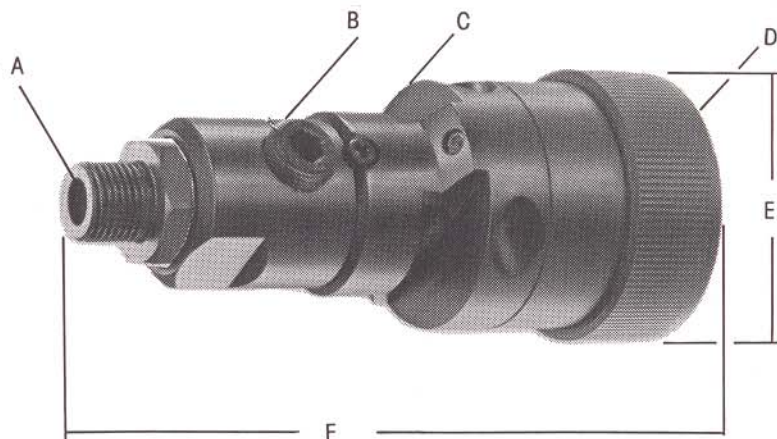


AUTOMATIC VALVE ASSEMBLY

651537-X

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



GENERAL DESCRIPTION

651537-1 Non-Adjustable Stroke
651537-2 Non-Adjustable Stroke w/Indicator

Automatic Valve with the following features.

- The ball and valve seat are made of tungsten carbide for maximum resistance to erosion and wear.
- The (3) 90565 packings are made of PTFE for maximum wear and resistance to solvents.
- This unit has a 2" diameter air cylinder. The 72842 piston is made of Buna "N".
- It has a 1/2" mounting hole.
- Both air inlets are 1/8" N.P.T.F. (female).
- Air operated opening and closing.

MAINTENANCE

With proper care this unit will give long reliable service. To maintain this performance, it should be "flushed thoroughly" with solvent immediately following each application period if equipment is to be idle for a long period of time.

- If material leakage occurs between valve housing (30) and body (24), check gasket (29).
- If material leakage occurs at orifice of gun, check ball and ball seat for dirt or foreign substance. Inspect ball and ball seat (28).
- If material leakage occurs around piston rod (26) in opening of air cylinder head (18) check tightness of retainer (20) or worn packings (22).
- If air leakage occurs around the air cylinder, check for damaged or worn "O" rings. (Indicated on the drawing (17), (16), and (9)).

SPECIFICATION DATA

REF.

- A Material Outlet 3/8-18 NPTF
- B Material inlet (2) 3/8" PTF
- C Air inlet 1/8" NPTF (Return or "Closing")
- D Air inlet 1/8" NPTF (Actuating)
- E Width Dia. 2 1/2" (63.5 mm)
- F Overall Length Approx. 7 5/16" (186 mm)

OPERATING PRECAUTIONS

- Use ARO replacement parts to assure compatible pressure rating.
- HEED ALL WARNINGS.
- WARNING: HIGH PRESSURE DEVICE. Improper usage of this equipment could result in serious injury. The possibility of injection into the flesh is a potential hazard. Never allow any part of the human body to come in front of or in direct contact with the material outlet. An injection injury can be serious. If injection should occur, contact a qualified physician for immediate treatment of such injuries.
- SERVICING. Before servicing or removing fluid hose or valve from a unit that has been used be sure to disconnect air lines and carefully bleed pressure off of the system.
- PREVENT FIRES. When pumping, flushing or recirculating volatile solvents, the area must be adequately ventilated.
- Keep solvents away from heat, sparks and open flames. Keep containers closed when not in use.

CAUTION: The maximum working pressure for the Automatic Dispensing Valve assembly is 5000 p.s.i. (pounds per square inch) (345 Bar).

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PARTS LIST

REF	DESCRIPTION	QTY
1	Nut	Y85-25-C
2	"O" Ring (1/2" O.D.)	Y325-12
3	Shaft	93170
4	Spring	76494
5	Nut	93169
6	Indicator ASM (Model 651537-2)	66777
7	Pipe Plug (Model 651537-1)	Y17-52
8	Cap	90995
9	"O" Ring (2 5/16" O.D.)	Y325-138
10	Piston Retainer	90555
11	Piston Washer	90586
12	Air Cylinder	90556
13	Piston	72842
14	Piston Washer	90559
15	Retaining Screw	90562
16	"O" Ring (3/8" O.D.)	Y325-10
17	"O" Ring (2 1/16" O.D.)	Y325-134
18	Air Cylinder Head	90994
19	Set Screw	Y29-43-C
20	Retainer	79255
21	Washer	F174-9
22	Packing (PTFE) (3 Req'd.)	90565
23	Washer	F15-64
24	Spray Gun Body	92891
25	Screw	Y191-82
26	Piston Rod	90558
27	Pin	Y178-36
28	Ball and Socket Asm	65774
29	Gasket	72851
30	Valve Seat Asm	66778

Included But Not Shown - Wrench 93140

DISASSEMBLY/REASSEMBLY

If it becomes necessary to disassemble this unit proceed in the following manner.

1. Place gun in vise, holding at air cylinder head (18).
2. Unscrew indicator assembly (6).
3. Unscrew Cap (8).
4. Unscrew valve housing assembly (30).
5. The ball and socket assembly (28) will now be exposed. The piston retainer (10) will be exposed. By putting a wrench on the flats of the ball & socket (28) and on the hex of the piston retainer (10) you can unscrew the piston retainer (10).
6. Remove piston washer (11) piston (13) and piston washer (14).
7. Push piston rod (26) forward (towards spray tip end of gun), this will remove the piston rod (26) roll pin (27) and ball and socket (28).
8. Unscrew retaining screw from air cylinder head (18) and check "O" Ring (16).
9. Unscrew set screw (25) from spray gun body (24).
10. Unscrew spray gun body (24) from air cylinder head (18), this will allow you to unscrew retainer (20) from spray gun body (24) and inspect washer (21) packings (22) and washer (23).
11. Reverse above procedure for assembly.

