OPERATOR’S MANUAL

TP0423S2XXXXXXXX

INCLUDING: OPERATION, INSTALLATION AND MAINTENANCE.

INCLUDE MANUALS: AF0423SXXXXXX-XX-X Extrusion Pump (97999-1499), 66731-X Follower Plate (pn 97999-213), 67342-X Follower Assembly (pn 97999-1099), 67347-X Follower Assembly (pn 97999-1102), RM052S-X Two Post Lift / Ram (pn 97999-1345), & S-636 General Information (pn 97999-636).

4-1/4” AIR MOTOR
23:1 RATIO
6” STROKE

TWO POST RAM PACKAGE
5 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 AF0460-XX air motor.
- 104302 for repair of P39124-120 filter / regulator.
- 104453 for repair of P39344-110 filter / regulator.
- 637465 for repair of lift / ram seals.
- 637074-X43-B for repair of 66266-X43-B lower pump section.

MODEL DESCRIPTION CHART

<table>
<thead>
<tr>
<th>Package</th>
<th>Air Motor Size</th>
<th>Pump Ratio</th>
<th>Check Type / Wetted Materials</th>
<th>Mount Style</th>
<th>Lower Pump End Options</th>
<th>Follower Assembly</th>
<th>Package Option</th>
</tr>
</thead>
<tbody>
<tr>
<td>TP 04 23 S 2 XXXX XX X</td>
<td>04 - 4-1/4”</td>
<td>23 - 23:1</td>
<td>S - Chop Check / Carbon Steel</td>
<td>2 - 5 gallon (35 lbs)</td>
<td>Refer to pump model operator’s manual</td>
<td>ET - 67342-2 A7 - 67347-2 E3 - 67342-1 A8 - 67347-1 ES - 67342-3 T7 - 67347-12 EB - 66731-2 T8 - 67347-11 EC - 66731 ED - 66731-1</td>
<td>0 - None - Basic Control for Ram only 2 - Advanced Ram and Pump Controls</td>
</tr>
</tbody>
</table>

Figure 1
INSTALLATION
The TP0423S2XXXXXXXX Ram 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 RM052X-XXX-XX Two Post Lift / Ram Operator’s Manual.

AIR CONTROLS

A - Air inlet
B - Ram pressure gauge
C - Ram air filter / regulator
D - Follower plate air supply valve
E - Ram control lever
F - Pump air filter / regulator
G - Pump air supply valve
H - Pump pressure gauge

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 RM052X-XXX-XX Two Post Lift / Ram Operator’s Manual.
2. Connect the air supply (150 psig / 10.3 bar max.) to the air inlet. Adjust the air pressure on the lift / ram pressure regulator (turn the knob clockwise) to 20 psig (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.
5. Once the lift / ram assembly and pump are in the “up” position, place and center an opened 5 gallon drum of material on the lift / ram base.
6. 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.
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 (see RM052X-XXX-XX Operator’s Manual).

LOWER LIFT:


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. Open the pump air supply valve. 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. Close the pump air supply valve.
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. To avoid damage, DO NOT OVER PRESSURIZE THE DRUM.
2. Open the follower plate supply valve to allow air under the follower plate.
3. Shift the control valve lever to the “up” position.
4. Place and center a new drum into position. Remove the cover.
### PARTS LIST / TP0423S2XXXXXXXX

<table>
<thead>
<tr>
<th>Item</th>
<th>Description (size)</th>
<th>Qty</th>
<th>Part No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Pump Assembly</td>
<td>(1)</td>
<td>AF0423S1XXXXX</td>
</tr>
<tr>
<td>2</td>
<td>* Tubing (1/2&quot; o.d. x 33&quot;)</td>
<td>(1)</td>
<td>94978-(①)</td>
</tr>
<tr>
<td>3</td>
<td>Cap Screw (3/8&quot; - 16 x 1-1/2&quot;)</td>
<td>(4)</td>
<td>Y6-68-C</td>
</tr>
<tr>
<td>4</td>
<td>Lock Washer (3/8&quot;)</td>
<td>(4)</td>
<td>Y14-616-C</td>
</tr>
<tr>
<td>5</td>
<td>Nut (3/8&quot; - 16)</td>
<td>(4)</td>
<td>Y12-6-C</td>
</tr>
<tr>
<td>6</td>
<td>Mounting Plate</td>
<td>(1)</td>
<td>96737</td>
</tr>
<tr>
<td>7</td>
<td>* Tubing (5/16&quot; o.d. x 30&quot;)</td>
<td>(1)</td>
<td>94980-(②)</td>
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<tr>
<td>8</td>
<td>Two-Post Lift / Ram</td>
<td>(1)</td>
<td>RM052S-XXX-XX</td>
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<table>
<thead>
<tr>
<th>Item</th>
<th>Description (size)</th>
<th>Qty</th>
<th>Part No.</th>
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<tbody>
<tr>
<td>9</td>
<td>* 90° Male Fitting (1/2 NPT x 1/2&quot; o.d.)</td>
<td>(1)</td>
<td>59756-362</td>
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<tr>
<td>10</td>
<td>Follower Assembly (see model description chart on page 1)</td>
<td>(1)</td>
<td></td>
</tr>
<tr>
<td>11</td>
<td>Wet-Sol &quot;Plus&quot; (1 quart) (not shown)</td>
<td>(1)</td>
<td>66333-B</td>
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<tr>
<td>①</td>
<td>Bulk Tubing (1/2&quot; o.d. x 100’)</td>
<td>(1)</td>
<td>94978-100</td>
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<tr>
<td>②</td>
<td>Bulk Tubing (5/16&quot; o.d. x 100’)</td>
<td>(1)</td>
<td>94980-100</td>
</tr>
</tbody>
</table>

* Included with RM052S-XXX-XX

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**Figure 3**

1. [Diagram of Pump Assembly](en)
2. [Diagram of Follower Assembly](en)
3. [Diagram of Wet-Sol "Plus"](en)
4. [Diagram of Two-Post Lift / Ram](en)

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