

# OPERATOR'S MANUAL

# 650967-X-B

SPECIFICATIONS, SERVICE KITS, GENERAL INFORMATION, TROUBLESHOOTING

INCLUDE MANUALS: 6694X-X LOWER PUMP END (PN 97999-12) &  
S-632 GENERAL INFORMATION MANUAL (PN 97999-624)

RELEASED: 1-14-00

REVISED: 7-26-02

(REV. B)

**12" AIR MOTOR**  
**23:1 RATIO**  
**6" STROKE**

## 650967-XXD-B

### TWO BALL PUMP SERIES

400 SERIES STAINLESS STEEL



**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.
- **637112 for repair of 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 66506-B, PN 97999-870).
- **637211-XX3 for repair of Lower Pump section.**  
Refer to the chart on page 2 for description of -XXD options.

### SPECIFICATIONS

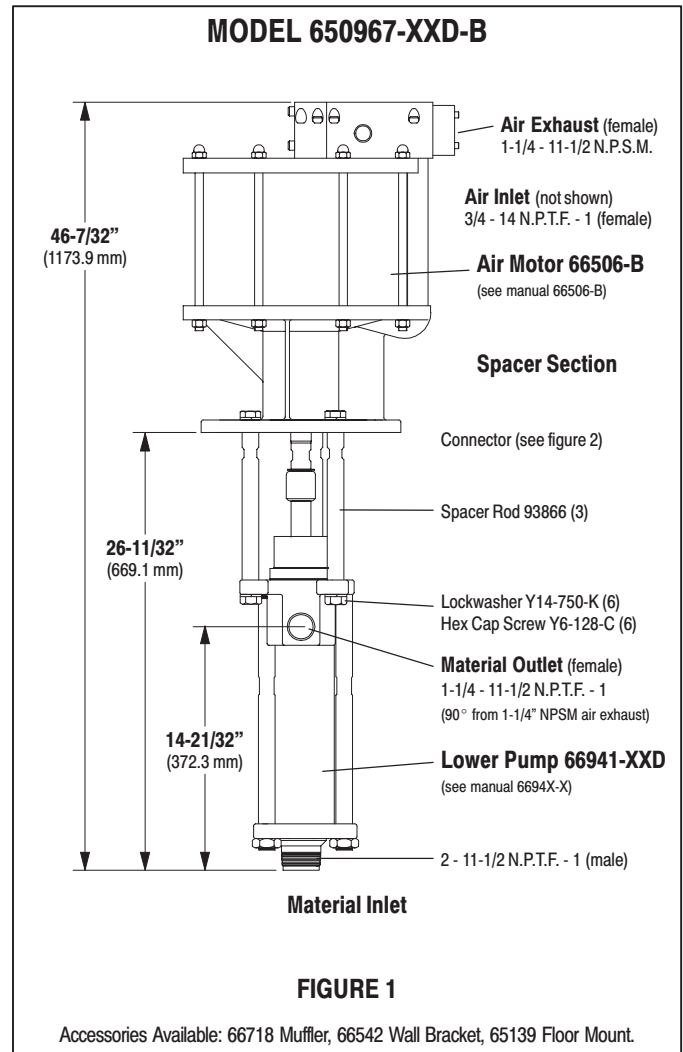
<b>Model Series</b> (refer to option chart)	650967-XXD-B
<b>Type</b>	Air Operated, Two Ball Double Acting Pump
<b>Ratio</b>	23:1
<b>Air Motor</b>	66506-B
<b>Motor Repair Kit</b>	637112
<b>Motor Diameter</b>	12" (30.5 cm)
<b>Stroke</b>	6" (15.2 cm)
<b>Air Inlet (female)</b>	3/4 - 14 N.P.T.F. - 1
<b>Air Exhaust (female)</b>	1-1/4 - 11-1/2 N.P.S.M.
<b>Lower Pump End Series</b>	66941-XXD
<b>Lower Pump Repair Kit</b>	637211-X63
<b>Material Inlet (male)</b>	2 - 11-1/2 N.P.T.F. - 1
<b>Material Outlet (female)</b>	1-1/4 - 11-1/2 N.P.T.F. - 1
<b>Weight</b>	140 lbs (63.5 kgs)

### PERFORMANCE

<b>Air Inlet Pressure Range</b>	30 - 90 p.s.i. (2.1 - 6.2 bar)
<b>Fluid Pressure Range</b>	690 - 2070 p.s.i. (47.6 - 142.8 bar)
<b>Maximum Rec'd Cycles / Minute</b>	70
<b>Displacement In<sup>3</sup> Per Cycle</b>	59.8
<b>Volume / Cycle</b>	33.1 oz. (979.6 ml)
<b>Cycles Per Gallon</b>	3.9
<b>Flow @ 70 Cycles / Minute</b>	18.1 g.p.m. (68.6 l.p.m.)
<b>Noise Level @ 60 p.s.i. - 40 c.p.m.</b>	89.8 db(A) *

\* The pump sound pressure level has been updated to an Equivalent Continuous Sound Level ( $L_{Aeq}$ ) to meet the intent of ANSI S1.13-1971, CAGI-PNEUROP S5.1 using four microphone locations.

### PUMP DATA



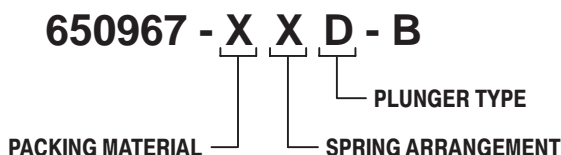
### IMPORTANT

**This is one of the four documents which support the pump. Replacement copies of these forms are available upon request.**

- 650967-X-B MODEL OPERATOR'S MANUAL
- GENERAL INFORMATION - INDUSTRIAL PISTON PUMPS
- 6694X-X LOWER PUMP END OPERATOR'S MANUAL
- 66506-B AIR MOTOR OPERATOR'S MANUAL



# PUMP OPTION DESCRIPTION CHART



### PACKING MATERIAL (PACKINGS ARE UPPER AND LOWER UNLESS NOTED)

C UHMW-PE	P UHMW-PE / Teflon staggered (upper)
K Carbon-Graphite filled Teflon	UHMW-PE (lower)
L Mineral filled Teflon	R Teflon / UHMW-PE staggered (upper)
	Mineral filled Teflon (lower)

### SPRING ARRANGEMENT

6 Wave Spring
D Wave Spring with Alternate Seat Material

### PLUNGER TYPE

D Hardened Stainless Steel with hard Chrome Plating
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## GENERAL DESCRIPTION

**⚠ WARNING HAZARDOUS PRESSURE.** Do not exceed maximum operating pressure of 2070 p.s.i. (142.8 bar) at 90 p.s.i. (6.2 bar) inlet air pressure.

$$\text{PUMP RATIO X} = \frac{\text{MAXIMUM PUMP FLUID PRESSURE}}{\text{INLET PRESSURE TO PUMP MOTOR}}$$

Pump ratio is an expression of the relationship between the pump motor area and the lower pump end area. EXAMPLE: When 90 p.s.i. (6.2 bar) inlet pressure is supplied to the motor of a 5:1 ratio pump it will develop a maximum of 450 p.s.i. (31.0 bar) fluid pressure (at no flow) – as the fluid control is opened, the flow rate will increase as the motor cycle rate increases to keep up with the demand.

**⚠ WARNING** Refer to general information sheet for additional safety precautions and important information.

- The Two-Ball pumps are primarily designed for the high volume transfer of light and medium viscosity fluids. Stainless Steel construction offers compatibility with a wide range of fluids. The lower pump is designed for easy priming and the double acting feature is standard in all ARO industrial pumps. Material is delivered to the pump discharge outlet on both the up and down stroke.
- The motor is connected to the lower pump end by a spacer section. This allows for lubrication of the upper packing gland and prevents motor contamination because of normal wear and eventual leakage through the material packing gland. Be sure the solvent cup is adequately filled with lubricant to protect the upper packings and insure longest service life.

## TROUBLE SHOOTING

Pump problems can occur in either the Air Motor Section or the Lower Pump End Section. Use these basic guidelines to help determine which section is affected.

### If the pump will not cycle.

- Be certain to first check for non-pump problems including kinked, restrictive or plugged inlet / outlet hose or dispensing device. Depressurize the pump system and clean out any obstructions in the inlet / outlet material lines.
- Refer to the motor manual for trouble shooting if the pump does not cycle and / or air leaks from the air motor.

### If the pump cycles but does not deliver material.

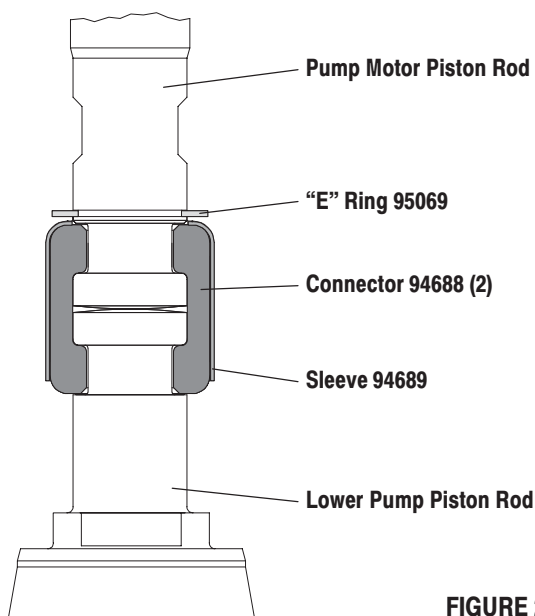
- Refer to the lower pump end manual for further trouble shooting.

## PUMP CONNECTION - UPPER / LOWER

**NOTE: All threads are right hand.**

1. Lay the pump assembly on a workbench.
2. Remove the three (Y6-128-C) cap screws and (Y14-750-K) lock washers from the three spacer rods (figure 1).
3. Pull the air motor from the lower pump end until motor piston rod is in the “down” position and lower pump end rod is in “up” position.
4. Remove the three spacer rods by removing the three (Y6-128-C) cap screws and (Y14-750-K) lock washers.
5. Using e-ring pliers, slide the “e” ring up far enough to allow the sleeve to move upward and release the two connectors (figure 2).

### PUMP CONNECTOR DETAIL



**FIGURE 2**

### REASSEMBLY

1. Align the pump motor with the lower pump end. Position the air inlet of the motor 180° from the material outlet.
2. Install the two connectors and retain with the sleeve, slide the “e” ring back into position.
3. Assemble the three spacer rods to the lower pump and secure using three (Y14-750-K) lock washers and (Y6-128-C) cap screws.
4. Reinstall the spacer rods to the pump motor.
5. Bring the motor and lower pump together and retain with three (Y14-750-K) lock washers and (Y6-128-C) cap screws.