

OPERATOR'S MANUAL

INCLUDING: OPERATION, INSTALLATION & MAINTENANCE

INCLUDE MANUALS: 6712X-X PUMP (PN 97999-602), 651615-X-D SINGLE POST LIFT / RAM (PN 97999-1025) & S-636
GENERAL INFORMATION (PN 97999-636)

650542-X

650543-X

RELEASED: 3-6-95
REVISED: 2-3-04
(REV. G)

4-1/4" AIR MOTOR
43.6:1 RATIO
4" STROKE

650542-X
CARBON STEEL

650543-1
STAINLESS STEEL

PUMP SYSTEM



**READ THIS MANUAL CAREFULLY BEFORE INSTALLING,
OPERATING OR SERVICING THIS EQUIPMENT.**

It is the responsibility of the employer to place this information in the hands of the operator. Keep for future reference.

SERVICE KITS

- Use only genuine ARO® replacement parts to assure compatible pressure rating and longest service life.
- **61268** for repair of **65440** air motor section. Service Note: The air motor Service / Parts Manual is not shipped with the pump but it is included with each service kit. If this Service / Parts information is needed, request the Air Motor Operator's Manual from ARO (manual 6544X-X, pn 97999-64).
- **104158** for repair of **127112-000** regulator.
- **104176** for repair of **F25241-100** filter.
- **104177** for repair of **R27241-100** regulator.
- **116772** for repair of **E512LM** valve.
- **637290-P43** for repair of **67100-P43** lower pump section.
637291-P43 for repair of **67101-P43** lower pump section.

GENERAL DESCRIPTION

⚠ WARNING DO NOT EXCEED MAXIMUM OPERATING PRESSURE OF 6,549 P.S.I. (451.7 BAR) AT 150 P.S.I. (10.3 BAR) AIR INLET PRESSURE.

⚠ WARNING REFER TO GENERAL INFORMATION MANUAL INCLUDED FOR OPERATING AND SAFETY PRECAUTIONS AND OTHER IMPORTANT INFORMATION.

By delivering a smooth, continuous bead of the proper size, an ARO system helps the operator maintain both his production rate and produce quality standards. Maintained quality standards assure that the material benefits are realized. To further maximize operator production time, the ARO system has a built-in lift / ram feature for quick and easy drum changeover.

ARO systems are totally enclosed, sealing the material in the system from air and moisture, preventing premature cure-out of the material. This allows for either continuous or intermittent use of the system and reduces the need for daily system clean-up.

Built-in lift capability allows for quick drum changeover and easy lifting of pump assembly from container.

The 43.6:1 ratio is an expression of the relationship between the effective air motor area and the effective lower pump area. When 150 p.s.i. (10.3 bar) of air pressure is supplied to the air motor, the lower pump area will develop a maximum of 6,549 p.s.i. (451.7 bar) of fluid pressure (at no flow). As the fluid control is opened, the flow rate will increase as the air motor cycle rate increases to keep up with the demand.

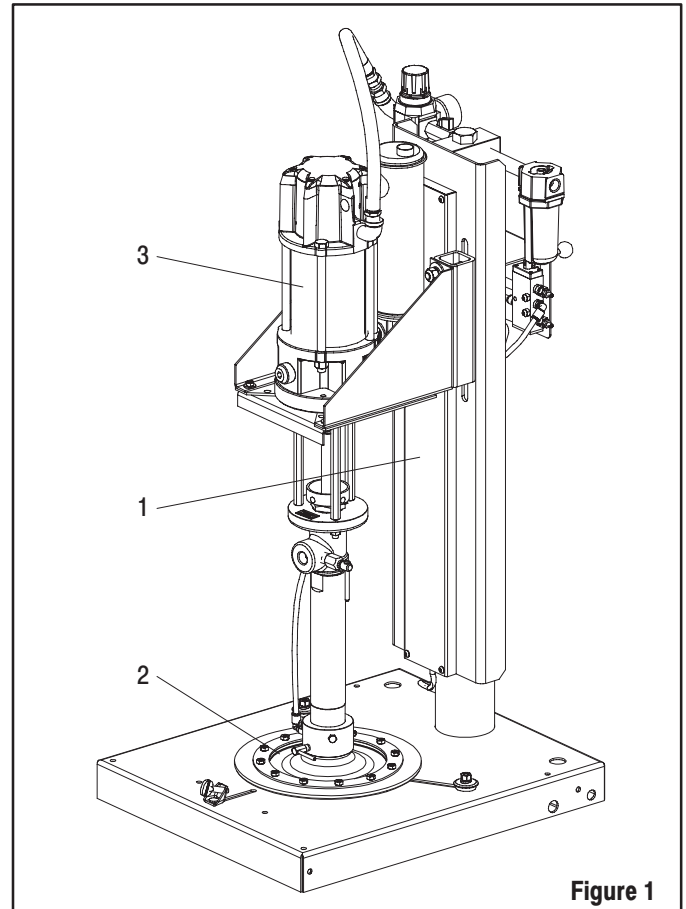


Figure 1

MAJOR COMPONENTS

Item	Description	Qty	Part No.
1	Single Post Ram Assembly	1	651615-D
2	Follower Plate (model 650542-1)	1	651840-1
	(model 650542-2)	1	651840-2
	(model 650543-1)	1	651841-1
3	Basic Pump Ass'y (models 650542-X)	1	67120-P43
	(model 650543-1)	1	67121-P43
	Portability Kit (optional)(not shown)		66713

INSTALLATION

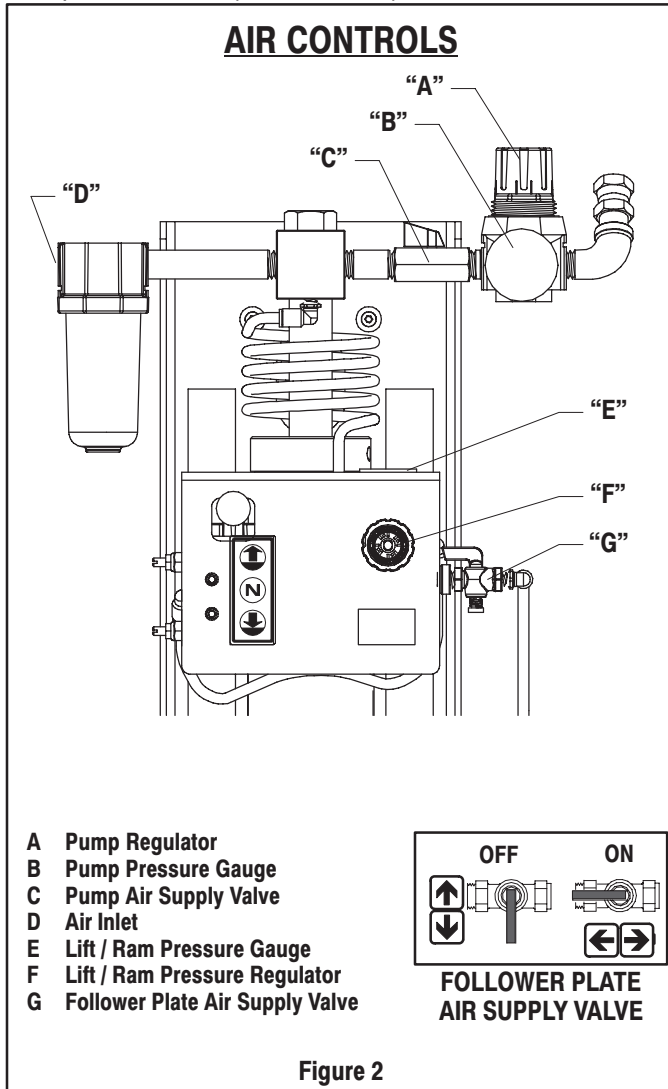
The 65054X-X Chop - Check Dispensing System comes completely assembled. Remove the unit from the crate and place on a level surface. Install material hose and dispensing device as required. When the following instructions are observed, heavy paste materials

can be pumped directly from their original 5 gallon / 25 liter drum without air inclusion or excessive waste. The follower plate creates an air tight seal as well as clean-wiping action in its progressive downward movement into the drum.

OPERATING INSTRUCTIONS

OPERATING INSTRUCTIONS / INITIAL SETUP PROCEDURE

⚠ WARNING STAND CLEAR. When raising or lowering the lift. Read the warning on page 2 of 651615-X-D Single Post Lift / Ram Operator's Manual (PN 97999-1025).



TO RAISE LIFT, (THE FIRST TIME):

1. Take note of the pump / drum clearance above. Be certain the lift / ram is clear of any objects above. Also refer to "Operating and Safety Precautions" found in "Lifts and Rams General Information Manual" (PN 97999-635).
2. Connect the air supply (150 p.s.i. / 10.3 bar maximum) to the air inlet. Adjust air pressure on lift / ram pressure regulator (turn knob clockwise) to 20 p.s.i. (1.4 bar).
3. Shift the control valve lever to the "up" position.
4. Raise the lift / ram high enough to clear the height of the drum. Stop the lift / ram's upward travel by moving the control valve lever to the "neutral" (center) position.

REFER TO PAGE 3:

1. Once the lift / ram assembly and pump are in the "up" position, place and center an opened 5 gallon / 25 liter drum of material on the lift / ram base. Use the stops on the base to center the 5 gallon / 25 liter drum. Tighten thumb screw to secure drum.
2. Lubricate lower follower wiper plate seal with grease. NOTE: Make certain the grease is compatible with the material being dispensed. This ensures a smooth fit into the pail as well as prevents curing type compounds from bonding to seal.
3. Check vent plug on follower plate to be sure it easily threads in and out. It is recommended to lubricate the threads of the plug to help prevent possible set up of compound at this point (see 65184X-X Operator's Manual).

TO LOWER LIFT:

⚠ WARNING PINCH HAZARD. Follower can descend quickly causing injury. Keep hands clear when aligning with container.

NOTE: Be certain the follower plate vent plug has been removed so that the air trapped between the follower and the material is allowed to escape from this vent. Captured air between the follower plate and drum will escape.

NOTE: The lift / ram may hesitate momentarily before starting downward, the air pressure inside the post air chamber must decrease before it will begin to descend.

1. Shift the control valve lever to the "down" position and proceed to lower the pump.
2. Replace the vent plug once the material begins to ooze from the vent opening.
3. The unit is now ready for operation. Adjust the air pressure on the pump filter / regulator (turn pump regulator knob clockwise) until the pump begins to cycle.
4. Trigger gun to prime pump with material.

TO RAISE LIFT, (NORMAL OPERATION):

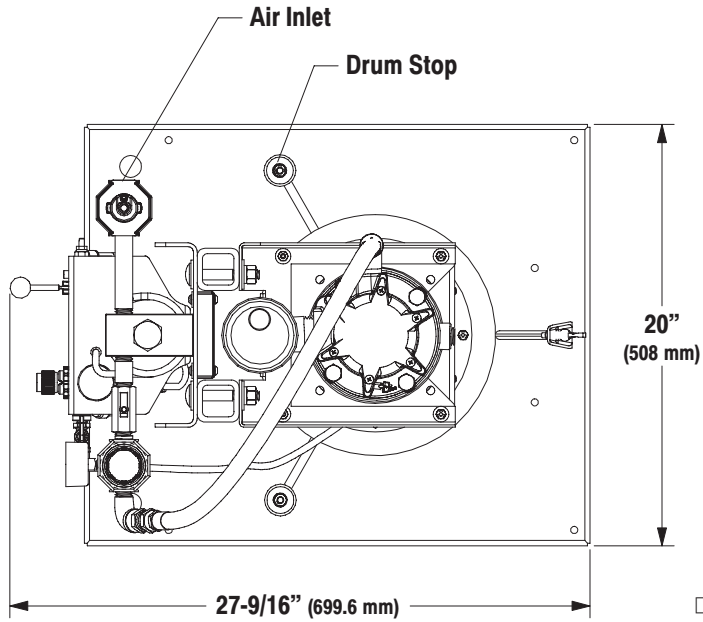
1. Adjust the follower plate air valve pressure up to approximately 8 p.s.i.g. (0.55 bar). DO NO OVERPRESSURIZE THE DRUM to avoid damage. NOTE: Air from this valve will only pass when the control valve lever is in the "up" position.
2. Shift the control valve lever to the "up" position.
3. Raise the lift / ram high enough to clear the height of the drum. Stop the lift / ram's upward travel by moving the control valve lever to the "neutral" (center) position.

TO CHANGE DRUM:

NOTE: The control lever should be in the "neutral" position.

1. Unscrew thumb screw and remove old 5 gallon / 25 liter drum.
2. Place and center a new drum into position. Remove cover. Tighten thumb screw.

65054X-X PARTS LIST



□ Included in 651615-D Single Post Ram Assembly.

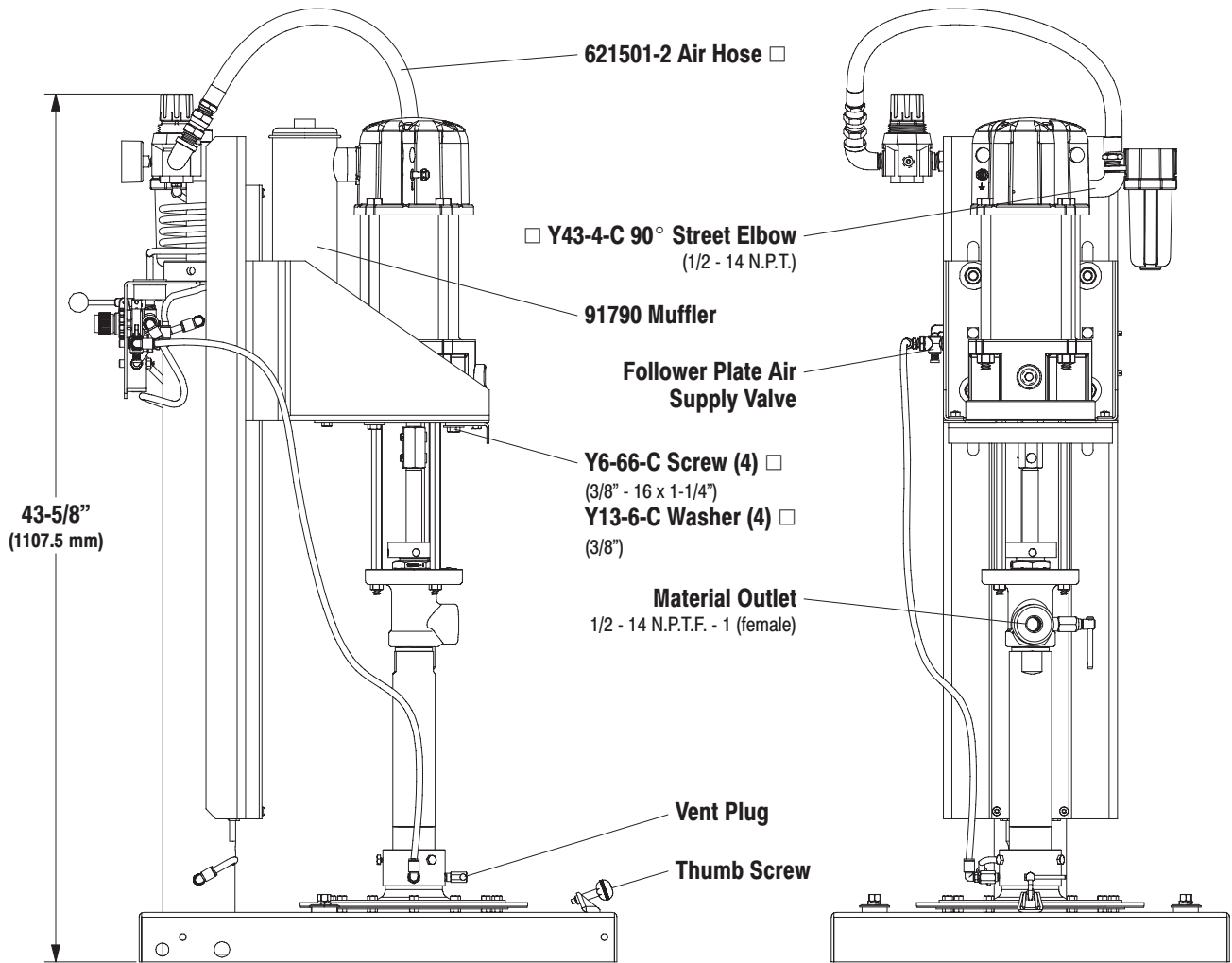


Figure 3

