

# OPERATOR'S MANUAL

# LM2350E-XX-B

INCLUDING: SPECIFICATIONS, SERVICE KITS, GENERAL INFORMATION, TROUBLESHOOTING.

INCLUDE MANUALS: S-632 General Information Manual (pn 97999-624).

RELEASED: 6-18-08

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(REV: P)

**3" AIR MOTOR**  
**50:1 RATIO**  
**0 - 7500 PSI RANGE**

## LM2350E-XX-B CHOP-CHECK GREASE PUMP



**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.
- **637227-B** pump rebuild kit. Includes the necessary soft parts for normal service of the entire pump.

### SPECIFICATIONS

<b>Model Series</b> .....	LM2350E-XX-B
<b>Pump Type</b> .....	Air Operated, Chop-Check Grease Pump
<b>Ratio</b> .....	50:1
<b>Air Motor Diameter</b> .....	3" (7.62 cm)
<b>Stroke</b> (double acting) .....	3" (7.62 cm)
<b>Air Inlet</b> (female)	
LM2350E-X1-B .....	1/4 - 18 NPTF - 1
LM2350E-X2-B .....	Rp 1/4 (1/4 - 19 BSP Parallel)
<b>Material Outlet</b> (female)	
LM2350E-X1-B .....	1/4 - 18 NPTF - 1
LM2350E-X2-B .....	Rp 3/8 (3/8" - 19 BSP Parallel)
<b>Pump Construction</b> .....	Carbon Steel
<b>Dimensional Data</b> .....	see chart
<b>Weight</b> .....	see chart

### PUMP PERFORMANCE

<b>Air Inlet Pressure Range</b> .....	0 - 150 psig (0 - 10.3 bar)
<b>Fluid Pressure Range</b> .....	0 - 7500 psig (0 - 517.2 bar)
<b>Cycles / Minute Rec'd</b>	
@ <b>Working Flow</b> .....	135
<b>Displacement</b> In. <sup>3</sup> Per Cycle .....	0.875
<b>Volume / Cycle</b> .....	0.48 oz. (14.33 ml)
<b>Cycles per Lb.</b> .....	30
<b>Maximum Delivery / Minute</b> .....	7.5 lbs (3.4 kgs)
<b>Noise Level @ 100 p.s.i.</b> .....	85.0 db(A) <sup>①</sup>
<b>Accessories Available</b> .....	61113 Wall Mount Bracket 66073-1 Air Line Connection Kit

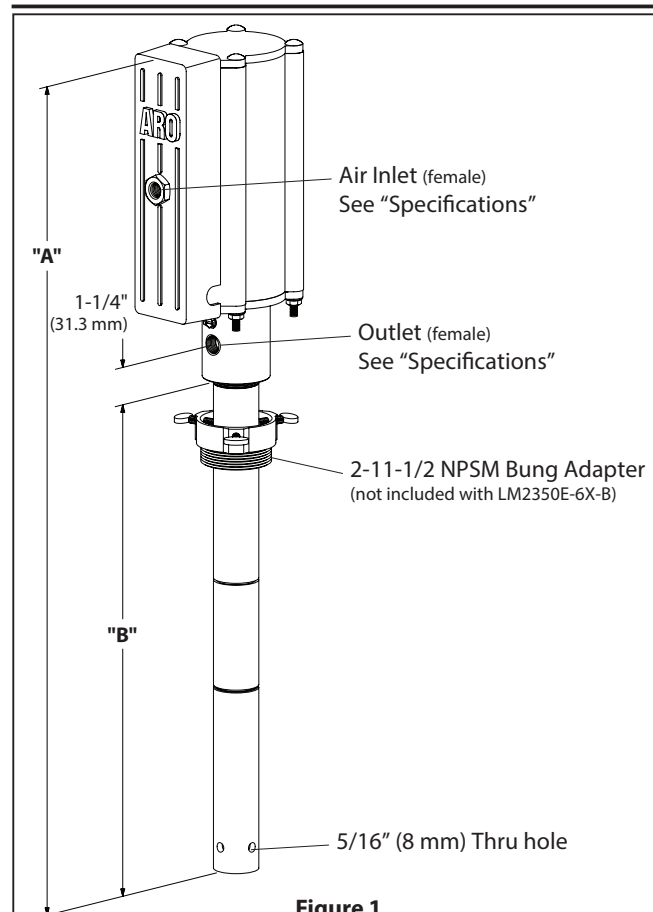
① The pump sound pressure level has been updated to an Equivalent Continuous Sound Level (LA<sub>eq</sub>) to meet the intent of ANSI S1.13-1971, CAGI-PNEUROP S5.1 using four microphone locations.

### GENERAL DESCRIPTION

Model LM2350E-XX-B series chop-check grease pump is intended to be used primarily for grease delivery systems. It uses carbon steel and other materials which make it compatible with most petroleum based lubrication products.

NOTE: If this pump was purchased separately (not part of a system), consult your sales representative for compatible dispensing accessories which will best match the application. All accessories must be able to withstand the maximum pressure developed by the pump.

### PUMP DATA



**Figure 1**

NOTE: Dimensions are shown in inches and (mm) and are supplied for reference only.

Model Number	"A" (mm)	"B" (mm)	Weight (kg)
LM2350E-21-B	27-3/4" (704.2)	16-9/16" (420.6)	18.0 lbs (8.16)
LM2350E-22-B	27-3/4" (704.2)	16-9/16" (420.6)	18.0 lbs (8.16)
LM2350E-31-B	38-7/16" (975.7)	27-1/4" (692.1)	21.9 lbs (9.94)
LM2350E-32-B	38-7/16" (975.7)	27-1/4" (692.1)	21.9 lbs (9.94)
LM2350E-41-B	48" (1218.6)	36-13/16" (935.0)	25.4 lbs (11.52)
LM2350E-42-B	48" (1218.6)	36-13/16" (935.0)	25.4 lbs (11.52)
LM2350E-61-B	30-1/2" (774.1)	19-5/16" (490.5)	19.0 lbs (8.62)
LM2350E-71-B	40-1/2" (1028.1)	29-5/16" (744.5)	22.7 lbs (10.28)
LM2350E-81-B	49" (1244.0)	37-13/16" (960.4)	25.8 lbs (11.68)

### IMPORTANT

**This is one of two documents which support the pump. Replacement copies of these forms are available upon request.**

☒ **LM2350E-XX-B** Model Operator's Manual (pn 97999-825)

☐ **S-632** General Information - Air Operated Lubrication Piston Pumps (pn 97999-624)

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# ARO®

## PARTS LIST / LM2350E-XX-B

Item	Description (size)	Qty	Part No.	Mtl
1	Carriage Bolt (1/4" - 20 x 9" long)	(4)	94333	[C]
2	Upper Cap	(1)	94390	[Z]
① 3	Track Gasket	(2)	94392	[B]
4	Sleeve	(2)	94316	[Br]
① 5	"O" Ring (1/16" x 11/16" OD)	(4)	Y325-15	[B]
① 6	"O" Ring (1/8" x 3/4" OD)	(4)	Y325-206	[B]
7	Spool	(2)	94310	[D]
① 8	"U" Cup (1/8" x 3/4" OD)	(2)	Y240-7	[B]
① 9	"O" Ring (0.106" x 0.587" OD)	(2)	15066-PM	[B]
10	Cylinder	(1)	94306	[A]
11	Adapter (LM2350E-X1-B)	(1)	97017	[C]
	(LM2350E-X2-B)	(1)	97017-1	[C]
① 12	"O" Ring (1/16" x 3/4" OD)	(1)	Y325-16	[B]
① 13	"O" Ring (1/16" x 11/32" OD)	(1)	Y325-9	[B]
14	Muffler Housing	(1)	94443	[A]
15	Foam Liner	(2)	94402	[U]
16	Edge Trim	(2)	94378-1	[N]
18	Retaining Ring	(1)	94406	[C]
19	Washer	(1)	94515	[C]
① 20	"U" Cup (3/16" x 3" OD)	(2)	94518	[B]
21	Piston	(1)	94403	[D]
23	Piston Adapter	(1)	94388	[C]
① 24	"O" Ring (3/32" x 1" OD)	(1)	Y325-117	[B]
25	Dowel Pin (1/4" OD x 7/8" long)	(1)	Y148-37	[C]
26	Washer	(1)	94785	[C]
① 27	"O" Ring (3/32" x 11/16" OD)	(1)	Y325-112	[B]
28	Spring	(1)	94705	[C]
① 29	Rod Seal	(1)	93921	[U]
30	Base (LM2350E-X1-B)	(1)	67188	[C/Z]
	(LM2350E-X2-B)	(1)	67188-1	[C/Z]
31	Nut (1/4" - 20)	(4)	93828	[SS]
32	Ground Screw (#10 - 32 x 1/4")	(1)	93005	[C]
① 33	Gasket	(1)	70834	[Co]
34	Extension Tube LM2350E-2X-B (7.531")	(1)	94401-2	[C]
	LM2350E-3X-B (20.281")	(1)	94401-3	[C]
	LM2350E-4X-B (28.781")	(1)	94401-4	[C]
	LM2350E-6X-B (10.281")	(1)	94401-6	[C]
	LM2350E-7X-B (18.531")	(1)	94401-7	[C]
	LM2350E-8X-B (27.781")	(1)	94401-8	[C]

Item	Description (size)	Qty	Part No.	Mtl
① 35	Gasket	(1)	70837	[Co]
36	Piston Rod	(1)	94385	[C]
37	Pin	(1)	94786	[C]
① 38	Cotter Pin (1/16" x 1/2" long)	(1)	Y15-21	[C]
39	Connector LM2350E-2X-B (3.457")	(1)	94340-2	[C]
	LM2350E-3X-B (14.145")	(1)	94340-3	[C]
	LM2350E-4X-B (23.707")	(1)	94340-4	[C]
	LM2350E-6X-B (6.207")	(1)	94340-6	[C]
	LM2350E-7X-B (16.207")	(1)	94340-7	[C]
	LM2350E-8X-B (24.707")	(1)	94340-8	[C]
	Piston and Tube Assembly (includes items 40 - 44)	(1)	71523-1	
40	Lower Suction Tube	(1)		[C]
41	Plunger	(1)		[C]
42	Ball Stop	(1)	83276	[C]
43	Ball (9/32" dia.)	(1)	Y16-209	[C]
44	Adapter	(1)	70817-11	[C]
① 45	Guide Washer	(1)	71524-1	[Co]
46	Spacer	(1)	72392-1	[C]
47	Retaining Ring (0.763" OD)	(1)	Y147-68	[C]
48	"U" Cup (3/16" x 11/16" OD)	(1)	Y186-4	[B]
49	Guide Spacer	(1)	76705	[T]
50	Valve Body	(1)	76704	[SH]
①	Foot Valve Assembly (includes items 47 - 50)	(1)	60940	
① 51	Gasket	(1)	F21-65	[Co]
52	Valve Seat	(1)	6797	[C]
53	Primer Rod	(1)	94446	[C]
① 54	Retainer Ring	(1)	94397	[C]
55	Primer	(1)	94400	[C]
56	Primer Tube	(1)	94399	[C]
✦ 57	Bung Assembly (includes item 58)	(1)	67145-2	[ZA]
✦ 58	Thumb Screw (1/4" - 20 x 1")	(3)	Y66-59-C	[C]
59	Screw	(2)	97019	[C]
60	Plate	(1)	97015	[C]
✦ Not included with models LM2350E-6X-B				
①	Gadus S2 U1000 Grease Packet	(1)	94833	
①	Parts in Repair Kit		637227-B	

## OPERATING AND SAFETY PRECAUTIONS

**⚠ WARNING** **EXCESSIVE INLET PRESSURE.** Can cause explosion, resulting in severe injury or death. Do not exceed maximum operating pressure of 7500 psig (517 bar) at 150 psig (10.3 bar) inlet pressure. Do not run pump without using a regulator to limit air supply pressure to the pump.

**⚠ WARNING** **EXCESSIVE MATERIAL PRESSURE.** Can cause equipment failure, resulting in severe injury or property damage. Do not exceed the maximum material pressure of any component in the system.

Replacement warning label (pn 94520) is available upon request.

**Pump Ratio X                      =                      Maximum Pump**  
**Inlet Pressure to Pump Motor                      Fluid Pressure**

Pump ratio is an expression of the relationship between the pump motor area and the lower pump end area. EXAMPLE: When 150 psig (10.3 bar) inlet pressure is supplied to the motor of a 4:1 ratio pump, it will develop a maximum of 600 psig (41.4 bar) fluid pressure (at no flow) - as the fluid control is opened, the flow rate will increase as the motor cycle rate increases to keep up with the demand.

**⚠ WARNING** **READ THE GENERAL INFORMATION MANUAL INCLUDED FOR ADDITIONAL OPERATING AND SAFETY PRECAUTIONS AND OTHER IMPORTANT INFORMATION.**

**NOTICE:** Thermal expansion can occur when the fluid in the material lines is exposed to elevated temperatures. Example: Material lines located in a non-insulated roof area can warm due to sunlight. Install a pressure relief valve in the pumping system.

# PARTS LIST / LM2350E-XX-B

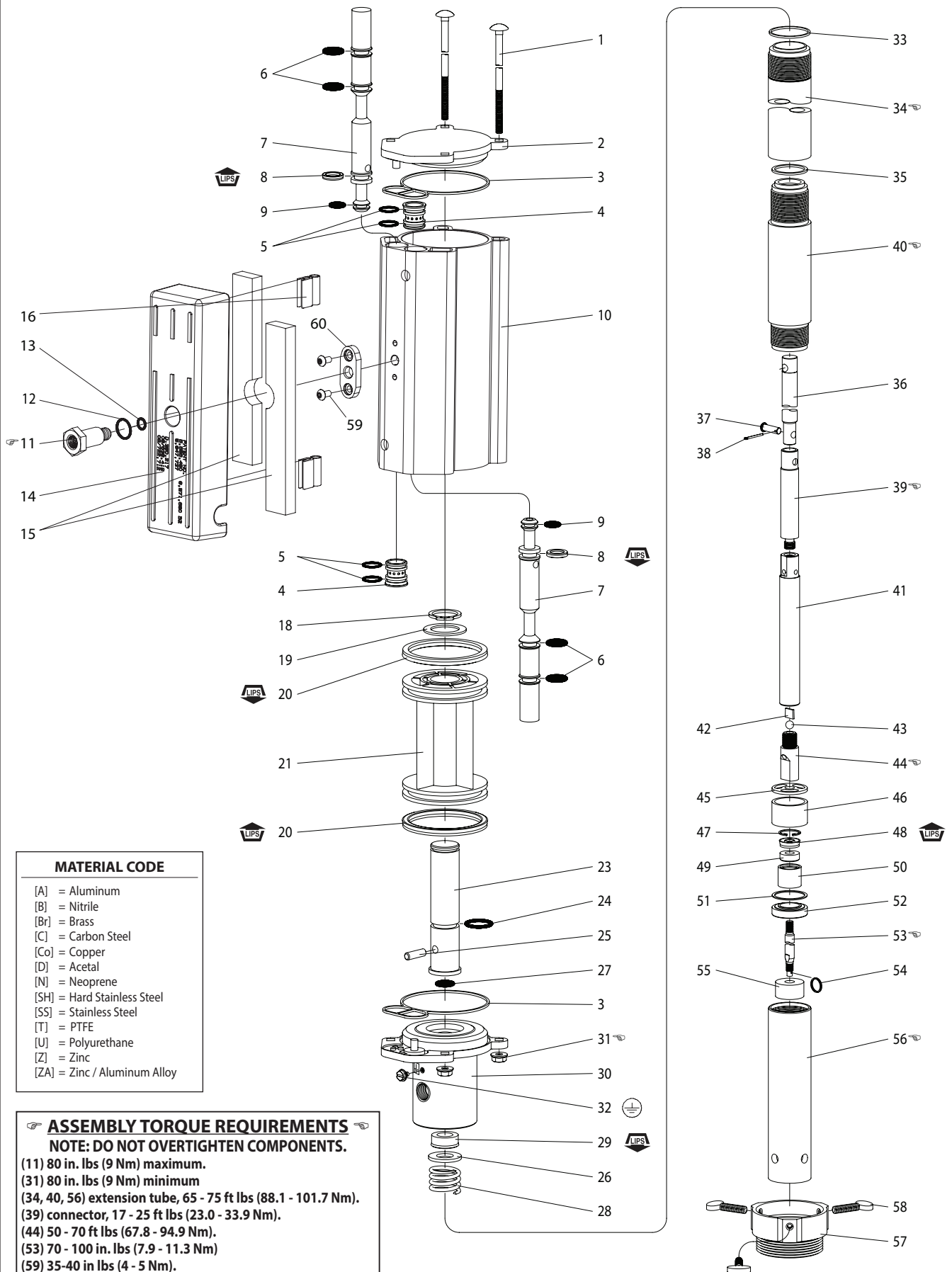


Figure 2

## PUMP DISASSEMBLY

**NOTE:** All threads are right hand. Refer to figure 2 (page 3). Disconnect air supply and relieve all system pressure prior to servicing. Carefully remove the parts, inspect for damage, nicks or excessive wear and determine if any parts will need replacement.

1. Using a 7/8" wrench, unthread and remove (11) adapter, containing (12 and 13) "O" rings, releasing (14) muffler housing.
2. Loosen the screws (59), remove plate (60).
3. Using a 7/16" wrench, remove (31) nuts.
4. Remove four (1) bolts, (2) upper cap and (3) gasket.
5. Remove (10) cylinder, containing (4) sleeves and (7) spools.
6. Using (1) bolt, push (7) spools and (4) sleeves out "sleeve" end of (10) cylinder.
7. Remove (18) retaining ring, (19) washer and (21) piston.
8. Remove (25) dowel pin, releasing (23) piston adapter.
9. Remove (3) gasket.
10. Clamp (34) extension tube horizontally in a vise. Unthread and remove (30) base, (33) gasket, (28) spring and (26) washer.  
**NOTE:** Remove (29) rod seal only if replacement is necessary.
11. Pull up on (36) piston rod to reveal (38) cotter pin.
12. Remove (38) cotter pin and (37) connecting pin, releasing (36) piston rod.
13. Using (36) piston rod, push down on (39) connector until it bottoms.
14. Remove (54) retainer ring.
15. Push (55) primer up into (56) primer tube.
16. Lightly wedge a flat blade screwdriver between (55) primer and (56) primer tube, so (55) primer unthreads with (56) primer tube.
17. Insert a 5/16" diameter rod thru the cross holes in (56) primer tube and use the rod to unthread and remove (56) primer tube.
18. Remove (46) spacer, (51) gasket and (52) valve seat from (56) primer tube.
19. Remove (47 - 50) foot valve assembly from (53) primer rod.
20. Remove (47) retaining ring, releasing (48) "U" cup. **NOTE:** Do not remove (49) guide spacer unless replacement is necessary.
21. Remove (45) guide washer.
22. Clamp (40) lower suction tube horizontally in a vise. Unthread and remove (34) extension tube and (35) gasket.
23. Using a 7/32" diameter rod in the cross hole in (39) connector and a 9/16" wrench on the flats of (41) plunger, unthread and remove (39) connector from (41) plunger. **NOTE:** Do not damage the OD of (41) plunger in any way.
24. Using a 7/16" wrench on flats of (44) adapter and a 1/4" wrench on flats of (53) primer rod, unthread and remove (53) primer rod.
25. Clamp on flats of (41) plunger and, using a 1/4" wrench on flats of (44) adapter, unthread and remove (44) adapter, releasing (43) ball and (42) ball stop.

## PUMP REASSEMBLY

**NOTE:** Thoroughly clean and lubricate all seals and bores with Shell Shell Gadus S2 U1000 upon assembly. Replace all soft parts with new ones included in the repair kit. **Note:** Refer to the illustration (figure 2, page 3) for "U" cup lip seal direction.

1. Assemble (42) ball stop and (43) ball into (41) plunger, securing with (44) adapter. **NOTE:** Torque (44) adapter to 50 - 70 ft lbs (67.8 - 94.9 Nm).
2. Assemble (53) primer rod to (44) adapter, using wrenches on flats to tighten. **NOTE:** Torque (53) primer rod to 70 - 100 in. lbs (7.9 - 11.3 Nm).
3. Thread (39) connector to (41) plunger, using a 7/32" diameter rod thru the cross hole to tighten. **NOTE:** Tighten (39) connector to 17 - 25 ft lbs (23.1 - 33.9 Nm).

4. Assemble (49) guide spacer and (48) "U" cup into (50) valve body, securing with (47) retaining ring. **NOTE:** Assemble chamfered corner of (49) guide spacer into (50) valve body first.
5. Assemble (45) guide washer and (47 - 50) foot valve assembly onto (53) primer rod.
6. Assemble (46) spacer, (51) gasket and (52) valve seat onto (53) primer rod.
7. Thread (55) primer onto (53) primer rod, securing with (54) retainer ring.
8. Thread (56) primer tube to (40) lower suction tube and tighten. **NOTE:** Torque (56) primer tube to 65 - 75 ft lbs (88.1 - 101.7 Nm).
9. Assemble (36) piston rod to (39) connector, securing with (37) connecting pin and (38) cotter pin.
10. Assemble (35) gasket and (34) extension tube to (40) lower suction tube and tighten. **NOTE:** Torque (34) extension tube to 65 - 75 ft lbs (88.1 - 101.7 Nm).
11. Assemble (27) "O" ring, (29) rod seal, (26) washer, (28) spring and (33) gasket into (30) base and assemble (30) base to (34) extension tube. Clamp (30) base horizontally in a vise and tighten (34) extension tube. **NOTE:** Torque (34) extension tube to 65 - 75 ft lbs (88.1 - 101.7 Nm).
12. Push up on (55) primer, exposing (36) piston rod.
13. Assemble (3) gasket to (30) base.
14. Assemble (24) "O" ring to (23) piston adapter and assemble (23) piston adapter to (36) piston rod, securing with (25) dowel pin.
15. Replace (20) "U" cups on (21) piston and assemble (21) piston onto (23) piston adapter, securing with (19) washer and (18) retaining ring.
16. Replace (5) "O" rings on (4) sleeves and assemble (4) sleeves into (10) cylinder. **NOTE:** Assemble each sleeve into the end of the cylinder nearest the exhaust hole.
17. Replace (6 and 9) "O" rings and (8) "U" cups on (7) spools and assemble (7) spools into (10) cylinder from the opposite end as the (4) sleeve went in.
18. Assemble (10) cylinder onto the pump, being careful when sliding over the lips of (20) "U" cups. **NOTE:** Be sure (3) gasket is seated properly.
19. Replace (3) gasket on (2) upper cap and assemble (2) upper cap to (10) cylinder.
20. Assemble (1) bolts to pump, securing with (31) nuts. **NOTE:** Torque (31) nuts to 80 - 90 in. lbs (9.0 - 10.2 Nm).
21. Replace plate (60) on cylinder (10) and tight the screws (59).
22. Replace (12 and 13) "O" rings on (11) adapter.
23. Assemble (15) foam liners and (16) edge trims to (14) muffler housing.
24. Assemble (14) muffler housing to (10) cylinder, securing with (11) adapter. **NOTE:** Torque (11) adapter to 70 - 80 in. lbs (7.9 - 9.0 Nm).

## TROUBLE SHOOTING

Pump problems can occur in either the air motor section or the lower pump end section. Use these basic guidelines to help determine which section is affected. Be sure to eliminate any possible non-pump problems before suspecting pump malfunction.

**Pump will not cycle or will not deliver material.**

- Be certain to check for non-pump problems, including kinked, restrictive or plugged inlet / outlet hose or dispensing device. Depressurize the pump system and clean out any obstructions in the inlet / outlet material lines.
- Check all seals, including track gaskets.
- Check direction of "U" cup lips.
- Remove (58) circlip. Take out (57) grease filter and clean. Re-install (57) grease filter inside (56) primer tube and retain by installing (58) circlip.