

OPERATOR'S MANUAL

650971-X-B

INCLUDING: SERVICE KITS, GENERAL DESCRIPTION & TROUBLESHOOTING
ALSO INCLUDE MANUALS: 66506 AIR MOTOR, 66236-X-B LOWER PUMP, FORM 3637-2
GENERAL INFORMATION SHEET.

RELEASED: 05-25-92
REVISED: 6-9-10
(REV. C) IPP

EXTRUSION PUMP (CARBON STEEL)

12" AIR MOTOR
30:1 RATIO
6" STROKE

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

(PACKINGS ARE UPPER AND LOWER UNLESS NOTED)

PACKING MATERIAL

- 1 THIKOL LEATHER
- 3 GLASS FILLED PTFE
- 5 PTFE (GF) / LEATHER STG'D (UPPER)
GLASS FILLED PTFE LOWER)
- 9 (G/F) PTFE / LEATHER STG'D
- A UHMW-PE (UPPER)
LEATHER (LOWER)
- B UHMW-PE (UPPER)
PTFE (LOWER)
- C UHMW-PE
- D UHMW-PE / LEATHER STG'D (UPPER)
LEATHER (LOWER)

PACKING MATERIAL

- E UHMW-PE / LEATHER STG'D (UPPER)
PTFE (LOWER)
- F UHMW-PE / LEATHER STG'D (UPPER)
UHMW-PE (LOWER)
- J POLYURETHANE (UPPER)
UHMW-PE (LOWER)
- N LEATHER (UPPER)
PTFE (LOWER)
- P UHMW-PE / PTFE STG'D (UPPER)
UHMW-PE (LOWER)
- R PTFE / UHMW-PE STG'D (UPPER)
PTFE (LOWER)

PUMP OPTION DESCRIPTION CHART 650971-XXX-B



- SPRING ARRANGEMENT
- 3 NO SPRING
 - 4 MULTIPLE WAVE SPRING

- PLUNGER TYPE
- 4 CS HD CHROME PLATING

SERVICE KITS

- Use only genuine ARO® replacement parts to assure compatible pressure rating and longest service life.
- 637112 for general repair of the Air Motor section.
- 637128-XXX-B for general repair of the 66236-XXX-B Extrusion (Chop-Check) Lower Pump End.

GENERAL DESCRIPTION

⚠ WARNING HAZARDOUS PRESSURE. Do not exceed maximum operating pressure of 3,250 psi (224 bar) at 90 psi (6.3 bar) inlet air pressure.

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

- This MODEL MANUAL is one of four documents needed to properly support an ARO pump model. Ref: Part A. 650XXX-XXX-X MODEL (OPERATOR'S) MANUAL, Part B. GENERAL INFORMATION, Part C. AIR MOTOR (OPERATOR'S) MANUAL, Part D. LOWER PUMP END (OPERATOR'S) MANUAL. These forms are available from the factory if needed.
- The Extrusion (Chop-Check) pumps are primarily designed for the pumping of heavy viscous material with or without fibrous content. The models can be used with a gravity feed single post lift as a topper type assembly or with a two post lift as a force feed type assembly. 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.

PUMP DATA

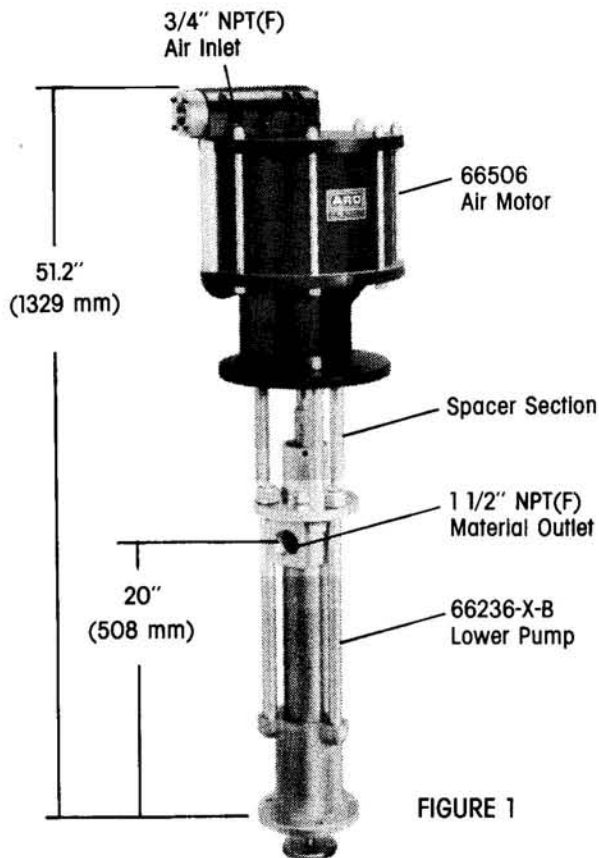


FIGURE 1

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PUMP DISASSEMBLY

Refer to Figure 2

1. Lay the pump assembly on a workbench.
2. Remove the three (C) nuts from the three (D) spacer rods.
3. Pull the air motor from the lower pump end until air motor piston rod is on "down" position and lower pump end rod is in "up" position.
4. Remove the three (D) spacer rods by unscrewing three (E) cap screws.
5. Remove the two (B) cotter pins from the (A) adapter.
6. Unscrew the (A) adapter from the air motor.

PUMP ASSEMBLY

NOTE: All threads are right hand.

1. Align Lower End Pump Rod with Air Motor Piston rod. Position air inlet of motor 180° from material outlet of pump.
2. Screw (A) adapter onto air motor piston rod and secure using (B) cotter pin. Screw other end of (A) adapter to lower pump plunger rod and secure using (B) cotter pin.
3. Secure the three (D) spacer rods onto the lower pump using three (E) cap screws.
4. Push air motor and lower pump end together so (D) spacer rods slide thru holes located in air motor base.
5. Secure air motor to lower pump end using three (C) nuts.

TROUBLE SHOOTING

• PROBLEM

__Cause, solution.

• Pump will not cycle.

- __No pressure to motor, See motor manual.
- __Restricted return lines, clean obstruction.
- __Damaged motor, service motor.

__Be sure to eliminate any possible non-pump problems before suspecting pump malfunction and continuing.

- Pump problems will typically occur in one of two areas:
 1. The Air Motor Section.
 2. The Lower Pump Section.

__Determine which section is affected.

SPACER SECTION

REF	PART NO.	DESCRIPTION
A	79176	ADAPTER
B	Y15-46-S (2)	COTTER PIN
C	Y108-8-Z (3)	HEX HEAD NUT
D	79179 (3)	SPACER ROD
E	79186 (3)	CAP SCREW

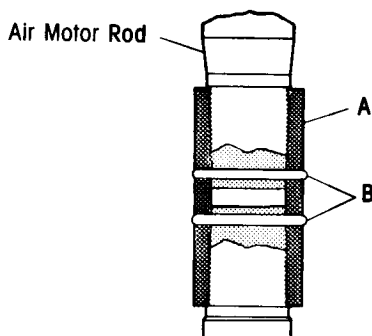
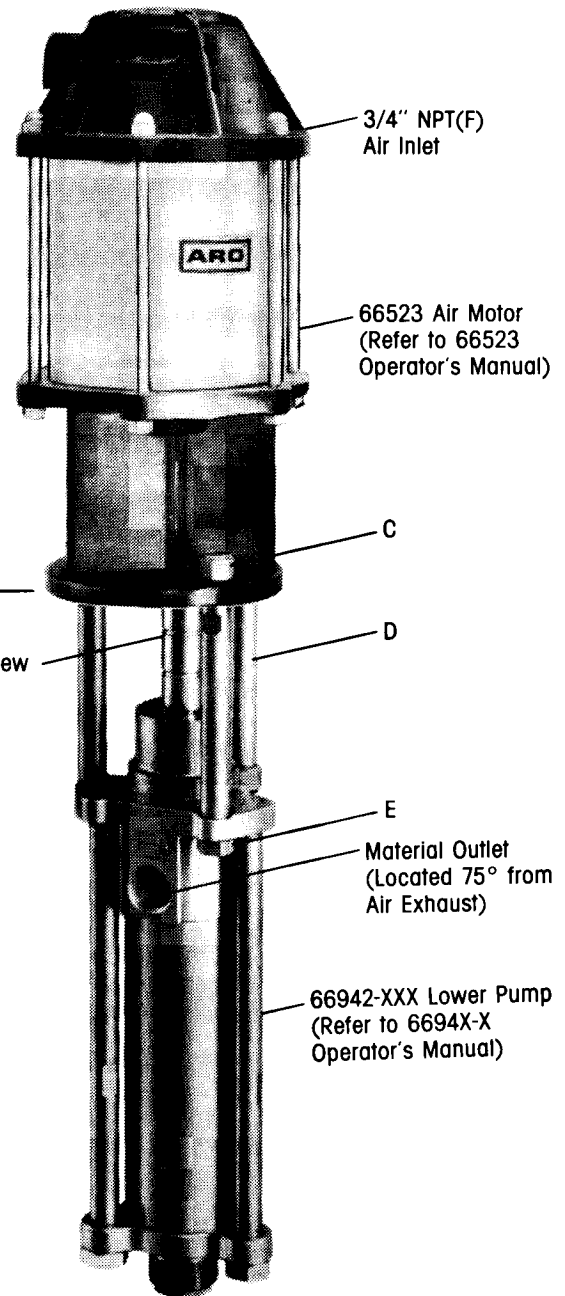


FIGURE 2



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