

# OPERATOR'S MANUAL

# HDD265S5XXXXXXX

INCLUDING: OPERATION, INSTALLATION AND MAINTENANCE.

INCLUDE MANUALS: AF1265SXXXXXX Extrusion Pump (97999-1528), RM552X-XXX-XX Two Post Lift / Ram (pn 97999-1445), & S-636 General Information (pn 97999-636).

RELEASED: 5-28-13  
(REV. A)

**12" AIR MOTOR**  
**65:1 RATIO**  
**6" STROKE**

## HEAVY DUTY TWO POST RAM PACKAGE 55 GALLON



**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.
- **637489** for repair of air motor section.
- **104468** for repair of filter section of P39124 -100 filter / regulator.
- **104302** for repair of regulator section of P39124-100 filter / regulator.
- **104326** for repair of filter section of P39344 -100 filter/regulator.
- **104327** for repair of regulator section of P39344 -100 filter/regulator.
- **637472** for repair of lift / ram seals.
- **637348-XXD** for repair of 67300-XXX lower pump end.

### MODEL DESCRIPTION CHART

HD D2 65 S 5 XXXXX XX X	
<b>Package</b> HD - Heavy Duty	
<b>Air Motor Size</b> D2 - 12"	
<b>Pump Ratio</b> 65 - 65:1	
<b>Check Type / Wetted Materials</b> S - Chop Check / Carbon Steel	
<b>Mount Style</b> 5 - 55 gallon (400 lbs)	
<b>Lower Pump End Options</b> Refer to pump model operator's manual	
<b>Follower Assembly</b>	
AC - 66517	AN - 67196-2
AA - 66517-1	AV - 67196-3
AB - 66517-2	TM - 67196-5
TC - 66517-5	TN - 67196-6
TA - 66517-6	TV - 67196-7
TB - 66517-7	AS - 67196-8
AM- 67196-1	TS - 67196-9
<b>Package Option</b>	
0 - None	
2 - Advanced Ram and Pump Controls	

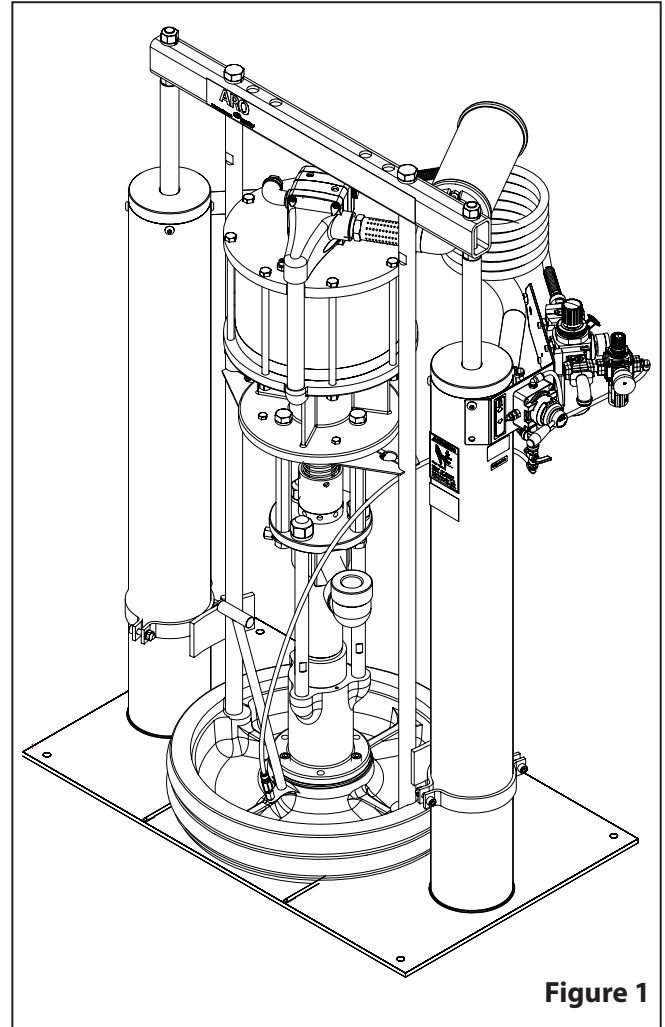


Figure 1

### GENERAL DESCRIPTION

By delivering a smooth, continuous bead of the proper size, an ARO® system helps the operator maintain both production rate and produce high quality standards. Maintained quality standards assures that the material benefits are realized. To further maximize operator production time, the ARO system has a built-in lift / ram feature for quick and easy drum changeover and easy lifting of the pump assembly from the container.

ARO systems are totally enclosed, sealing the material in the system from air and moisture, preventing premature cure-out of the material. This allows for either continuous or intermittent use of the system and allows the need for daily system clean-up.

## INSTALLATION

The HDD265S5XXXXXXX Extrusion System comes completely assembled. Remove the unit from the crate and place on a level surface. Install the material hose and dispensing device as required.

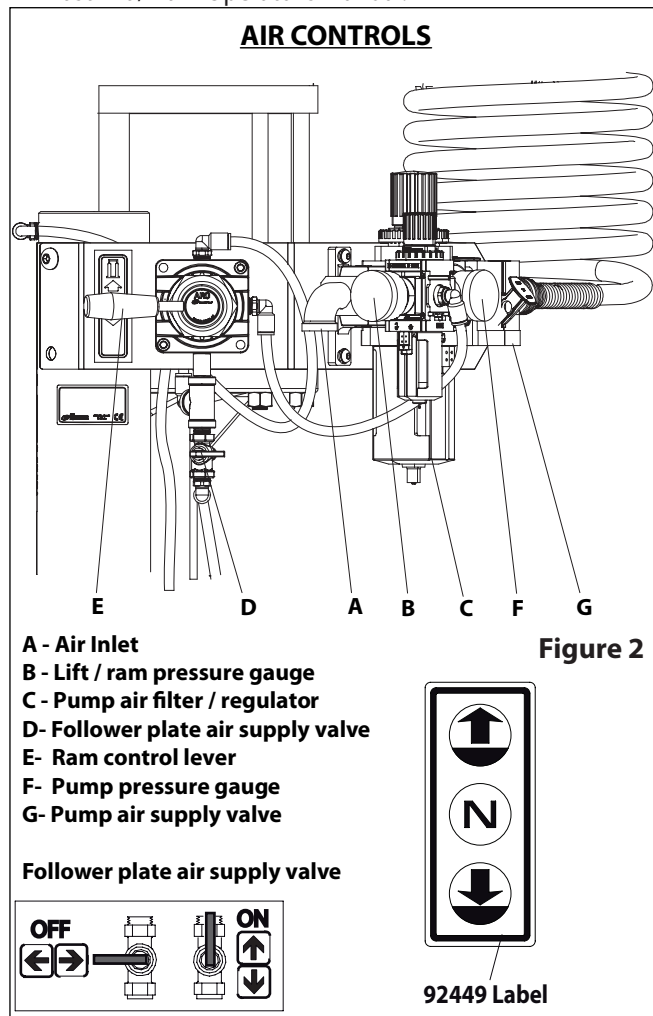
When the following instructions are observed, heavy paste

materials can be pumped directly from their original drum without air inclusion or excessive waste. The follower plate creates an air tight seal as well as clean-wiping action in its progressive downward movement into the drum.

## OPERATING INSTRUCTIONS

### OPERATING INSTRUCTIONS / INITIAL SET-UP PROCEDURE

**WARNING** Stand clear when raising or lowering the lift. Read the warnings on page 3 of RM552X-XXX-XX Two Post Lift / Ram Operator's Manual.



#### TO RAISE THE LIFT, (the first time):

1. Take note of the pump / drum clearance above. Be certain the lift / ram is clear of any objects above. Also, refer to "Operating and Safety Precautions" found on page 3 of RM552X-XXX-XX Two Post Lift / Ram Operator's Manual.
2. Connect the air supply (150 p.s.i. max.) to the air inlet. Adjust the air pressure on the lift / ram pressure regulator (turn the knob clockwise) to 20 p.s.i. (1.4 bar).
3. Shift the control valve lever to the "up" position.
4. Raise the lift / ram high enough to clear the height of the drum. Stop the lift upward travel by moving the control valve lever to the "neutral" (center) position.

#### REFER TO PAGE 3:

1. Once the lift / ram assembly and pump are in the "up" position, place and center an opened 5 or 55 gallon drum of material on the lift / ram base.

2. Lubricate the lower follower wiper plate seal with grease. This ensures a smooth fit into the drum, as well as prevents curing type compounds from bonding to the seal. NOTE: Make certain the grease is compatible with the material being dispensed.
3. Check the vent plug on the follower plate to be sure it easily threads in and out. It is recommended to lubricate the threads of the plug to help prevent possible set-up of the compound at this point (see RM552X-XXX-XX Operator's Manual).

#### TO LOWER LIFT:

**WARNING** PINCH HAZARD. Follower can descend quickly, causing injury. Keep hands clear when aligning with container. Read the warnings on page 3 of RM552X-XXX-XX Two Post Lift / Ram Operator's Manual.

NOTE: Be certain the follower plate vent plug has been removed so that the air trapped between the follower and the material is allowed to escape from this vent. Captured air between the follower plate and drum will escape.

NOTE: The lift / ram may hesitate momentarily before starting downward. The air pressure inside the post air chamber must decrease before it will begin to descend.

1. Shift the control valve lever to the "down" position and proceed to lower the pump.
2. Replace the vent plug once the material begins to ooze from the vent opening.
3. The unit is now ready for operation. Adjust the air pressure on the pump filter / regulator (turn the pump regulator knob clockwise) until the pump begins to cycle.
4. Trigger the gun to prime the pump with material.

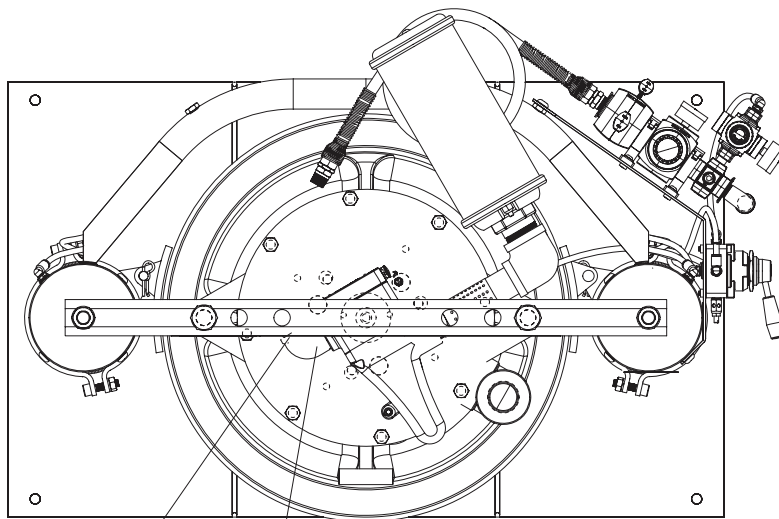
#### TO RAISE LIFT, (normal operation):

1. Adjust the follower plate air valve pressure up to approximately 8 p.s.i.g. (0.55 bar). DO NOT OVER PRESSURIZE THE DRUM to avoid damage. NOTE: Air from this valve will only pass when the control lever is in the "up" position.
2. Shift the control valve lever to the "up" position.
3. Raise the lift / ram high enough to clear the height of the drum. Stop the lift upward travel by moving the control valve lever to the "neutral" (center) position.

#### TO CHANGE THE DRUM:

NOTE: The control valve lever must be in the "neutral" position.

1. Remove the old drum.
2. Place and center a new drum into position.



Y45-9-C Bushing

Y43-5-C Street Elbow (3/4 - 14 NPT)

**Included but not shown**

66333-B Wet-Sol "Plus" (1 quart)

**\*Apply anaerobic pipe sealant to all uncoated threads before assembly.**

AF1265S1XXXXX  
Pump Assembly

94810 Muffler

Y44-69-C Nipple

96927 Reducing Elbow

RM552X-XXX-XX Two Post Lift / Ram

Y6-66-C Cap Screw (4)

Y14-616 Lock Washer (4)

Y12-106-C Nut (4)

92362 Support Bracket (2)  
(see Figure 5 for 66353-1 Bracket Assembly)

Y6-65-C Cap Screw (4)

Y12-6-C Nut (4)

Y14-616 Lock Washer (4)

Y43-317-C Elbow (1 1/4"-11 1/2" NPT)

96614 Nipple (1 1/4"-11 1/2" NPT)

67504 Drum Hold Down Kit

Y99-84-C Screw (3)

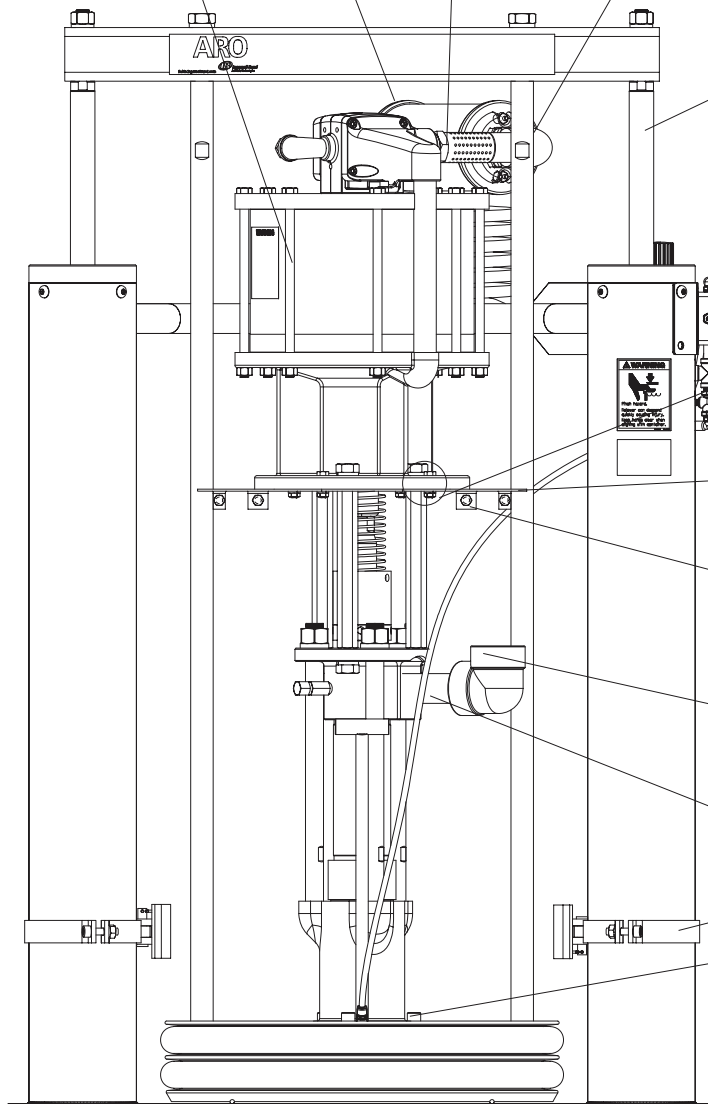


Figure 3

94980-(●) Tubing (5/16" o.d. x 44")

59474-158 Male Connector

**Follower Assembly**  
(See model description chart  
on page 1)

(●) 94980-100 Bulk Tubing (5/16" o.d. x 100")

Figure 4

### 66353-1 Bracket Assembly

Y14-616 Lock Washer (4) (3/8")

Y6-66-C Cap Screw (4) (3/8" - 16 x 1-1/4")

Y12-106-C Nut (4) (3/8" - 16)

92362 Bracket (2)

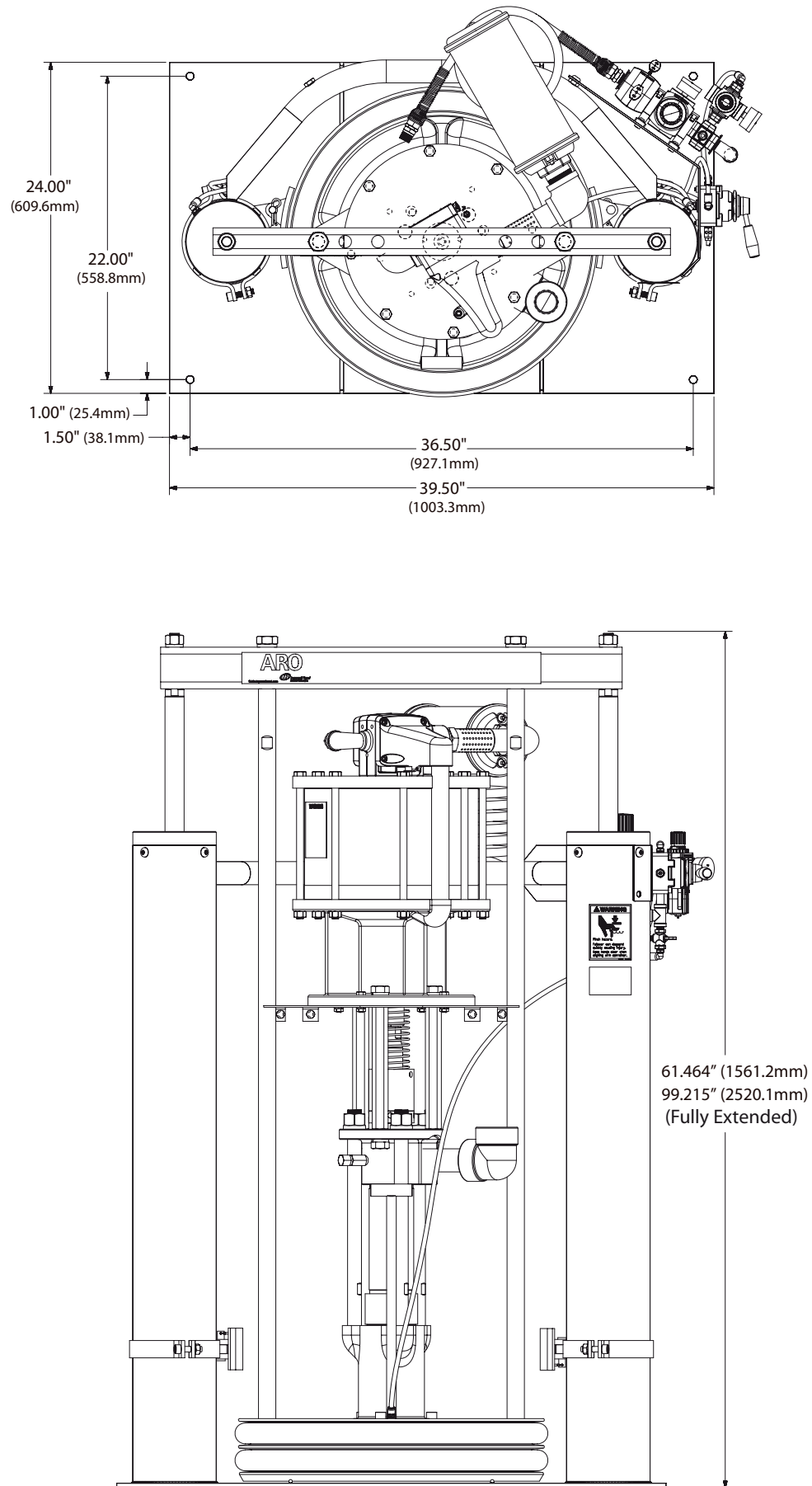
Y14-616 Lock Washer (4) (3/8")

Y12-6-C Nut (4) (3/8" - 16)

Y6-65-C Cap Screw (4) (3/8" - 16 x 1")

Figure 5

## DIMENSIONS



**Figure 6**

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## NOTES

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