

OPERATOR'S MANUAL

650871-X-B

INCLUDING: SERVICE KITS, GENERAL DESCRIPTION & TROUBLESHOOTING
ALSO INCLUDE MANUALS: 66523 AIR MOTOR, 66236-X-B LOWER PUMP, FORM 3637-2
GENERAL INFORMATION SHEET.

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

8" AIR MOTOR
13:1 RATIO
6" STROKE

EXTRUSION PUMP (CARBON STEEL)

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

(PACKINGS ARE UPPER AND LOWER UNLESS NOTED)

PACKING MATERIAL

- 1 THIOLKOL LEATHER
- 3 GLASS FILLED PTFE
- 4 BUNA "N"
- 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 650871-XXX-B

PACKING MATERIAL

PLUNGER TYPE

SPRING ARRANGEMENT

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.
- 66614 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 1,900 psi (133 bar) at 120 psi (8.3 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

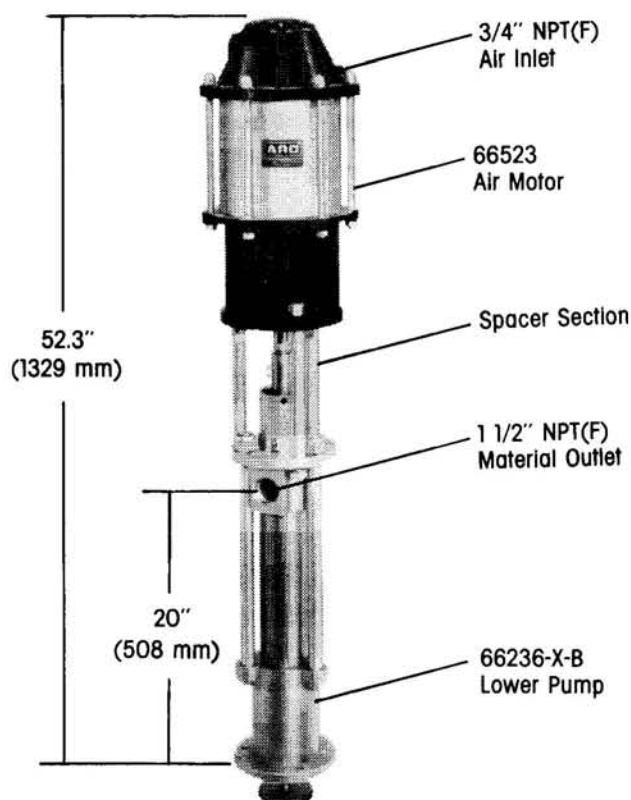


FIGURE 1

INGERSOLL RAND COMPANY LTD

209 NORTH MAIN STREET - BRYAN, OHIO 43506

☎ (800) 495-0276 • FAX(800) 892-6276

www.ingersollrandproducts.com

© 2010

ARO

IR Ingersoll Rand
Industrial Technologies

PUMP DISASSEMBLY

Refer to Figure 2

1. Lay the pump assembly on a workbench.
2. Unscrew the top three (103) cap screws and (110) lockwashers from the three (102) 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 (102) spacer rods by unscrewing three (103) cap screws and (110) lockwashers.
5. Remove the two (107) cotter pins from the (104) adapter.
6. Unscrew the (104) adapter from the air motor.

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.

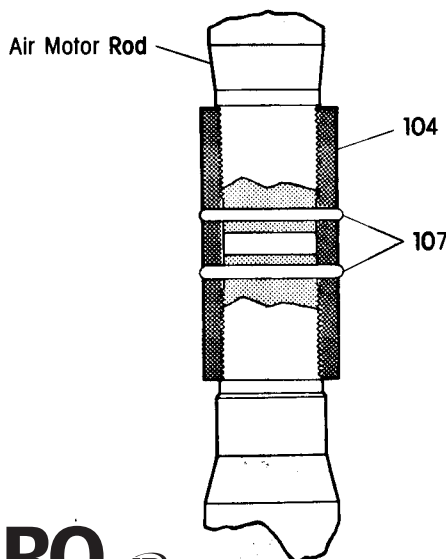
• Pump problems will typically occur in one of two areas:

1. The Air Motor Section.
2. The Lower Pump Section.

___Determine which section is affected.

SPACER SECTION

REF	PART NO.	DESCRIPTION
101	66523	AIR MOTOR
102	93866 (3)	SPACER ROD
103	Y6-128-C (6)	CAP SCREW
104	92226	ADAPTER
107	Y15-46-C (2)	COTTER PIN
110	Y14-750-K (6)	LOCKWASHER



PUMP ASSEMBLY

Refer to Figure 2

1. Align Lower End Pump Rod with Air Motor Piston rod. Position air inlet of motor 90° from material outlet of pump.
2. Screw (104) adapter onto air motor piston rod and secure using (107) cotter pin. Screw other end of (104) adapter to lower pump plunger rod and secure using (107) cotter pin.
3. Thread the three (102) spacer rods onto the lower pump using three (110) lockwashers and (103) cap screws.
4. Push air motor and lower pump end together so (102) spacer rods align with the holes located in air motor base.
5. Secure air motor to lower pump end using three (110) lockwashers and (103) cap screws.

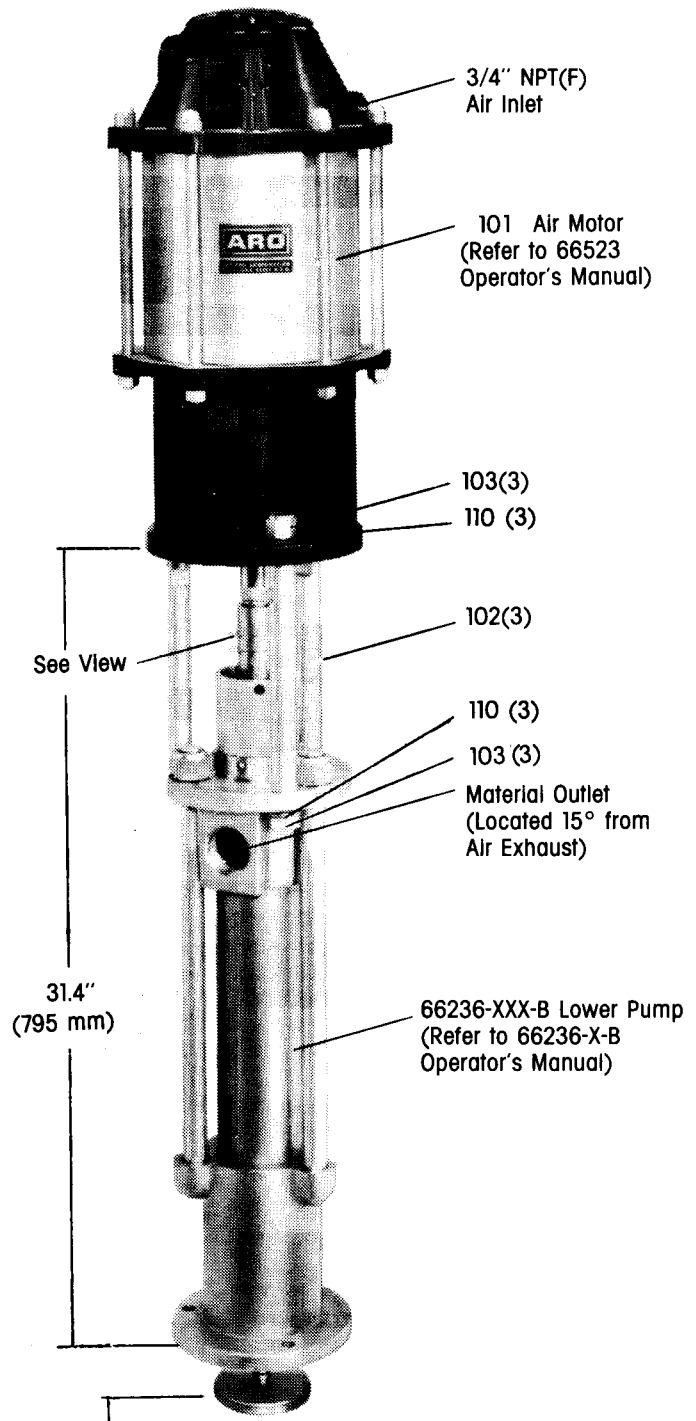


FIGURE 2