

OPERATOR'S MANUAL

TP1020S5XXXXXXX

INCLUDING: OPERATION, INSTALLATION AND MAINTENANCE.

RELEASED: 5-12-10

INCLUDE MANUALS: AF1020SXXXXXX Extrusion Pump (pn 97999-1521), RM552S-X Two Post Lift/Ram (pn 97999-1445), (REV. 01)
66516-X Follower Assembly (pn 97999-854), 67195-X Follower Assembly (pn 97999-841) 651729 Air Manifold (pn 97999-610)
& S-636 General Information (pn 97999-636).

10" AIR MOTOR
20:1 RATIO
6" STROKE

EXTRUSION SYSTEM

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.
The original language of this manual is English.**

SERVICE KITS

- Use only genuine ARO® replacement parts to assure compatible pressure rating and longest service life.
- **637489** for repair of AF1060-XX air motor.
- **104302** for repair of P39124-100 filter / regulator.
- **104453** for repair of P39344-100 filter / regulator.
- **637491** for repair of lift / ram seals.
- **637128-XX4-B** for repair of 66236-XXE-B lower pump section.

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.

MODEL DESCRIPTION CHART

	TP	10	20	S	5	XXXX	XX	X
Packing Type TP - Two Post								
Air Motor Size 10 - 10"								
Pump Ratio 20 - 20 : 1								
Check Type / Wetted Materials S - Primer Piston, Carbon Steel Nickel-Plated								
Container Suitability 5 - 55 Gallon (400 lbs)								
Pump Options Refer to pump Operator's Manual								
Follower Assembly AC - 66517 TB - 66517-7 TN - 67196-6 AA - 66517-1 AM - 67196-1 TV - 67196-7 AB - 66517-2 AN - 67196-2 AS - 67196-8 TC - 66517-5 AV - 67196-3 TS - 67196-9 TA - 66157-6 TM - 67196-5								
Package Options 0 - None - Basic control for Ram only 2 - Advanced Ram and Pump Controls								

TP1020S5XXXXXXX EXTRUSION SYSTEM

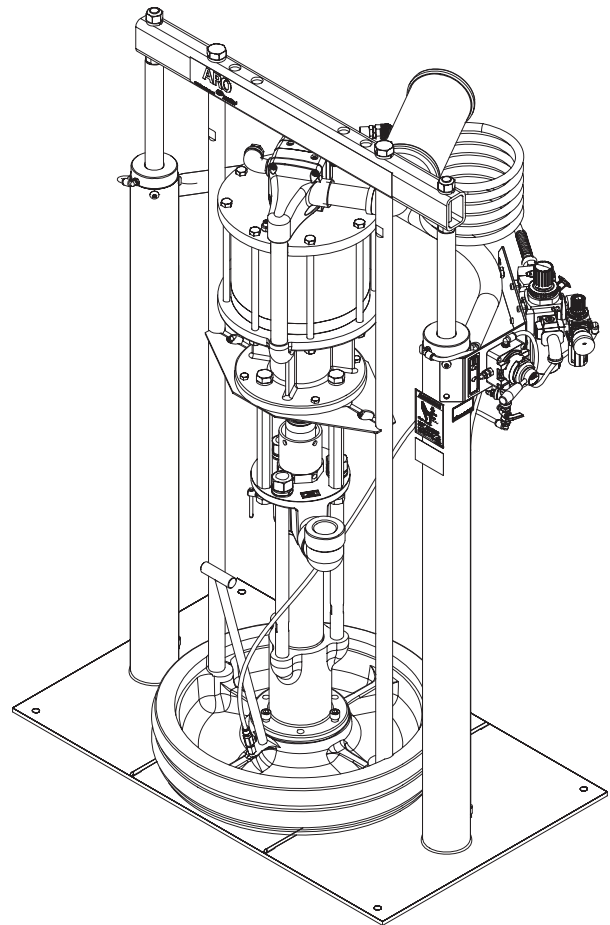


Figure 1

INGERSOLL RAND COMPANY LTD

P.O. BOX 151 • ONE ARO CENTER • BRYAN, OHIO 43506-0151

☎ (800) 495-0276 • FAX (800) 892-6276

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INSTALLATION

The TP1020S5XXXXXXX 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.

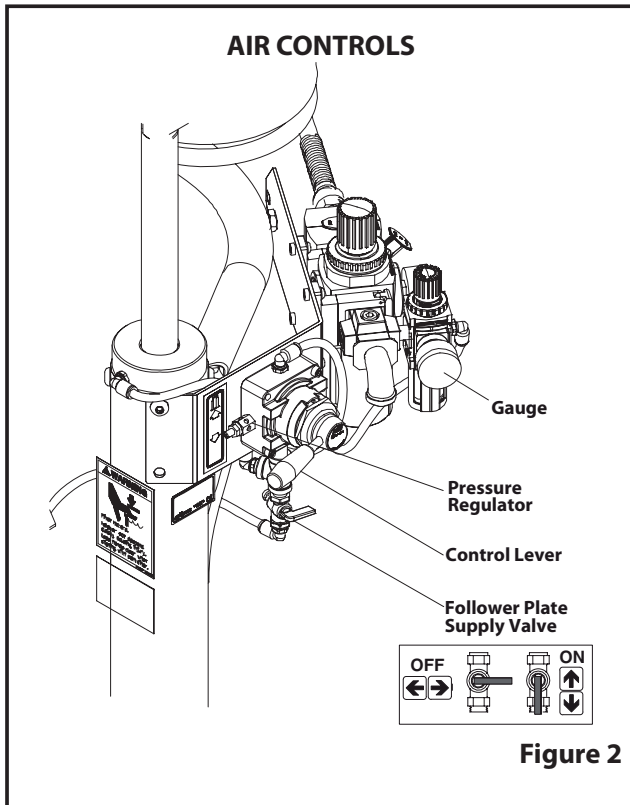
When the following instructions are observed, heavy paste materials can be pumped directly from their original drum without air inclusion or excessive waste. The follower plate creates an air tight seal as well as clean-wiping action in its progressive downward movement into the drum.

OPERATING INSTRUCTIONS

OPERATING INSTRUCTIONS / INITIAL SET-UP PROCEDURE

⚠ WARNING Stand clear when raising or lowering the lift.

Read the warnings on page 3 of RM552S-X 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 RM552S-X 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.
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.
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 (see RM552S-X 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 RM552S-X 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.

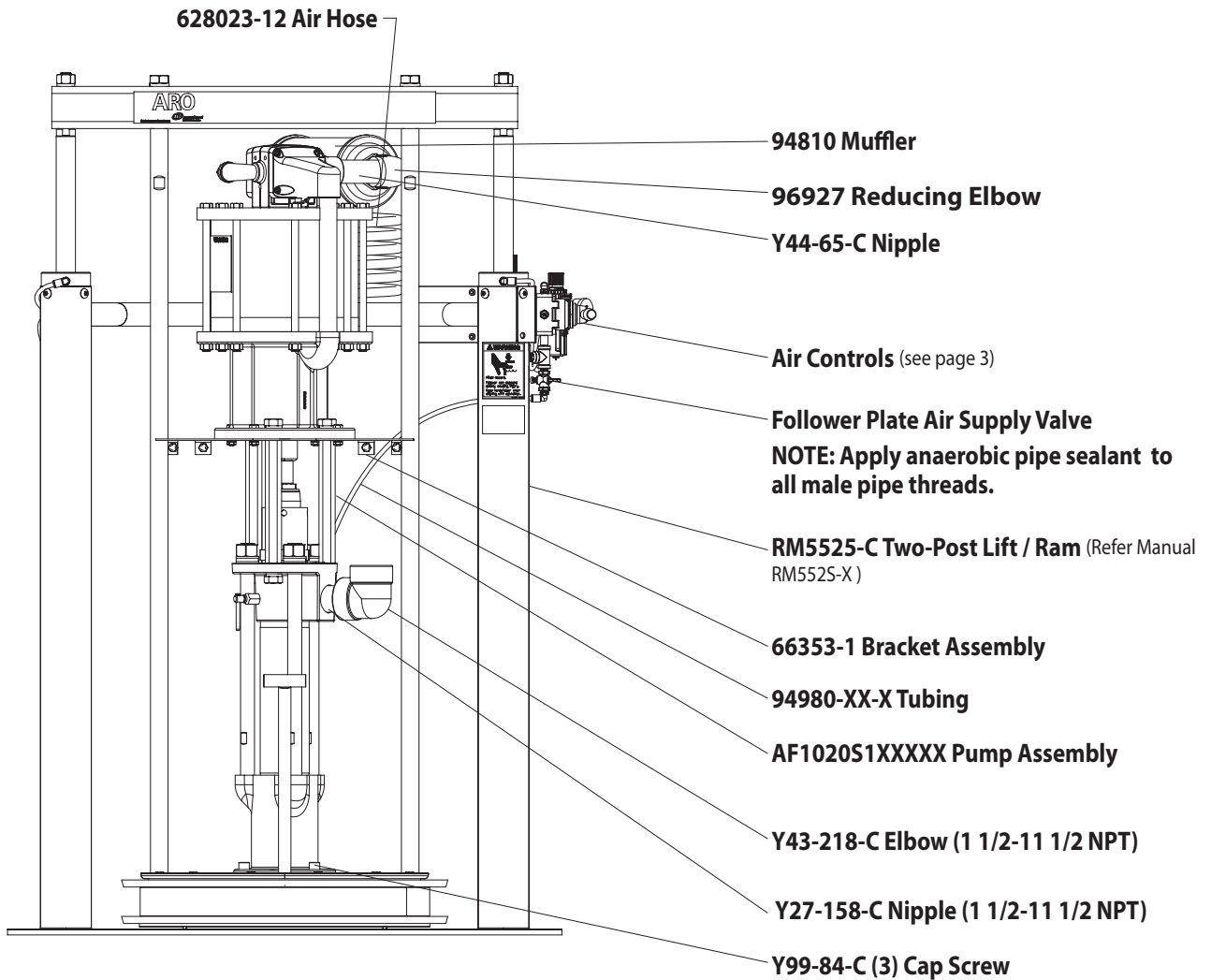
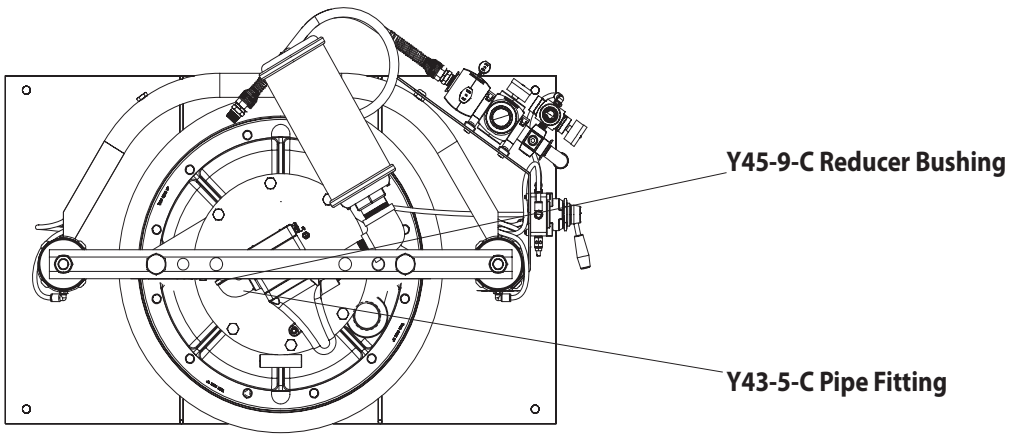
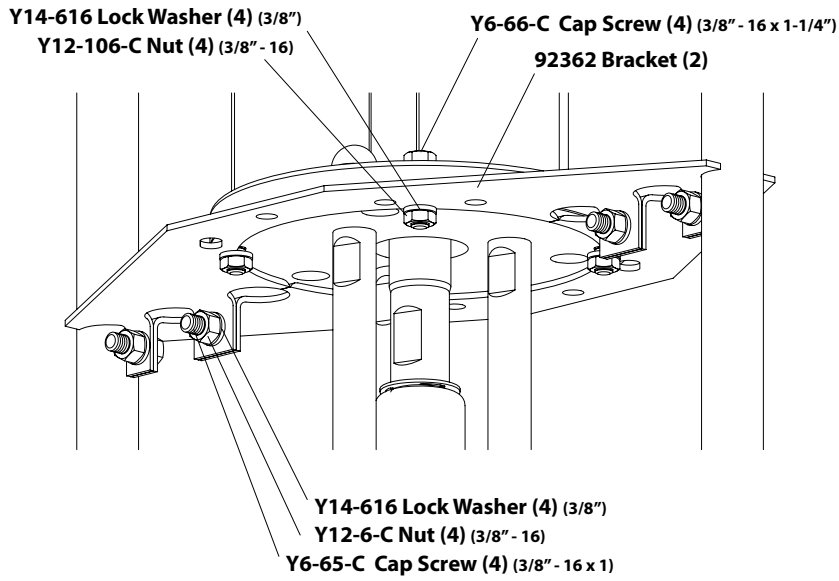


Figure 3

PARTS LIST / TP1020S5XXXXXXXX

66353-1 Bracket Assembly



DIMENSIONAL DATA

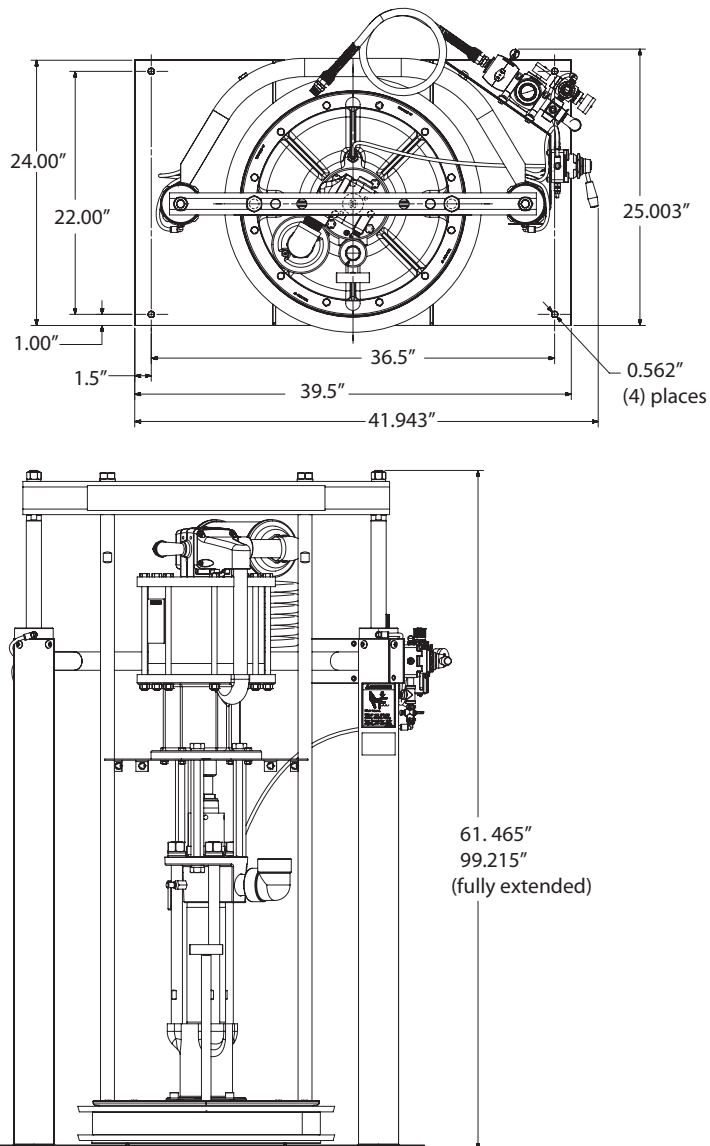


Figure 4