

OPERATOR'S MANUAL

650918-X-X

SPECIFICATIONS, SERVICE KITS, GENERAL INFORMATION, TROUBLESHOOTING
INCLUDE MANUALS: 67319-X LOWER PUMP END (PN 97999-1073) & 67343 AIR MOTOR (PN 97999-1072).

RELEASED: 10-1-03
REVISED: 6-1-10
(REV. 03)

2" AIR MOTOR
2:1 RATIO
3" STROKE

650918-X1-X31 TWO-BALL PUMP SERIES CARBON 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.
- **637399** for repair of air motor section.
- **637398-X31** for repair of 67319-X31 and 67320-X31 lower pump ends.

SPECIFICATIONS

Model Series (refer to option chart)	650918-X1-X31
Type	Air Operated, Two-ball
Ratio	2:1
Air Motor	67343
Motor Repair Kit	637399
Motor Diameter	2" (5.08 cm)
Stroke (Double Acting)	3" (7.62 cm)
Air Inlet (female)	1/4 - 18 N.P.T.F. - 1
Lower Pump End Series	
650918-11-B31	67320-B31
650918-41-B31	67319-B31
650918-41-C31	67319-C31
Lower Pump Repair Kit	637398-X31
Material Inlet	
650918-11-X31 (female)	1-1/2 - 11-1/2 N.P.T.F.
650918-41-X31	immersed
Material Outlet (female)	3/4 - 14 N.P.T.F.
Weight	See chart

PERFORMANCE

Air Inlet Pressure Range	0 - 150 p.s.i. (0 - 10.3 bar)
Fluid Pressure Range	0 - 351 p.s.i. (0 - 24.2 bar)
Maximum Rec'd Cycles / Minute	120
Displacement In.³ Per Cycle	8.28
Volume / Cycle	4.59 oz. (135.6 ml)
Cycles Per Gallon	27.9
Flow @ 60 Cycles / Minute	2.15 g.p.m. (8.14 l.p.m.)
Noise Level @ 100 p.s.i.	80 db(A) *
Accessories Available	61113 Wall Mount Bracket 66073-1 Air Line Connection Kit

* 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

MODEL 650918-X1-X31

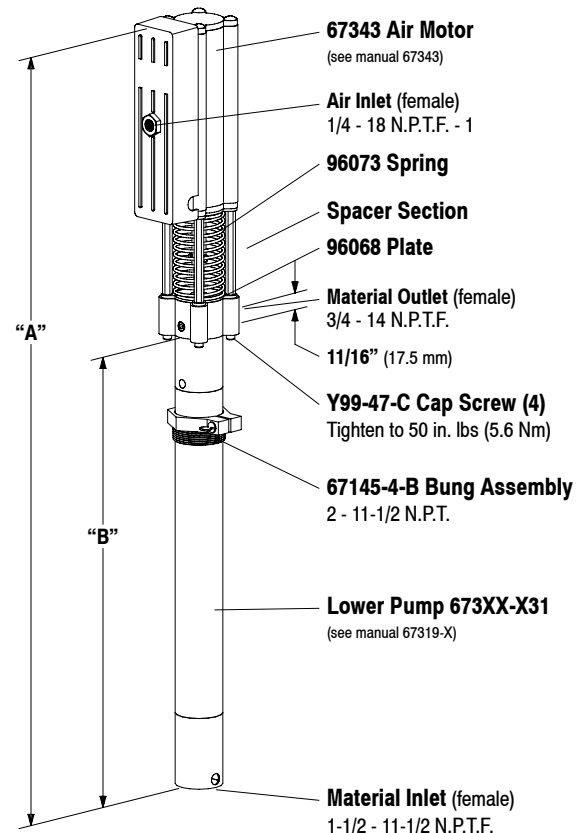


Figure 1

NOTE: Dimensions are shown in inches and (mm), supplied for reference only and are typically rounded up to the nearest 1/16 inch.

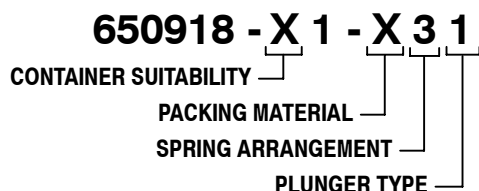
Model Number	"A" (mm)	"B" (mm)	Weight (kg)
650918-11-X31	34-3/16" (868.0 mm)	20-1/16" (508.8 mm)	17.5 lbs (7.9)
650918-41-X31	47-7/8" (1214.8 mm)	33-11/16" (855.6 mm)	19.6 lbs (8.9)

IMPORTANT

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

- ☒ 650918-X-X Model Operator's Manual (pn 97999-1071)
- ☐ 67319-X Lower Pump End Operator's Manual (pn 97999-1073)
- ☐ 67343 Air Motor Operator's Manual (pn 97999-1072)

PUMP OPTION DESCRIPTION CHART



CONTAINER SUITABILITY

- 1 - Universal (Stub)
- 4 - 55 Gallon

PACKING MATERIAL

- 7 - PTFE (upper and lower)
- B - UHMW-PE (upper) / PTFE (lower)
- C - UHMW-PE (upper and lower)
- J - Polyurethane (upper) / UHMW-PE (lower)

SPRING ARRANGEMENT

- 3 - No Spring

PLUNGER TYPE

- 1 - Standard (Carbon steel)

GENERAL DESCRIPTION

Model 650918-X-X Series two-ball, double acting pumps are intended to be used primarily for oil transfer and delivery systems. It is best to use this pump with low - medium viscosity fluids. It uses carbon steel and other materials which make it compatible with most petroleum based lubrication products. The two-ball design provides better priming of the lower foot valve. Double acting pumps will deliver material on both the up and down stroke.

NOTE: If this pump was purchased separately (not part of a system), consult your sales representative for compatible dispensing accessories which will best match the application. All accessories must be able to withstand the maximum pressure developed by the pump.

⚠ WARNING HAZARDOUS PRESSURE. Do not exceed maximum operating pressure of 351 p.s.i. (24.2 bar) at 150 p.s.i. (10.3 bar) inlet air pressure.

**PUMP RATIO X
INLET PRESSURE TO PUMP MOTOR = MAXIMUM PUMP
FLUID PRESSURE**

Pump ratio is an expression of the relationship between the pump motor area and the lower pump end area. EXAMPLE: When 150 p.s.i. (10.3 bar) inlet pressure is supplied to the motor of a 4:1 ratio pump it will develop a maximum of 600 p.s.i. (41.4 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.

NOTICE: Thermal expansion can occur when the fluid in the material lines is exposed to elevated temperatures. Example: Material lines located in a non-insulated roof area can warm due to sunlight. Install a pressure relief valve in the pumping system.

Replacement warning label (pn 94520) is available upon request.

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. Be sure to eliminate any possible non-pump problems before suspecting pump malfunction.

Pump will not cycle.

- No pressure to the motor. See motor manual.
- Damaged motor. Service motor

No material at the outlet (pump continually cycles).

- Check the material supply, disconnect or shut off the air supply and replenish the material, reconnect.

Material on one stroke only (fast downstroke).

- The lower check may not be seating in the foot valve (see lower pump disassembly). Remove the check from the foot valve, clean and inspect the valve seat area. If check or foot valve are damaged, replace.

Material on one stroke only (fast upstroke).

- The middle packings may be worn (see lower pump disassembly). Replace the seals as necessary.

PUMP CONNECTION - UPPER / LOWER

NOTE: All threads are right hand.

1. Lay the pump assembly on a workbench.
2. Remove four (Y99-47-C) cap screws and pull the air motor from the lower pump end until the motor piston rod is in the "down" position and the lower pump end rod is in the "up" position.
3. Remove the (Y15-31-C) cotter pin and (96064) pin, releasing the air motor from the lower pump end.

PUMP CONNECTOR DETAIL

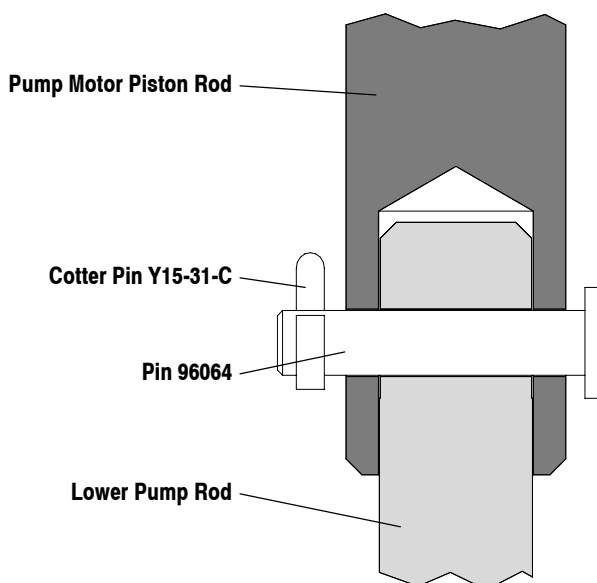


Figure 2

REASSEMBLY

1. Assemble motor piston rod to the lower pump end rod, aligning thru holes.
2. Assemble (96064) pin through hole, securing rods.
3. Assemble (Y15-31-C) cotter pin through hole in pin.
4. Align tie rods with holes in (96068) plate and pump outlet body.
5. Assemble four (Y99-47-C) cap screws, securing air motor. NOTE: Tighten cap screws to 50 in. lbs (5.65 Nm).