

# MaceratingFlo R1 Upflush Toilet System Installation Guide



**MACERATING  
FLO**

Innovation For A Better Flow



At MaceratingFlo, we understand that even the best plumbing systems can face challenges.

Our goal is to make installing the MaceratingFlo upflush toilet system straightforward and simple, achievable in perhaps half a day's work.

While our systems are designed to be user-friendly, errors can still occur. That's why we provide detailed guidance and support. Drawing from industry practices and considering the latest technology and home needs, we ensure you can easily and correctly install your system.

Whether you're a beginner or experienced installer, following our step-by-step guide ensures successful installation and avoids common pitfalls.



# R1 Toilet Package List



R1 Toilet



Floor Mounting Kit



Water Tank Mounting Kit



Seat Mounting Kit



Flush Lever



Extension Pipes



Tank-To-Bowl Gasket

# Macerating Pump Package List



600W Pump

OR



750W Pump



Clamps



Hoses



Stoppers



Floor Mounting Kit



Elbow

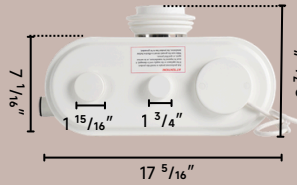
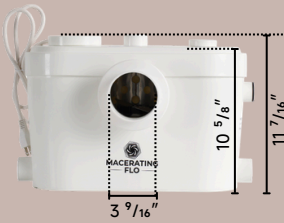
# Dimensions



Digital Manual



If you need to purchase a smart bidet, please check the dimensions.



Please note that the 600W pump and 750W pump are the same size.



27 3/8"

Without Extension Pipe

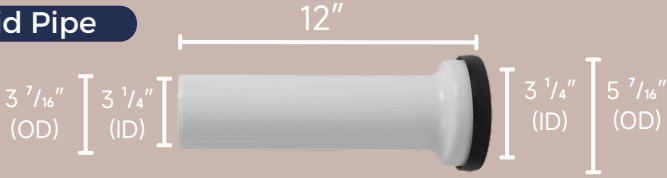


38 9/16"

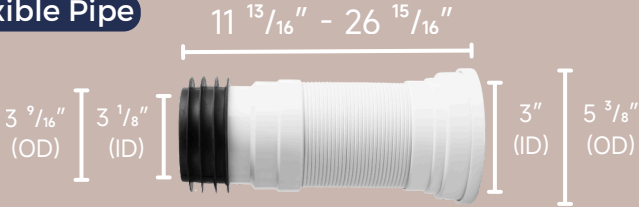
With Extension Pipe

# Dimensions

## Rigid Pipe

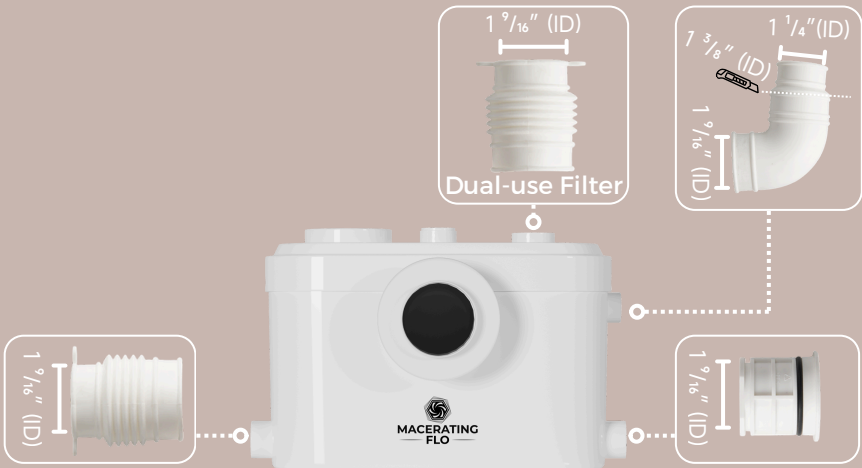




## Flexible Pipe



Note: The right end, as shown above, is connected to the toilet.

## Pipe Size Compatibility



Name	Image	Originally Fits	After Cutting
Elbow		NPS 1" Pipe	NPS 1 1/4" Pipe
Flexible Hose		NPS 1" or 1 1/4" Pipe	/

## Step 1

Read the installation instructions included with the MaceratingFlo unit. Identify all provided components and acquire any needed NPS 1 or 1 1/4" PVC pipes and fittings, along with PVC fasteners, cleaner, primer, and glue.



Choose the installation location within the maximum distance range: For installation distances,

- The Ultra 750W Pump supports up to 36 feet below sewer lines and 328 feet from the soil stack.
- The Pro 600W Pump allows for 30 feet below sewer lines and 262 feet from the soil stack.

If you plan to connect additional fixtures to the MaceratingFlo unit, they must be on the same structural level.

## Step 2



Pro 600W



Ultra 750W

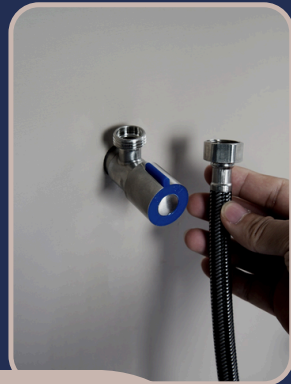
### Step 3

Cut into the soil stack material and install a Y-connector for the macerator discharge pipe.



### Step 4

When installing with a concealed macerating pump, ensure about 12" of space behind the pump frame. When installing near an exterior wall, leave a few inches behind the macerator for insulation.



### Step 5

Establish or access a fresh water supply in the installation area, with a shut-off valve and water line prepared in advance, using cold water for toilet installation.



### Step 6

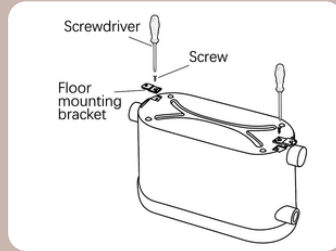
A nearby 15-amp circuit is needed to operate the macerating pump. Due to proximity to water, the circuit should be protected with a Ground Fault Circuit Interrupter (GFCI) in actual installations.

## Step 7

Now prepare to install the macerator unit, starting with attaching elbows and hoses to the corresponding pump outlets and inlets, securing them with clamps.



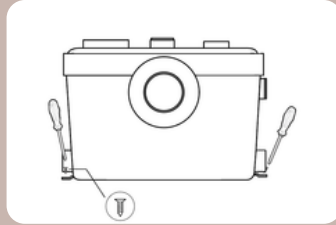
- a. Place the pump in position.
- same level as the toilet
  - 0.4" from the wall



- Secure the pump by #8 Phillips pan head self-taping screws (not provided).



- b. Install the discharge elbow.



- Plastic anchors (not provided) would be needed for concrete floor.



- Secure the elbow with a clamp. Ensure it's properly positioned: press down and tighten with a flathead screwdriver.



- Note:** the pump's sewage outlet has an integrated check valve, eliminating the need for an additional check valve in the elbow.



- c. In the same way, insert the hose into the pump's water inlet and continue to secure it with a clamp.



- d. For any unused water inlets, insert stopper plugs and twist to tighten.

## Step 8

Connect the pump to PVC pipe, ensuring it's primed and glued. Arrange PVC pipes as required, using two 45° elbows for right-angle turns for smoother flow. Insulate pipes in areas where freezing is a concern.



- a. Insert a 1" sewage PVC pipe to the elbow and secure it with a clamp. Alternatively, cut off the elbow's marked section and connect a 1 1/4" pipe.



- We recommend installing a stop and waste valve in the drain pipe during setup for easier maintenance of the toilet or pump later on.



- b. To connect to a sink or shower waste, use the pump's left and right inlets. Ensure the hot water temperature for bathtubs and faucets is 131°F or lower.

Use a 1 1/4" pipe for connection, preferably with at least a 10° slope for gravity flow into the pump.



- c. The top right corner of the pump has a dual-use filter with activated carbon.



- You can also connect it to your exhaust system. Insert a hose, secure with a clamp, then connect to a 1 1/4" vent pipe.

## Step 9

After securing the PVC pipes, connect the toilet bowl to the pump.

- a. Mark the locations of the mounting holes. Drill holes at the marked points.



Rigid Pipe



Flexible Pipe

**Note:** An extension pipe is optional. If needed, attach it when marking the bowl location. The installation process is the same with or without it.

- b. Secure the toilet bowl to the pump with a large clamp. Insert the floor mounting components in order.



**Note:** If concealing the pump, remember to install a removable panel in the wall for macerator access.

## Step 10

Connect Water Tank & Toilet Bowl. You may scan the QR code to watch the video guide for assistance.



a. Tighten the tank-to-bowl bolt set in order.



**Note:** Make sure the flush valve nut is securely tightened before installation.



b. Place the rubber gasket on the bottom of the tank, align each opening, and set the tank on top.



c. Tighten the bottom nuts, then firmly secure the screws to prevent leaks, using a screwdriver as needed for assistance.



## Flush Volume Adjustment Guide

# Step 11

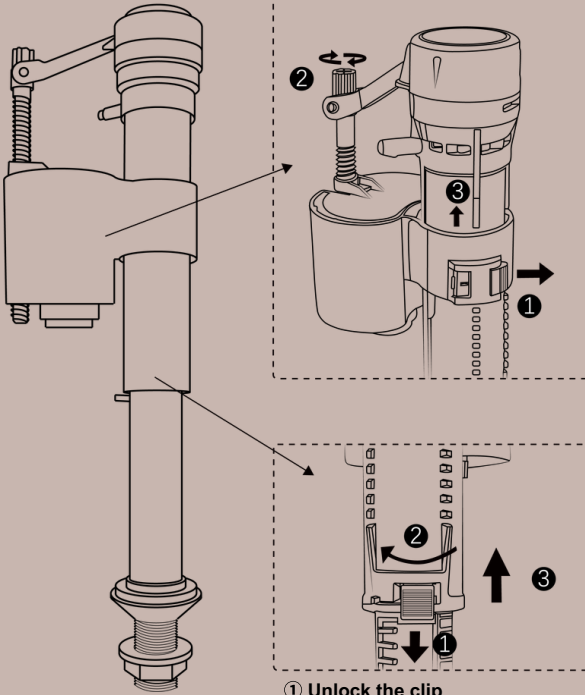
Attach the lever.



### \*How To Adjust The Fill Valve To Fix A Poor Flush?

TIP: Please remember to restore the clips after adjustment.

- ① Unlock the clip
- ② Adjust the lever float upward
- ③ Level the float with the lever float



(Note: Do not exceed the internal tank height.)

- ① Unlock the clip
- ② Twist the valve
- ③ Adjust the height

Figure 1

## Step 12

Connect the supply water line and plug in the pump, beginning to test if the toilet and pump operate smoothly.



## Step 13



After successful testing, install the toilet seat. Scan the QR code to watch how to correctly install.



a. Place the bracket and expansion bolts onto the seat.



b. Pull the bracket directly in the direction of the toilet bowl.



c. Tighten the screws.



d. Insert the toilet seat until you hear a "click".

## Troubleshooting Guide

**Warning:** When servicing or replacing any components, be sure the water supply is shut off and the toilet is flushed.

SYMPTOMS	PROBABLE CAUSES	REMEDIES
The pump stops	<ul style="list-style-type: none"> <li>• An object is blocking the blades.</li> <li>• The pump has been running for too long, triggering the thermal cut out.</li> </ul>	<ul style="list-style-type: none"> <li>• Call an approved service engineer.</li> <li>• The pump should reset itself after cooling down.</li> </ul>
Pump intermittently activates	<ul style="list-style-type: none"> <li>• Connected sanitary devices are dripping.</li> </ul>	<ul style="list-style-type: none"> <li>• Inspect and correct the installation upstream.</li> </ul>
	<ul style="list-style-type: none"> <li>• Faulty check valve.</li> </ul>	<ul style="list-style-type: none"> <li>• Clean or replace the check valve.</li> </ul>
Slow and intermittent water drainage	<ul style="list-style-type: none"> <li>• Air vent is clogged.</li> <li>• Toilet bowl is partially blocked.</li> </ul>	<ul style="list-style-type: none"> <li>• Clear the air vent.</li> <li>• Ensure the toilet bowl is clear of any blockages.</li> </ul>
Pump runs for extended periods	<ul style="list-style-type: none"> <li>• Installation exceeds specified length/height or contains too many bends/elbows.</li> </ul>	<ul style="list-style-type: none"> <li>• Check the installation.</li> </ul>
	<ul style="list-style-type: none"> <li>• Pump chamber blockage.</li> </ul>	<ul style="list-style-type: none"> <li>• Call an approved service engineer.</li> </ul>
Pump does not activate	<ul style="list-style-type: none"> <li>• No electrical power.</li> </ul>	<ul style="list-style-type: none"> <li>• Restore the electrical supply.</li> </ul>
	<ul style="list-style-type: none"> <li>• Motor or control system defect.</li> </ul>	<ul style="list-style-type: none"> <li>• Call an approved service engineer.</li> </ul>


## Troubleshooting Guide

**Warning:** When servicing or replacing any components, be sure the water supply is shut off and the toilet is flushed.

SYMPTOMS	PROBABLE CAUSES	REMEDIES
Rattling sound from pump, no operation	<ul style="list-style-type: none"> <li>• Presence of a foreign object.</li> </ul>	<ul style="list-style-type: none"> <li>• Call an approved service engineer.</li> </ul>
	<ul style="list-style-type: none"> <li>• Issue with motor or control system.</li> </ul>	<ul style="list-style-type: none"> <li>• Contact customer service to replace the product within the warranty period.</li> </ul>
	<ul style="list-style-type: none"> <li>• The pump's overheat protection has been activated.</li> </ul>	<ul style="list-style-type: none"> <li>• Wait about 20 minutes and try again.</li> </ul>
Cloudy water in shower base	<ul style="list-style-type: none"> <li>• The shower is installed lower than the recommended height relative to the macerator pump.</li> </ul>	<ul style="list-style-type: none"> <li>• Check the installation height.</li> </ul>
	<ul style="list-style-type: none"> <li>• The built-in valve on the side water inlet is clogged.</li> </ul>	<ul style="list-style-type: none"> <li>• Clean the side water inlet.</li> <li>• Call an approved service engineer.</li> </ul>
Toilet does not flush	<ul style="list-style-type: none"> <li>• Water supply valve closed.</li> </ul>	<ul style="list-style-type: none"> <li>• Open valve and allow water to fill tank.</li> </ul>
	<ul style="list-style-type: none"> <li>• Supply line blocked.</li> </ul>	<ul style="list-style-type: none"> <li>• Shut off water supply, disconnect supply line and inspect its accessories. Reassemble.</li> </ul>
	<ul style="list-style-type: none"> <li>• Flush valve chain too loose or disconnected.</li> </ul>	<ul style="list-style-type: none"> <li>• Re-adjust chain length as required.</li> </ul>
The water level in the toilet bowl is low	<ul style="list-style-type: none"> <li>• The bowl water level is lower than in traditional toilets due to its design.</li> </ul>	<ul style="list-style-type: none"> <li>• This is normal and does not require any action.</li> </ul>

# Troubleshooting Guide

**Warning:** When servicing or replacing any components, be sure the water supply is shut off and the toilet is flushed.

SYMPTOMS	PROBABLE CAUSES	REMEDIES
Toilet poor flush	<ul style="list-style-type: none"> <li>Tank water level too low.</li> </ul>	<ul style="list-style-type: none"> <li>Adjust the fill valve to raise water level in tank. (Review <b>Step 11</b>. Scan the <b>QR code</b> to watch the steps from 00:49, or refer to <b>Figure 1</b> for reference.)</li> </ul> 
	<ul style="list-style-type: none"> <li>Supply valve partly closed.</li> </ul>	<ul style="list-style-type: none"> <li>Open supply valve fully. Be sure that proper supply tube size is used.</li> </ul>
	<ul style="list-style-type: none"> <li>Partially clogged trapway and/or drain pipe and/or vent.</li> </ul>	<ul style="list-style-type: none"> <li>Remove obstruction. Consult a plumber if necessary.</li> </ul>
	<ul style="list-style-type: none"> <li>Supply pressure too low.</li> </ul>	<ul style="list-style-type: none"> <li>Normal supply pressure must be at least 35 PSI.</li> </ul>
Toilet leaks	<ul style="list-style-type: none"> <li>Poor supply line connection.</li> <li>Poor bowl to tank/wall connection.</li> </ul>	<ul style="list-style-type: none"> <li>Review <b>Step 12</b> of installation procedure.</li> <li>Review <b>Step 10</b> of installation procedure.</li> </ul>
Toilet does not shut off	<ul style="list-style-type: none"> <li>Flapper seal leaking or deformed.</li> <li>Flush valve chain too tight, holding flapper open.</li> </ul>	<ul style="list-style-type: none"> <li>Clean debris from seal surface. Replace flapper seal as needed.</li> <li>Re-adjust chain length as needed. Review <b>Step 11</b>.</li> </ul>



For any queries or concerns, feel free to reach out to us at



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