

OPERATOR'S MANUAL

TP0443X4XXXXXXXXXX

INCLUDING: OPERATION, INSTALLATION AND MAINTENANCE.

RELEASED: 7-26-24

(REV: A)

INCLUDE MANUALS: AF0443XXXXXXXX-XX-X Extrusion Pump (97999-1501), 66731-X Follower Plate (pn 97999-213), 67347-X Follower Assembly (pn 97999-1102), 67486-X Follower Plate (pn 97999-1809), 67487-X Follower Plate (pn 97999-1810), RM0725-XXX-XX Two Post Lift / Ram (pn 97999-1707), and S-636 General Information (pn 97999-636).

4-1/4" AIR MOTOR

43:1 RATIO

4" STROKE

TWO POST RAM PACKAGE

16 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.
- **104217** for repair of P39124-120 filter / regulator.
- **104453** for repair of P39344-110 filter / regulator.
- **637466** for repair of lift / ram seals.
- **63729X-P4X** for repair of 6710X-P4X lower pump section.

MODEL DESCRIPTION CHART

TP 04 43 X 4 XXXXX XX X	
Package TP - Two Post	
Air Motor Size 04 - 4-1/4"	
Pump Ratio 43 - 43:1	
Check Type / Wetted Materials S - Chop Check / Carbon Steel T - Chop Check / Stainless Steel	
Mount Style 4 - 16 gallon (120 lbs)	
Lower Pump End Options Refer to pump model operator's manual	
Follower Assembly E1 - 67486-2 EC - 66731 E3 - 67486-1 A7 - 67347-2 E5 - 67486-3 A8 - 67347-1 S2 - 67487-1 T7 - 67347-12 EA - 66731-1 T8 - 67347-11 EB - 66731-2	
Package Option 0 - None-Basic Control for Ram only 2 - Advanced Ram and Pump Controls	

TP0443X4XXXXXXXXXX RAM PACKAGE

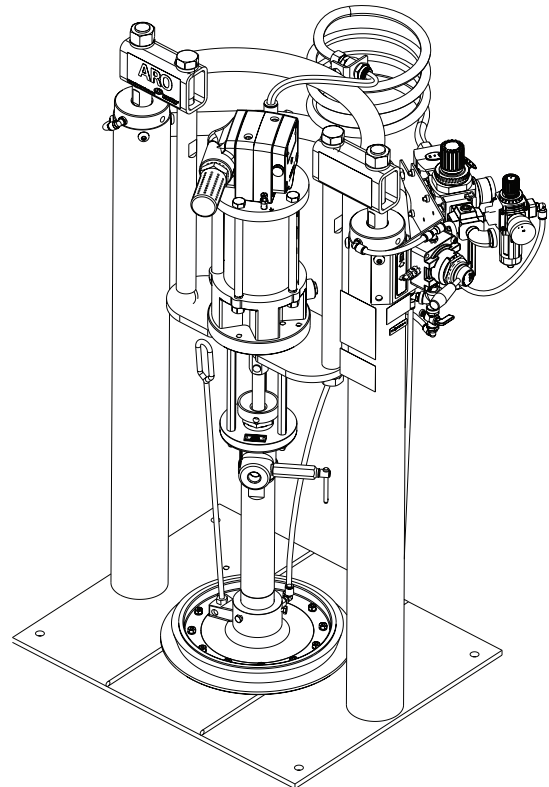


Figure 1

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INSTALLATION

The TP0443X4XXXXXXX 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 3 of RM072S-XXX-XX Two Post Lift / Ram Operator's Manual.

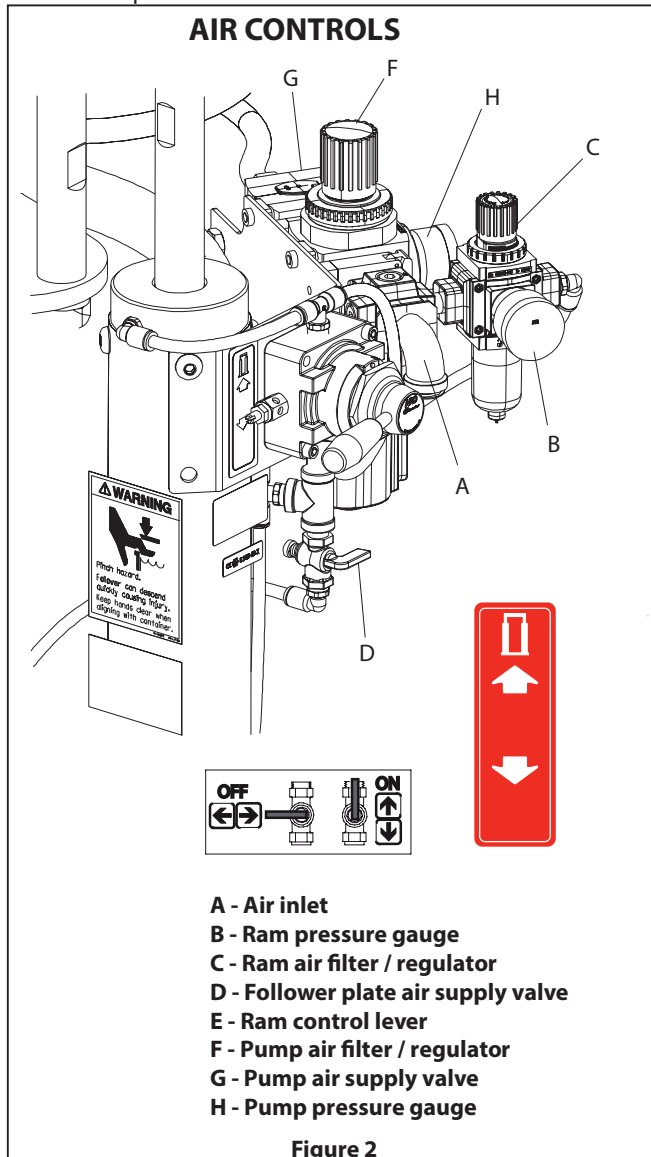


Figure 2

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 RM072S-XXX-XX Two Post Lift / Ram Operator's Manual.
2. Connect the air supply (125 psig / 8.6 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 16 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. **NOTE:** Make certain the grease is compatible with the material being dispensed.
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 RM072S-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 RM072S-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. 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.

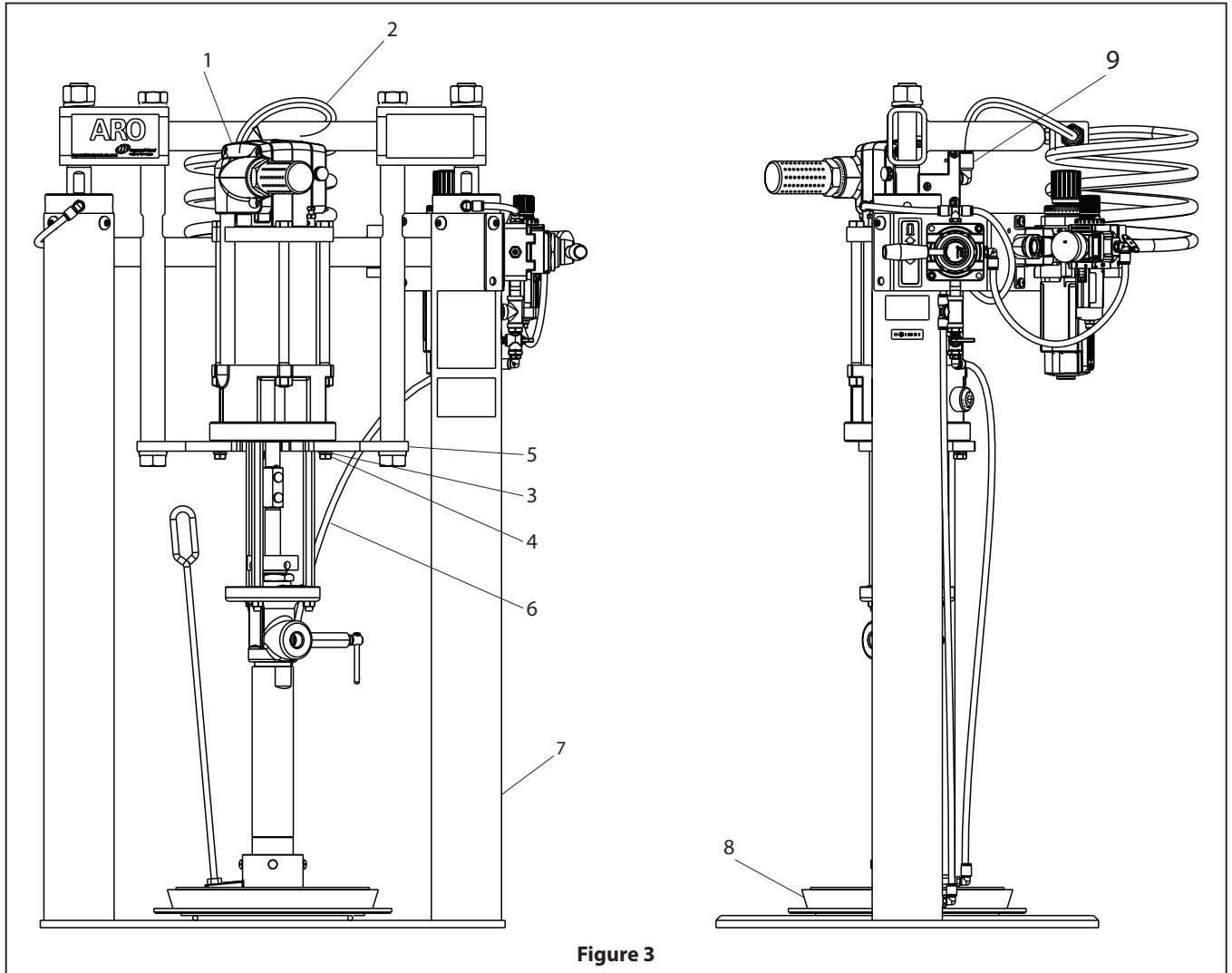
TO CHANGE THE DRUM:

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

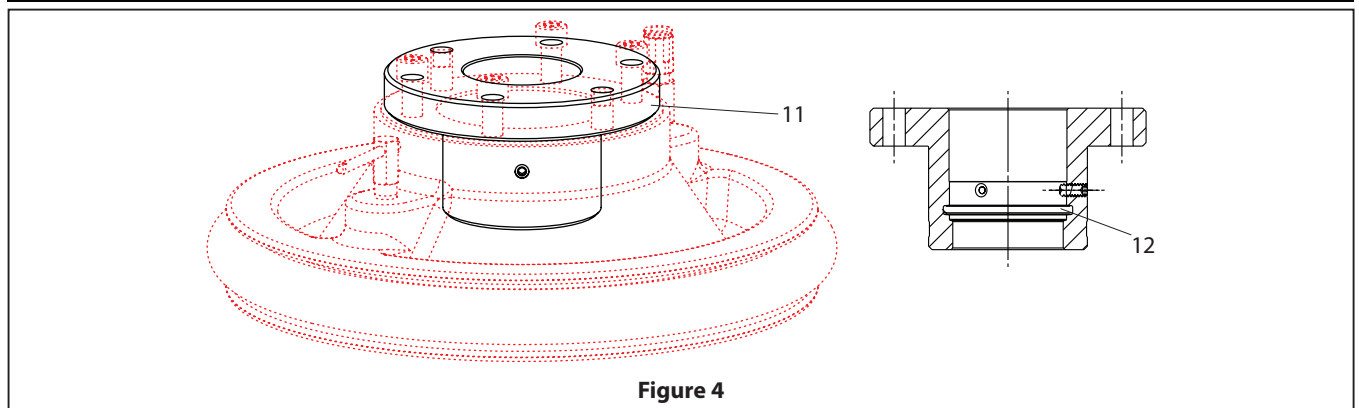
1. To avoid damage, **DO NOT OVER PRESSURIZE THE DRUM.**
2. Open the follower plate supply valve to allow air under the follower plate.
3. Shift the control valve lever to the "up" position.
4. Place and center a new drum into position. Remove the cover.

PARTS LIST / TP0443X4XXXXXXX

Item	Description (size)	Qty	Part No.	Item	Description (size)	Qty	Part No.
1	Pump Assembly	(1)	AF0443X2XXXXX	8	Follower Assembly (see model description on page 4)	(1)	
2	Tubing (1/2" OD x 18")	(1)	94978-(①)	* 9	90° Male Fitting (1/2 NPT x 1/2" OD)	(1)	59756-362
3	Lock Washer (3/8")	(3)	Y14-616-C	10	Wet-Sol "Plus" (1 quart) (not shown)	(1)	66333-B
4	Cap Screw (3/8" - 16 x 1-1/2")	(3)	Y6-67-C	①	Bulk Tubing (1/2" OD x 100')	(1)	94978-100
5	Mounting Plate	(1)	96737	②	Bulk Tubing (5/16" OD x 100')	(1)	94980-100
6	Tubing (5/16" OD x 30")	(1)	94980-(②)	* Included with RM0725-XXX-XX			
7	Two-Post Lift / Ram	(1)	RM0725-XXX-XX				



PARTS LIST / TP0443X4XXXXXXX



Item	Description (size)	Qty	Part No.	Material
11	Adapter (models TP0443X4XXXXXAXX only)	(1)	67446	Aluminum
	(models TP0443X4XXXXXTXX only)	(1)	67447	PTFE Coated Aluminum
12	O Ring	(1)	Y325-227	Nitrile

MODEL DESCRIPTION / FOLLOWER PLATE OPTIONS

Model	Pump Size	Follower Plate Material	Seal Type	Seal Material	Seal Diameter	Follower Asm.
TP0443X4XXXXXA7X	Standard Footprint "A" with 67446 or 67447 Adapter	Aluminum	Single Tube	EPR	11.440" (290.6 mm)	67347-2
TP0443X4XXXXXA8X				Nitrile		67347-1
TP0443X4XXXXXT7X		Aluminum with PTFE Coating		EPR		67347-12
TP0443X4XXXXXT8X				Nitrile		67347-11
TP0443X4XXXXXE1X	Slip-On "C"	Carbon Steel, Electroless Nickel Coating	Single Lip	Nitrile / Polyethylene	11.614" (295.0 mm)	67486-2
TP0443X4XXXXXE3X				Polyurethane / Polyethylene	11.437" (290.5 mm)	67486-1
TP0443X4XXXXXE5X				Nitrile / Polyethylene	12.281" (311.9 mm)	67486-3
TP0443X4XXXXXEAX			Double Lip	Polyurethane	11.609" (294.9 mm)	66731-1
TP0443X4XXXXXEBX				EPR		66731-2
TP0443X4XXXXXECX				Nitrile		66731
TP0443X4XXXXXS2X		Stainless Steel	Single Lip	PTFE coated Nitrile / Polyethylene	11.437" (290.5 mm)	67487-1

DIMENSIONAL DATA

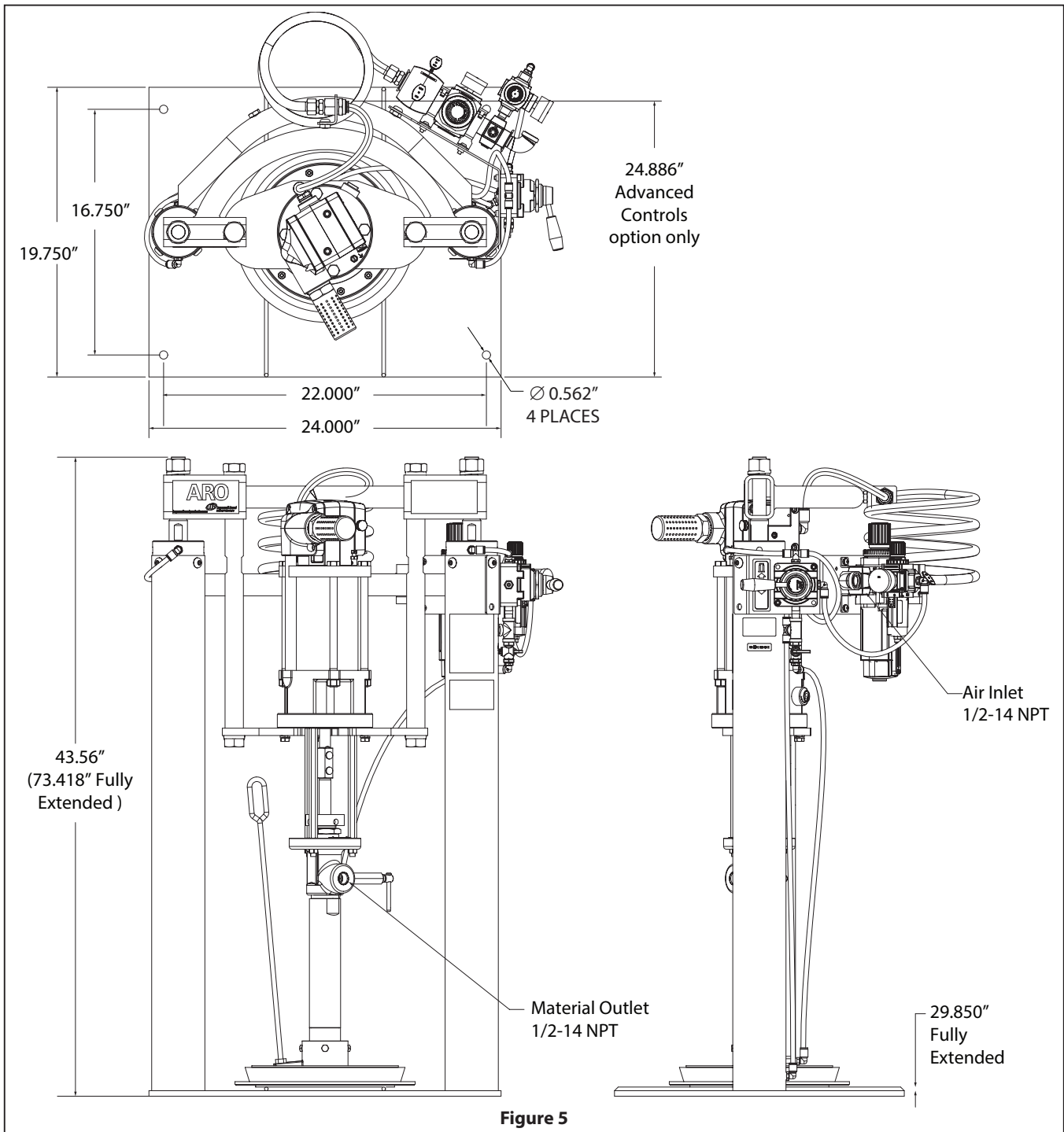


Figure 5