

# OPERATOR'S MANUAL

# NP844XXXXR6-XX

## INCLUDING: OPERATION, INSTALLATION AND MAINTENANCE.

INCLUDE MANUALS: 650891-XXX-C Pump (pn 97999-889), 651612-X Heavy Duty Two Post Lift / Ram (pn 97999-226), 253XX-XXX Heavy Duty Air Line Filter-Regulator-Lubricator (pn 103942) & S-636 General Information (pn 97999-636).

RELEASED: 2-19-09

REVISED:  
(REV. 01)

**8" AIR MOTOR**  
**44:1 RATIO**  
**6" STROKE**

## NP844EXXR6-XX EXTRUSION SYSTEM 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.  
The original language of this manual is English.

### SERVICE KITS

**29960** for repair of 27354-000 heavy duty regulator.  
**66614** for repair of 66523-B air motor.  
**104020** for repair of 25351-010 heavy duty filter.  
**104023** for repair of 26351-010 heavy duty lubricator.  
**104158** for repair of 127122-000 miniature regulator.  
**637071-XXD-B** for repair of 66243-XXD-B lower pump end.  
**637343** for repair of lift / ram seals.

### MODEL DESCRIPTION CHART

NP 8 44 E XXX R6 - XX	
<b>Air Motor Size</b> 8 - 8"	
<b>Pump Ratio</b> 44 - 44:1	
<b>Check Type / Wetted Materials</b> E - Chop-check / carbon steel	
<b>Lower Pump End Options</b> Refer to pump model operator's manual	
<b>Mount Style</b> R6 - Heavy duty two post ram, 55 gallon	
<b>Follower Assembly</b>	
10 - 66516	31 - 67195-2
11 - 66516-1	32 - 67195-3
12 - 66516-2	33 - 67195-8
20 - 66516-5	40 - 67195-5
21 - 66516-6	41 - 67195-6
22 - 66516-7	42 - 67195-7
30 - 67195-1	43 - 67195-9

### NP844XXXXR6-XX EXTRUSION SYSTEM

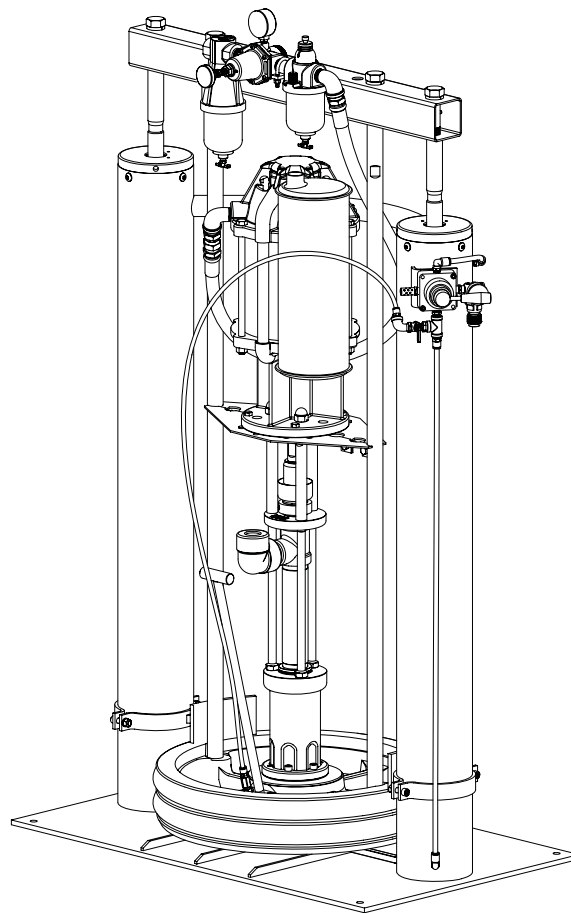


Figure 1

### 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 NP844XXXXR6-XX 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

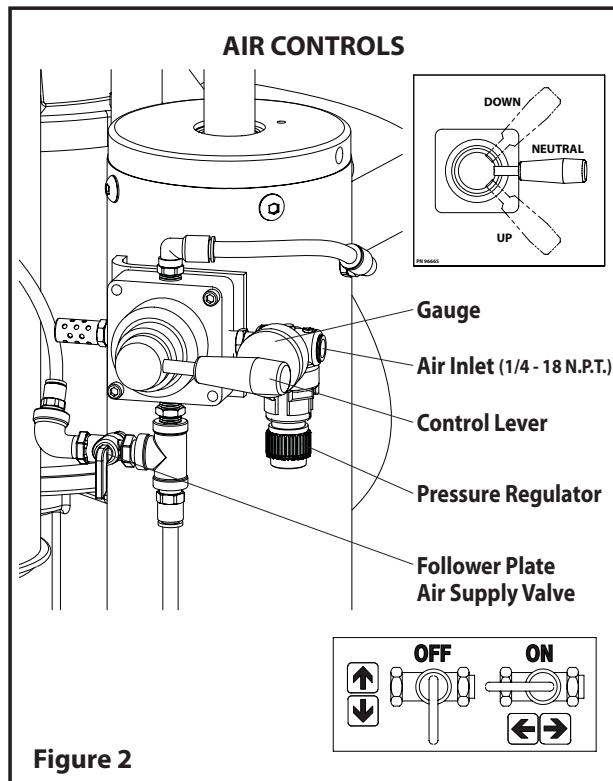
materials can be pumped directly from their original drum without air inclusion or excessive waste. The follower plate creates an air tight seal as well as clean-wiping action in its progressive downward movement into the drum.

## OPERATING INSTRUCTIONS

### OPERATING INSTRUCTIONS / INITIAL SET-UP PROCEDURE

#### **⚠ WARNING** Stand clear when raising or lowering the lift.

Read the warnings on page 2 of 651612-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 2 of 651612-XX Two Post Lift / Ram Operator's Manual.
2. Connect the air supply (100 p.s.i. max.) to the air inlet. Adjust the air pressure on the lift / ram pressure regulator (turn the knob clockwise) to 30 - 40 p.s.i. (2.1 - 2.8 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.
5. Once the lift / ram assembly and pump are in the "up" position, place and center an opened drum of material on the lift / ram base and securely against the barrel guides, adjusting if necessary.

6. Lubricate the lower follower wiper plate seal with grease. NOTE: Make certain the grease is compatible with the material being dispensed. This ensures a smooth fit into the drum, as well as prevents curing type compounds from bonding to the seal.
7. 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.

#### **TO LOWER LIFT:**

**⚠ WARNING** PINCH HAZARD. Follower can descend quickly, causing injury. Keep hands clear when aligning with container. Read the warnings on page 2 of 651612-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.

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.

# PARTS LIST / NP844XXXXR6-XX

Item	Description (size)	Qty	Part No.
1	Heavy Duty Filter (3/4 - 14 N.P.T.)	(1)	25351-010
2	Nipple (3/4 - 14 N.P.T. x 2")	(2)	Y27-55-C
3	"U" Bolt (1/4" - 20)	(2)	76254
4	Heavy Duty Regulator (3/4 - 14 N.P.T.)	(1)	27354-000
5	Gauge (0 - 160 p.s.i. / 0 - 11 bar)	(1)	29728
6	Heavy Duty Lubricator (3/4 - 14 N.P.T.)	(1)	26351-010
7	Nut (1/4" - 20)	(4)	Y12-4-C
8	Lock Washer (1/4")	(4)	Y14-416
9	Mounting Plate	(2)	90935
10	Swivel Union (3/4 - 14 N.P.T.F. - 1 male x 3/4 - 14 N.P.S.M. female)	(1)	75367
11	90° Street Elbow (3/4 - 14 N.P.T.)	(2)	Y43-5-C
12	Screw (7/8" - 14 x 4")	(2)	94009
13	Lock Washer (7/8")	(2)	Y14-875
14	Hose Assembly (3/4 - 14 N.P.T.F. x 4')	(1)	622651-4
15	Exhaust Muffler	(1)	92460
16	Piston Pump (44:1 chop check)	(1)	650891-XXX-C
17	Bracket Assembly (see page 6)	(1)	66353-1
18	Two Post Lift / Ram Assembly	(1)	651612-Z
19	Rod	(2)	94016

Item	Description (size)	Qty	Part No.
20	Follower Assembly (see "Model Description Chart", page 1)	(1)	
21	Gauge (0 - 160 p.s.i. / 0 - 11 bar)	(1)	29850
22	Nipple (1/4 - 18 N.P.T.F. - 1 x 1-5/16")	(1)	1950
23	Cap Screw (1/4" - 20 x 5/8")	(4)	Y6-42-C
24	Lock Washer (1/4")	(4)	Y14-416
25	Miniature Regulator (1/4 - 18 N.P.T.)	(1)	127122-000
26	Tubing (5/16" o.d. x 58")	(1)	94980-( ❶ )
27	90° Elbow (1 - 11-1/2 N.P.T.)	(1)	Y43-316-C
28	Nipple (1 - 11-1/2 N.P.T.F. - 1 x 1-1/2") (not shown)	(1)	90818
29	Connector (1/4 - 18 N.P.T. x 5/16" o.d. tubing)	(1)	59474-158
30	Support Bracket	(2)	92362
31	Nut (3/8" - 16)	(4)	Y12-106-C
32	Cap Screw (3/8" - 16 x 1-1/4")	(4)	Y6-66-C
33	Lock Washer (3/8")	(8)	Y14-616
34	Nut (3/8" - 16)	(4)	Y12-6-C
35	Cap Screw (3/8" - 16 x 1")	(4)	Y6-65-C
	Wet-Sol Plus (1 quart) (not shown)	(1)	66333-B
❶	Bulk Tubing (5/16" o.d. x 100')	(1)	94980-100

- ❶ Apply anaerobic pipe sealant to threads.

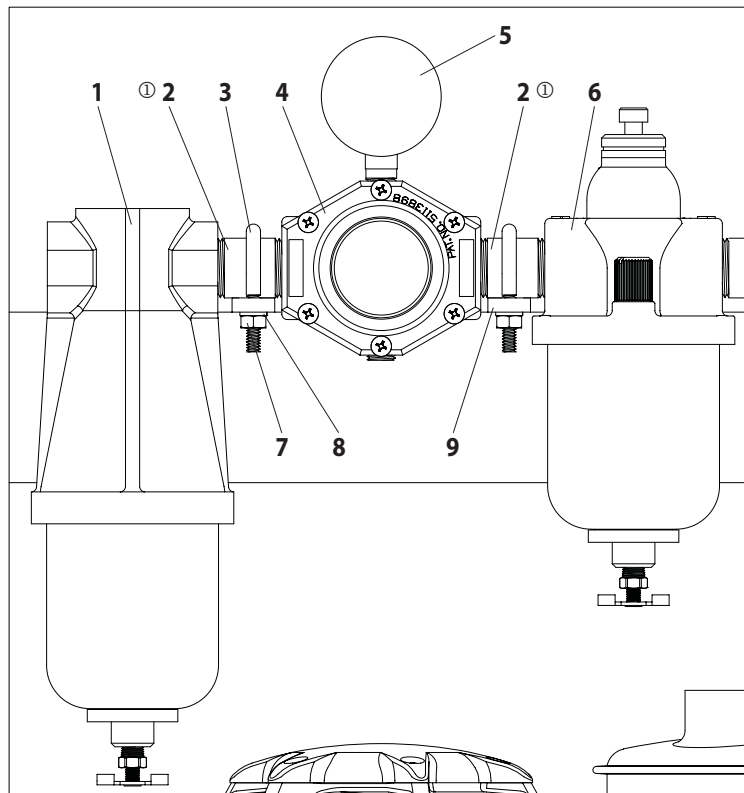


Figure 3

Figure 4

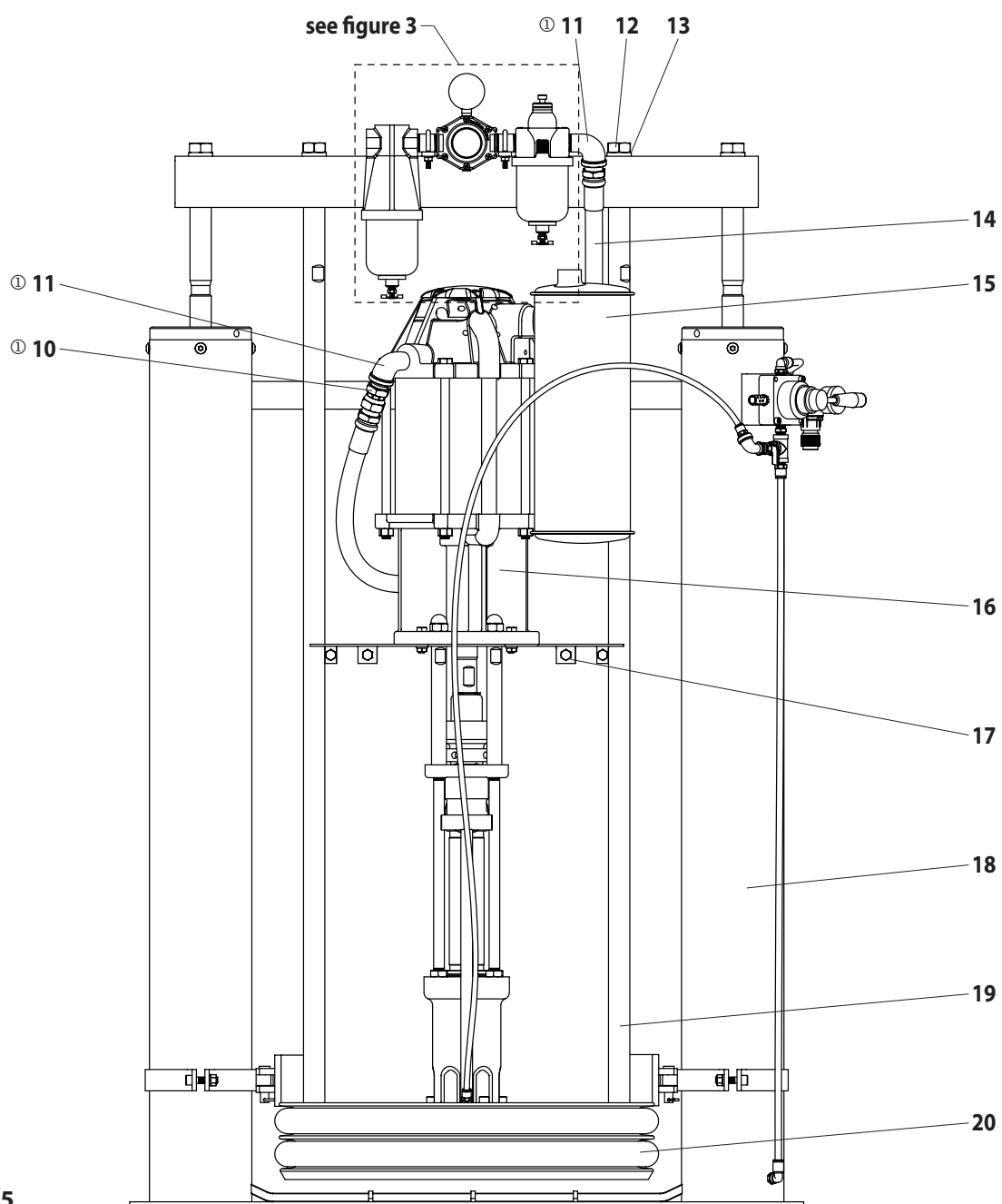
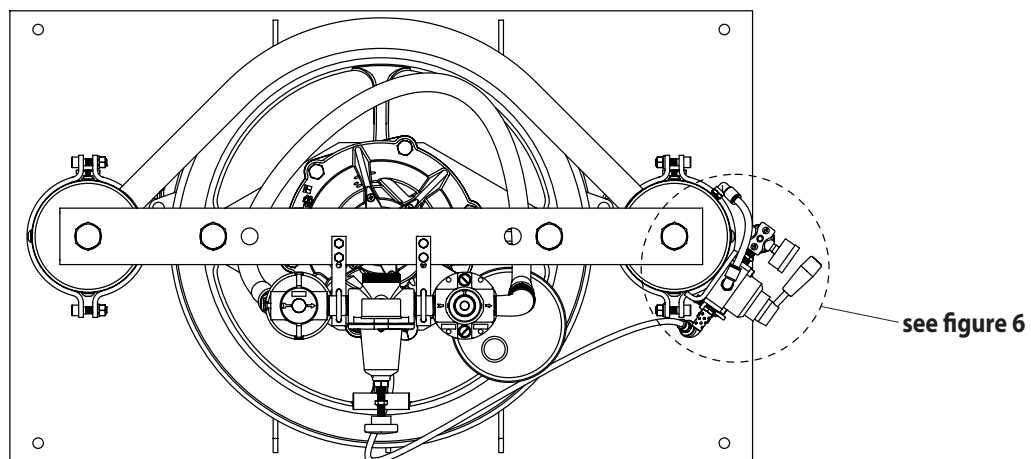


Figure 5

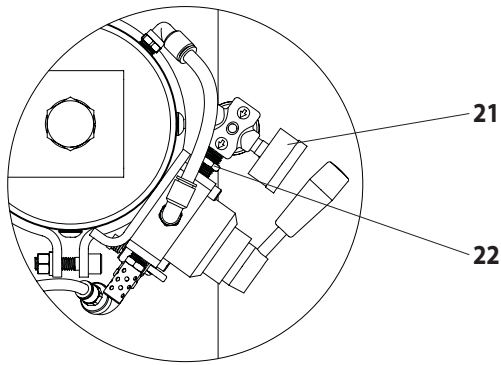


Figure 6

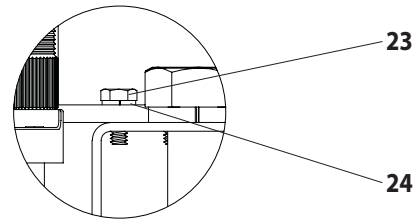


Figure 7

- ① Apply anaerobic pipe sealant to threads.

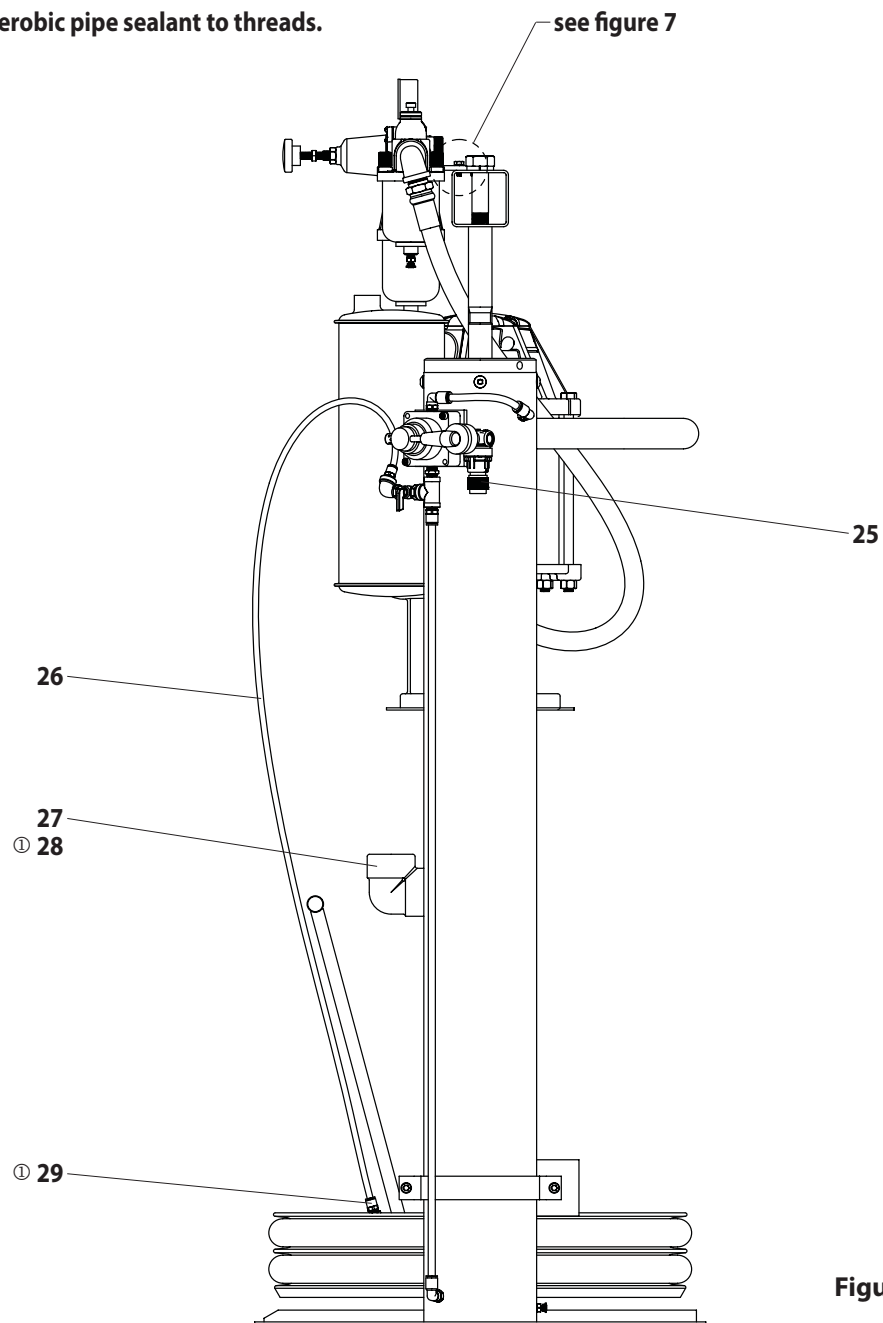
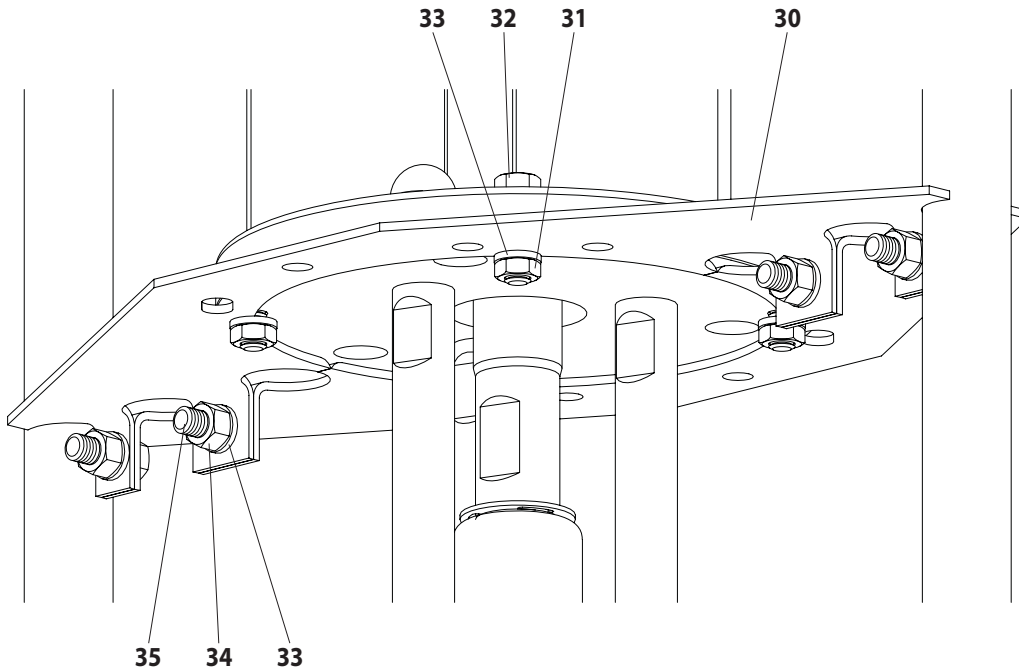


Figure 8

**66353-1 Bracket Assembly****Figure 9**



