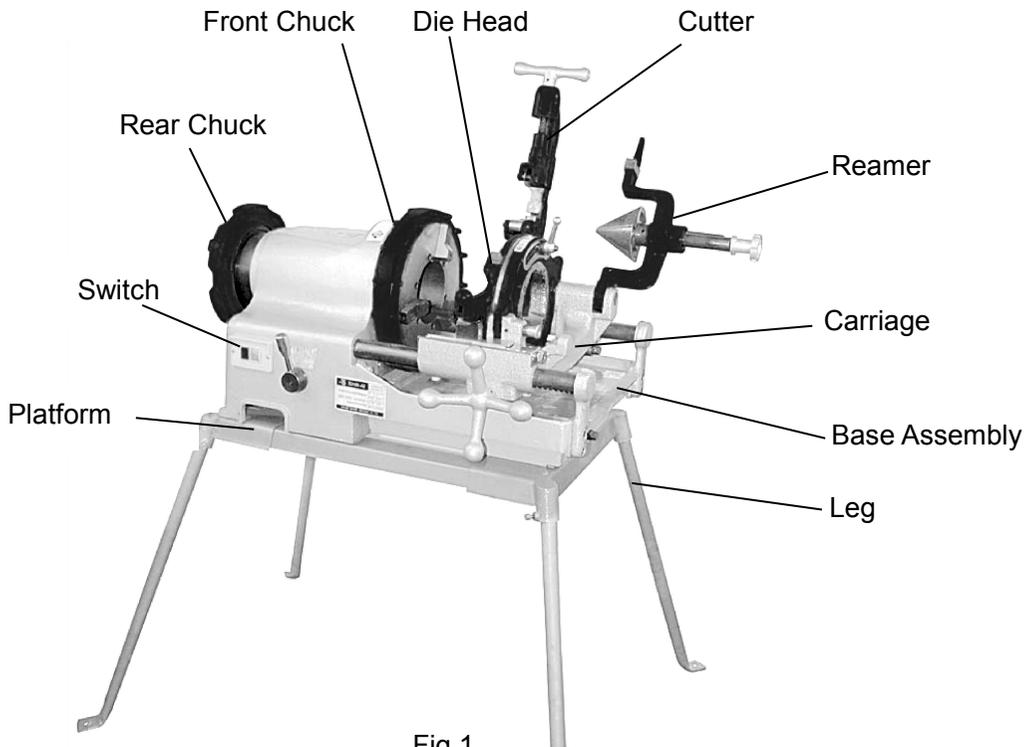


Fig.1

3. MAIN TECHNICAL PARAMETERS

Table1-a

Model	TQ25-C		TQ50-AEX		TQ50-CFX		TQ50-CFX1		TQ50- DX	
Capacity	1/2-1		1/2-2		1/2-2		1/2-2		1/2-2	
Spindle speed	32 r/min (No-load)		18 r/min		18 r/min		21 r/min		18 r/min	
Thread standard	GB/T 7306									
Die system	REX		114		REX		REX		REX	
Die opening	Manual		Manual		Manual		Manual		Profiling	
Die head	DH25-B		DH50		DH50-C		DH50-C		DH50-G	
Size and quantity of dies attached to machine	1/2-3/4	1	1/2-3/4	1	1/2-3/4	1	1/2-3/4	1	1/2-3/4	1
	1	1	1-11/4	1	1-2	1	1-2	1	1-2	1
	-	-	11/2-2	1	-	-	-	-	-	-
Motor	H261 220V 650W 28000r/min(No-load)		YDQ120-2 220V 50Hz 750W 2800 r/min		YDQ120-2 220V 50Hz 750W 2800 r/min		DOT7142P 110V 60Hz 750W 3300 r/min		YDQ120-2 220V 50Hz 750W 2800 r/min	
Capacitor	-		450V 30uF		450V 30uF		250V 180uF		450V 30uF	
Weight	29kg		56kg		56kg		56kg		58kg	
Dimensions	447×290×290		545×400×396		545×400×396		545×400×396		545×400×396	

Table1-b

Model	TQ80-AX		TQ80-B		TQ80-C		TQ80-DB		TQ80-DC	
Capacity	1/2-3		1/2-3		1/2-3		1/2-3		1/2-3	
Spindle speed	11, 23 r/min		11, 23 r/min		11, 23 r/min		17, 24, 37 r/min		17, 24, 37 r/min	
Thread standard	GB/T 7306									
Die system	1/2-2	114	1/2-2	114	REX		1/2-2	114	REX	
	21/2-3	REX	21/2-3	REX			21/2-3	REX		
Die opening	Manual opening		Manual opening		Manual opening		Manual opening		Manual opening	
Die head	DH50, DH80		DH50, DH80		DH50-C, DH80-B		DH50, DH80		DH50-C, DH80-B	
Size and quantity of Dies attached to machine	1/2-3/4	1	1/2-3/4	1	1/2-3/4	1	1/2-3/4	1	1/2-3/4	1
	1-11/4	1	1-11/4	1	1-2	1	1-11/4	1	1-2	1
	11/2-2	1	11/2-2	1	21/2-3	1	11/2-2	1	21/2-3	1
	21/2-3	1	21/2-3	1			21/2-3	1		
Motor	YT7122 380V 50Hz 1KW 2800 r/min		YDQ120-2 220V 50Hz 750W 2800 r/min		YDQ120-2 220V 50Hz 750W 2800 r/min		DOT9012GA 220V 50Hz 1.1KW 2800 r/min		DOT9012GA 220V 50Hz 1.1KW 2800 r/min	
Capacitor	-		450V 30uF		450V 30uF		450V 80uF		450V 80uF	
Weight	95kg		95kg		95kg		90kg		90kg	
Dimensions	790×470×388		790×470×388		790×470×388		675×477×480		675×477×480	

Table 1-c

Model	TQ80-DF		TQ100-AE		TQ100-BFX		TQ100-CG		TQ100-DF	
Capacity	1/2-3		1/2-4		1/2-4		1/2-4		1/2-4	
Spindle speed	20, 28, 44 r/min		9, 23 r/min		9, 23 r/min		9, 23 r/min		19, 27, 42 r/min	
Thread standard	GB/T 7306									
Die system	REX		1/2-2, 114		REX		1/2-2, 114		REX	
			2 1/2-4, REX				2 1/2-4, REX			
Die opening	Profiling		1/2-2, Manual opening		Profiling		1/2-2, Manual opening		Profiling	
			2 1/2-4, Profiling				2 1/2-4, Profiling			
Die head	DH80-A		DH50-F, DH100-B		DH50-E, DH100-B		DH50-F, DH100-B		DH50-B, DH100-A	
Size and quantity of dies attached to machine	1/2-3/4	1	1/2-3/4	1	1/2-3/4	1	1/2-3/4	1	1/2-3/4	1
	1-2	1	1-11/4	1	1-2	1	1-11/4	1	1-2	1
	21/2-3	1	11/2-2	1	21/2-4	1	11/2-2	1	21/2-4	1
			21/2-4	1			21/2-4	1		
Motor	DOT9012GA 220V 50Hz 1.1KW 2800 r/min		YDQ120-2 220V 50Hz 750W 2800 r/min		YYT1000 220V 50Hz 1KW 2800 r/min		YT7122 380V 50Hz 1KW 2800 r/min		DOT9012GA 220V 50Hz 1.5KW 2800 r/min	
Capacitor	450V 80uF		450V 30uF		450V 30uF		-		450V 60uF	
Weight	91kg		107kg		107kg		107kg		115kg	
Dimensions	675×477×480		830×525×425		830×525×425		830×525×425		751×540×516	

Table 1-d

Model	TQ100-C1		TQ100-DFW		TQ150-AD		TQ150-BC			
Capacity	1/2-4		1/2-4		2 1/2-6		2 1/2-6			
Spindle speed	22, 10 r/min		19, 27, 42 r/min		5, 15r/min		5, 15r/min			
Thread standard	GB/T 7306		GB/T 7306		GB/T 7306		GB/T 7306			
Die system	REX		REX		REX		REX			
Die opening	Profiling		Profiling		Profiling		Profiling			
Die head	DH50-B DH100-A		DH50-B, DH100-A		DH100 DH150		DH100 DH150			
Size and quantity of dies attached to machine	1/2-3/4	1	1/2-3/4	1	21/2-4	1	21/2-4	1		
	1-2	1	1-2	1	5-6	1	5-6	1		
	21/2-4	1	21/2-4	1						
Motor	YT7122 380V 50Hz 1KW 2800 r/min		YST9012 380V 50Hz 1.5KW 2800 r/min		YST9012 380V 50Hz 1.5KW 2800 r/min		DOT9012GA 220V 50Hz 1.5KW 2800 r/min			
Capacitor	-		-		-		450V 60uF			
Weight	153kg		115kg		182kg		182kg			
Dimensions	870×540×480		751×540×516		930×670×590		930×670×590			

4. OPERATION INSTRUCTIONS

4.1 Preparation

4.1.1 Fit the legs into the holes of the platform or base assembly and fasten them.

4.1.2 Lubricate each rotating and moving part. Fill the two ball valve oilers with engine oil one or two times every shift. Raise the cutter, die head and reamer to their non-operative position. Pull out the grip (See Fig.2) before raising the profiling die head. Fill the tank with cutting coolant, start the machine and let it run idly to check if the machine is normal.

4.1.3 The power supply circuit must be provided with ground wire and fuse for safety.

4.1.4 The high speed threading machine should be stopped for speed change. If there is any difficulty, turn the front chuck with hand to make the gear engaged.

4.2 Threading

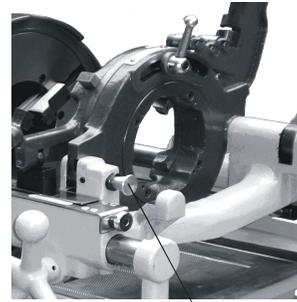
4.2.1 Install the correct dies into the die head against the numbers according to the size of the pipe to be processed. The dies should be used as a complete set. Mount the die head in the relative hole in the carriage and lower it to the threading position.

4.2.2 Loosen the lock lever (See Fig. 3) on the die head and turn the cam plate to make the scale line be aligned with the position corresponding to the desired thread size. The scale line location can be adjusted according to the processing situation so as to obtain satisfactory thread.

4.2.3 As to the machine with profiling die head, turn the knurl knob (See Fig.4) on the profiling assembly to make the scale line be aligned with the desired thread size. The position of the profiling assembly can be adjusted as per practical situation to obtain desired thread length.

4.2.4 Select the rotating speed of the spindle according to the indication at the shift lever (See Fig.5). Turn the hand wheels of the front and rear chucks to open both the chucks. Insert the pipe, leaving a proper length to be processed outside the front chuck. Close with hand the rear chuck and then the front chuck tightly.

4.2.5 After the above preparation has been completed, start the machine and move the carriage to make the dies get into contact with the pipe, and then apply proper force on the carriage handle until the dies get engaged with the pipe. Then, the threading will be done automatically.



Grip Fig.2

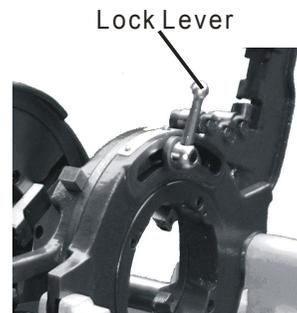
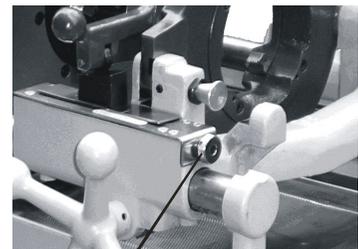


Fig.3



Knurl knob

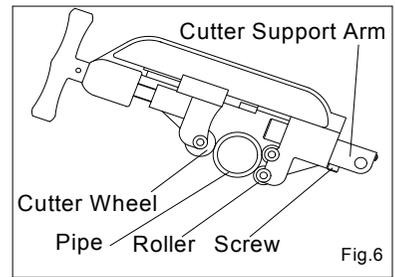
Fig.4



Shift Lever

Fig.5

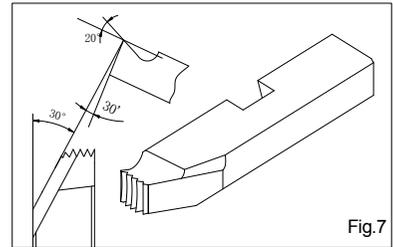
As for the machine with profiling die head, the roller on the die head rolls on the profiling board slowly to open the die head to form a taper of 1/16. When the roller falls down at the end of the profiling board, the threading is finished and the die head is open. Turn the carriage handle wheel to retract the carriage to its original position. Pull out the grip and put the die head in the non-operative position. Jerk the front chuck open, loosen the rear chuck and then take out the pipe.



4.2.6 For the machine using a series motor, its spindle speed will be reduced in pipe threading operation. This is a normal phenomenon.

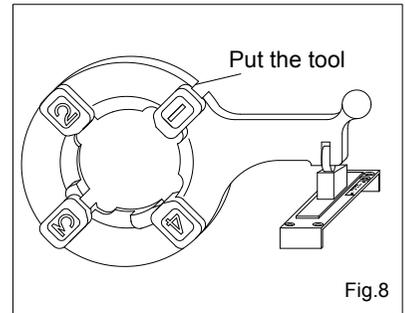
4.3 Pipe Cutting

Set the shift lever to the fast position in order to boost the work efficiency.



4.3.1 Adjust the screw beneath the cutter support arm to make the two rollers of the cutter contact the surface of the pipe at the same time (See Fig.6)

4.3.2 Chuck the pipe at the desired position, lower the cutter, start the machine and turn the cutter handle to cut the pipe. Turn the handle a quarter of a revolution for each revolution of the machine.

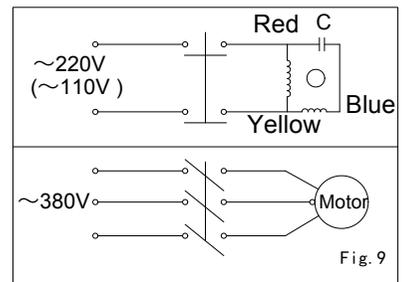


4.3.3 After cutting, raise the cutter to its rest position and back the carriage.

4.4 Reaming

Set the shift lever to the same position as in pipe cutting.

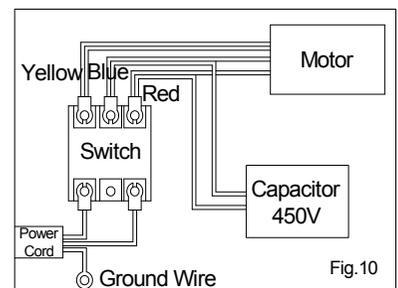
4.4.1 Chuck the pipe, lower the reamer, push the reamer shaft toward the chuck and lock it at the end. Start the machine and move the carriage to feed the reamer cone into the pipe for reaming.



4.4.2 When the reaming is completed, retreat the reamer and raise it to the rest position and back the carriage.

4.5 Grooving

4.5.1 Make use of a scrapped die and get it ground as per the required angle as shown in Fig.7. Put the tool into the operative slot in the die head, and pad a flat object under the roller of die head in the front of the profiling assembly as shown in Fig.8.



4.5.2 Insert the pipe and chuck it. Start the machine and move the carriage to make the grooving tool contact with the pipe and then begin to groove. You will obtain a different grooving effect when changing the speed.

5. ELECTRICAL PRINCIPLE AND SAFETY

The electrical principle diagram and the circuit diagram are shown in Fig.9, Fig.10 and Fig. 11



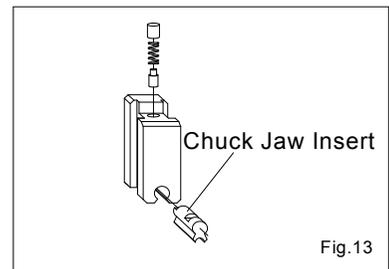
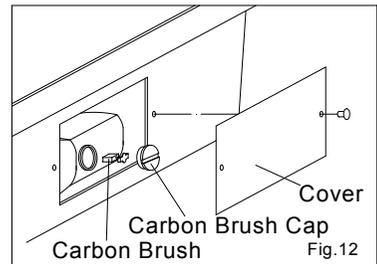
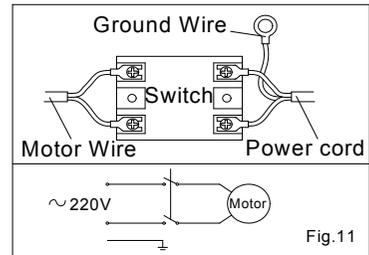
Warning!!

5.1 The power circuit must be provided with a ground wire and connected with a proper fuse..

5.2 Each time after repair, the ground wire of the machine must be well connected. The wire terminals must be jacketed with sleeves and the wiring must be carefully checked if it is correct.

5.3 As the threading machine using a capacitor motor has a smaller starting torque, only no-load starting is allowed. In order to avoid overheating of the capacitor motor due to an under load, the no-load running time should not be greater than 30 minutes.

5.4 For the threading machine adopting series motor, it is necessary to open the cover at both sides in the lower part of the base assembly and check the carbon brushes after unscrewing the carbon brush cover (see Fig.12). When the length of the carbon brush in the motor is less than 9mm, please replace the carbon brush in time. The power cord must be removed before changing the carbon brushes. Poor quality carbon brushes may also destroy the motor.



6. MAINTENANCE AND LUBRICATION

6.1 Fill the two ball valve oiler on the housing with L-AN32 (GB443-1989) engine oil one or two times every shift. All the rotating and moving parts should be frequently lubricated with oil. The machine should be kept clean.

6.2 The gearbox of a new machine should be cleaned after the first 600-hour running, and then, once every 1200-hour running. After each cleaning, always fill the gear box with No.3 lithium base grease.

6.3 As the rear jaw holder of the rear chuck is made of aluminium-alloy casting, it is not allowed to strike it. The front and rear chucks should be kept clean, and the chuck jaw inserts should be flexible in movement. Slippage will happen when the tips of chuck jaw inserts are worn out. In this case, replace the inserts as shown in Fig.13 or grind them.

6.4 After a long-term operation of the front chuck, burrs may exist at the positions where the hand wheel contacts with the front chuck scroll, thus causing a difficult rotation of the hand wheel of the front chuck. In this case, it should be disassembled to remove the burr with a file. It is not allowed to solve this problem by loosening the six screws of the chuck.

6.5 The oil supply for the die head can be adjusted with the knurl knob on the valve under the carriage. The cutting coolant should be used according to the instructions on the coolant container. Tap water can not be directly used as coolant.

6.6 If the coolant flow is found insufficient or the coolant is not supplied, check to see if the coolant in the tank is sufficient, the filter are blocked up, the oil pipe is broken or the oil pump is working normally. The coolant tank should be cleaned once every 48-hour operation.

6.7 The inside of the die head should be often kept clean. If the cam plate is difficult to turn and the dies can not move flexibly, a cleaning should be made in time. It is not allowed to strike any part of the die head.

6.8 The normal operation conditions for the pipe threading machine: the height above the sea level is no more than 1000m; the environment temperature is from 0°C to +40°C; the relative humidity is no more than 90% (25°C) .

7. LIST OF SPARE PARTS AND ACCESSORIES (PACKING LIST)

It should be noted that the customer should purchase the pipe stand additionally if it is needed. The part number of the pipe stand for TQ100-C1/DF is JLM4.114.007.

Table 2-a

Description	TQ25-C	TQ50-AEX	TQ50-CFX	T50-CFX1	TQ50-DX
Leg	-	3	3	3	3
Spare Cutter Wheel	1	1	1	1	1
Screw Driver	2	2	2	2	2
Oil Gun	1	1	1	1	1
Coolant	1kg	2kg	2kg	2kg	2kg
Paint Brush	1	1	1	1	1
Hexagonal spanner	3,4,5,6	3,4,5,6	3,4,5,6	3,4,5,6	3,4,5,6
Carbon Brush	1	-	-	-	-

Table 2-b

Description	TQ80-AX	TQ80-B	TQ80-C	TQ80-DB	TQ80-DC
Die Head 1/2-2	1	1	1	1	1
Leg	4	4	4	4	4
Spare Cutter Wheel	1	1	1	1	1
Screw Driver	2	2	2	2	2
Oil Gun	1	1	1	1	1
Coolant	2kg	2kg	2kg	2kg	2kg
Paint Brush	1	1	1	1	1
Hexagonal spanner	4,5,6,8	4,5,6,8	4,5,6,8	4,5,6,8	4,5,6,8
Carbon Brush	-	-	-	-	-

Description	TQ80-DF	TQ100-AE	TQ100-BFX	TQ100-CG	TQ100-DF
Die Head 1/2-2	1	1	1	1	1
Leg	4	4	4	4	4
Spare Cutter Wheel	1	1	1	1	1
Screw Driver	2	2	2	2	2
Oil Gun	1	1	1	1	1
Coolant	2kg	2kg	2kg	2kg	2kg
Paint Brush	1	1	1	1	1
Hexagonal spanner	3,4,5,6,8	3,4,5,6,8	3,4,5,6,8	3,4,5,6,8	3,4,5,6,8
Carbon Brush	-	-	-	-	-

Table 2-d

Description	TQ100-C1	TQ100-DFW	TQ150-AD	TQ150-BC	
Die Head 1/2-2	1	1	-	-	
Die Head 2 1/2-4	-	-	1	1	
Leg	4	4	4	4	
Spare Cutter Wheel	1	1	1	1	
Screw Driver	2	2	2	2	
Oil Gun	1	1	1	1	
Coolant	2kg	2kg	2kg	2kg	
Paint Brush	-	1	-	-	
Hexagonal spanner	3,4,5,6,8	3,4,5,6,8	4,5,6,8	4,5,6,8	
Carbon Brush	-	-	-	-	

8. PART NUMBER OF PARTS

Table 3-a

Model	Pump	Die Head	Gearbox with Motor	Profiling Assembly	
TQ25-C	JLM5.869.1000	JLM4.240.1002	JLM4.220.1034	—	
TQ50-DX	JLM5.869.1004	JLM4.240.016	JLM4.220.018	JLM4.114.019	
TQ50-AEX		JLM4.240.001			
TQ50-CFX		JLM4.240.008	JLM4.220.019		
TQ50-CFX1			JLM4.220.019		
TQ80-AX	JLM5.869.00	JLM4.240.001	JLM4.220.1028	/	
TQ80-B		JLM4.240.009	JLM4.220.004		
TQ80-C		JLM4.240.008 JLM4.240.009			
TQ80-DB	JLM5.869.002	JLM4.240.001 JLM4.240.009	JLM4.220.1015		
TQ80-DC		JLM4.240.008 JLM4.240.009			
TQ80-DF		JLM4.240.012	JLM4.220.1016		JLM4.114.013
TQ100-C1	JLM5.869.001	JLM4.240.007 JLM4.240.005	JLM4.220.014		JLM4.114.008
TQ100-AE	JLM5.869.003	JLM4.240.014 JLM4.240.013	JLM4.220.015		JLM4.114.017

TQ100-CG		JLM4.240.014 JLM4.240.013	JLM4.220.016	
TQ100-DF	JLM5.869.002	JLM4.240.007 JLM4.240.005	JLM4.220.1018	JLM4.114.014
TQ100-DFW				
TQ100-BFX	JLM5.869.003	JLM4.240.013 JLM4.240.015	JLM4.220.1027	JLM4.114.017
TQ150-BC	JLM6.455.000	JLM4.240.002 JLM4.240.003	JLM4.220.1019	JLM4.114.003
TQ150-AD			JLM4.220.1020	

Table 3-b

	Front Chuck	Rear Chuck	Cutter	Reamer
TQ25-C	JLM6.270.1010	JLM6.270.1001	JLM4.114.1026	JLM6.150.1024
TQ50-AEX (CFX/CFX1/DX)	JLM6.270.007	JLM6.270.009	JLM4.114.011	JLM6.150.039
TQ80-AX	JLM6.270.007	JLM6.270.006	JLM4.114.012	JLM6.150.029
TQ80-B				
TQ80-C				
TQ80-DB (DC/DF)				
TQ100-C1	JLM6.270.011	JLM6.270.012	JLM4.114.016	JLM6.150.061
TQ100-AE(CG)				
TQ100-DF/DFW	JLM6.270.016			
TQ100-BFX				
TQ150-AD	JLM6.270.003	JLM6.270.002	JLM4.114.004	JLM6.150.032
TQ150-BC				

Note: 1. The logo “   ” on QINGYANG Pipe Threading Machine products is a anti-counterfeit mark. Please pay attention to the logo and protect it with care.

2. The operation manual is subject to change without notice. CEC Jinjiang Info Industrial CO., Ltd. owns the right of interpretation.

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