

# OPERATOR'S MANUAL

# 650925-X-B

SPECIFICATIONS, SERVICE KITS, GENERAL INFORMATION, TROUBLESHOOTING  
INCLUDE MANUALS: 6695X-X LOWER PUMP END (PN 97999-002), 67147 HYDRAULIC MOTOR (PN 97999-705) &  
FORM 3638-2 GENERAL INFORMATION MANUAL (PN 97999-353)

RELEASED: 8-1-97  
REVISED: 6-4-10  
(REV. B)

**2.062 SQ." HYDRAULIC MOTOR**  
**0.3:1 RATIO**  
**6" STROKE**

## 650925-X-B FOUR BALL PUMP SERIES 400 SERIES STAINLESS 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.

### SERVICE KITS

- Use only genuine ARO® replacement parts to assure compatible pressure rating and longest service life.
- **637315** for repair of Hydraulic Motor section.
- **637230-X43** for repair of Lower Pump section.  
Refer to the chart on page 2 for description of -XXX options.

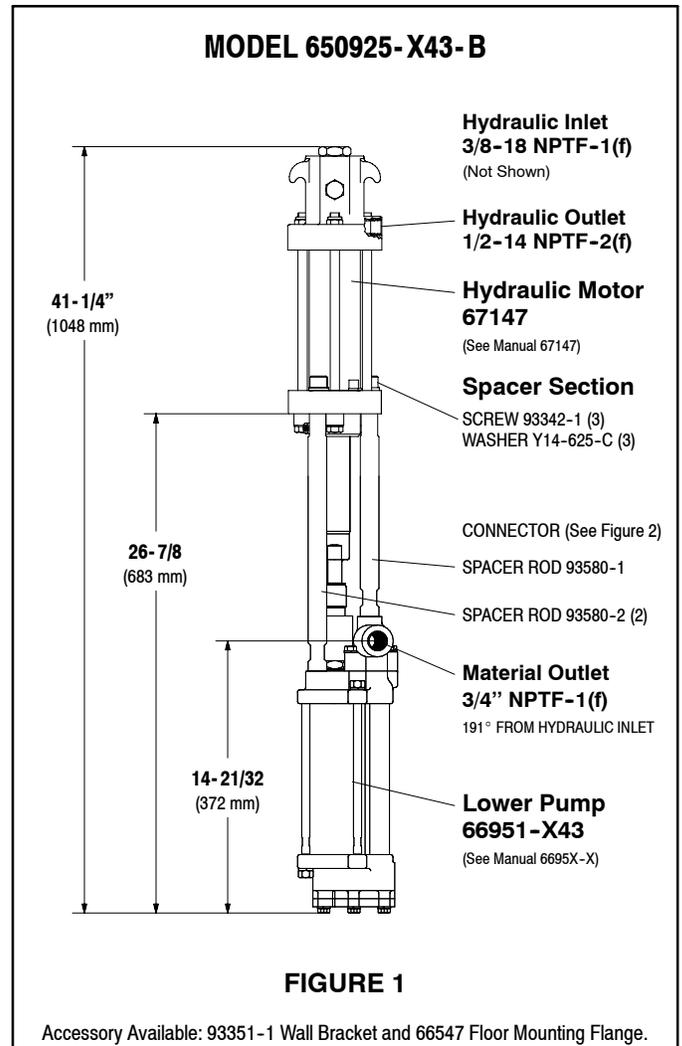
### SPECIFICATIONS

Model Series (Refer to option chart)	650925-X43-B
Type	Hydraulically Operated, Four Ball
Ratio	0.3:1
Hydraulic Motor	67147
Motor Repair Kit	637315
Motor Size	2.062 sq." (13.3 sq. cm)
Stroke	6"
Hydraulic Inlet	3/8" - 18 NPTF-1(f)
Hydraulic Return	1/2" - 14 NPTF-1(f)
Lower Pump End Series	66951-X43
Lower Pump Repair Kit	637230-X43
Material Inlet	N/A
Material Outlet	3/4" NPTF-1 (f)

### PERFORMANCE

Hydraulic Inlet Pressure Range	50 - 1200 psi (3.4 - 83 bar)
Fluid Pressure Range	15 - 360 psi (1 - 25 bar)
Required H-power @ 50 cpm	3.2 @ 1200 (83 bar)
Hydraulic flow req'd @ 50 cpm	8.7 gpm (32.9 lpm)
Max. Rec'd Cycles / Minute	50
Displacement In <sup>3</sup> Per Cycle	82.172
Volume / Cycle	45.5 oz. (1346 ml)
Cycles Per Gallon	2.8
Flow @ 50 Cycles / Minute	17.8 gpm (67 lpm)
Noise Level	N/A
Maximum Temperature Limit	130° F (54° C)

### PUMP DATA



### IMPORTANT

- This is one of the four documents which support the pump.  
Replacement copies of these forms are available upon request.
- 650925-X-B MODEL OPERATOR'S MANUAL
  - GENERAL INFORMATION - INDUSTRIAL PISTON PUMPS
  - 6695X-X LOWER PUMP END OPERATOR'S MANUAL
  - 67147 HYDRAULIC MOTOR OPERATOR'S MANUAL

INGERSOLL RAND COMPANY LTD

209 NORTH MAIN STREET - BRYAN, OHIO 43306

☎ (800) 495-0276 • FAX(800) 892-6276

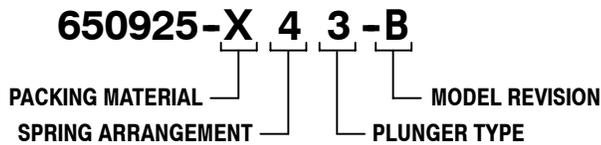
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# ARO

**IR** Ingersoll Rand  
Industrial Technologies

# PUMP OPTION DESCRIPTION CHART



<b>PACKING MATERIAL</b> (PACKINGS ARE UPPER AND LOWER UNLESS NOTED)	
7 GLASS FILLED PTFE (UPPER)	P UHMW-PE / PTFE STAG'D (UPPER)
VIRGIN PTFE (LOWER)	UHMW-PE (LOWER)
C UHMW-PE	R PTFE / UHMW-PE STAG'D (UPPER)
F UHMW-PE / LEATHER STAG'D (UPPER)	PTFE (LOWER)
UHMW-PE (LOWER)	
<b>SPRING ARRANGEMENT</b>	
4 MULTIPLE WAVE SPRING	
<b>PLUNGER TYPE</b>	
3 HD SS W/HD CHROME PLATING	

## GENERAL DESCRIPTION

**⚠ WARNING** HAZARDOUS PRESSURE. Do not exceed maximum operating pressure of 360 psi (25 bar) at 1200 psi (83 bar) inlet hydraulic pressure.

**PUMP RATIO X INLET PRESSURE TO PUMP MOTOR = MAXIMUM PUMP FLUID PRESSURE**

Pump ratio is an expression of the relationship between the pump motor area and the lower pump end area. EXAMPLE: When 150 p.s.i. (10.3 bar) inlet pressure is supplied to the motor of a 5:1 ratio pump it will develop a maximum of 750 p.s.i. (52 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** Refer to general information sheet for additional safety precautions and important information.

- The Four-Ball pumps are primarily designed for the high volume transfer of light and medium viscosity fluids compatible with 400 series stainless steel. The lower pump is designed for easy priming and the double acting feature is standard in all ARO industrial pumps. Material is delivered to the pump discharge outlet on both the up and down stroke.
- The motor is connected to the lower pump end by a spacer section. This allows for lubrication of the upper packing gland and prevents motor contamination because of normal wear and eventual leakage through the material packing gland. Be sure the solvent cup is adequately filled with lubricant to protect the upper packings and insure longest service life.

## TROUBLE SHOOTING

Pump problems can occur in either the Hydraulic Motor Section or the Lower Pump End Section, use these basic guidelines to help determine which section is affected.

### If the pump will not cycle.

- Be certain to first 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.
- Refer to the motor manual for trouble shooting if the pump does not cycle and / or hydraulic fluid leaks from the hydraulic motor.

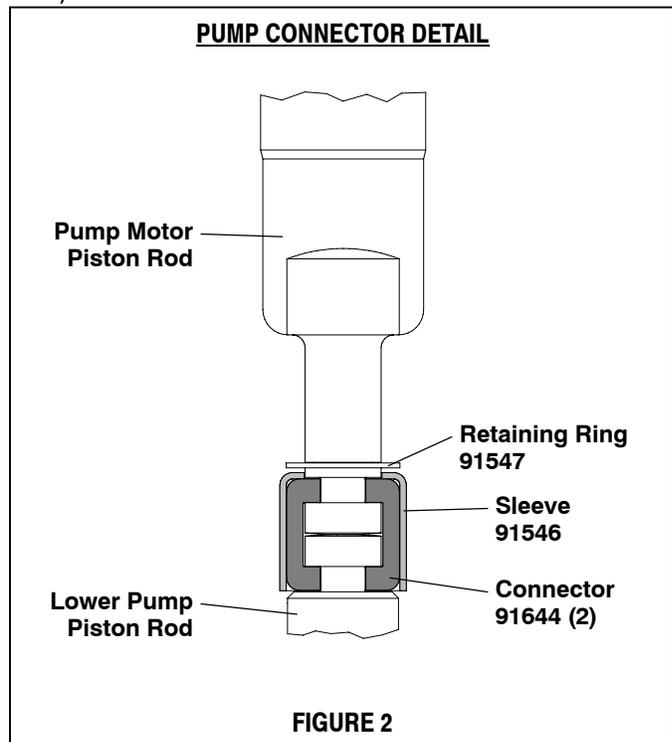
### If the pump cycles but does not deliver material.

- Refer to the lower pump end manual for further trouble shooting.

## PUMP CONNECTION - UPPER / LOWER

**NOTE: All threads are right hand.**

- Lay the pump assembly on a workbench.
- Remove the three screws and washers from the three spacer rods (see figure 1).
- Pull the hydraulic motor from the lower pump end until motor piston rod is in the "down" position and lower pump end rod is in "up" position.
- Using e-ring pliers, slide the retaining ring up far enough to allow the sleeve to move upward and release the two connectors (see figure 2).



**FIGURE 2**

### REASSEMBLY

- Align the pump motor with the lower pump end.
- Install the two connectors and retain with the sleeve, slide the retaining ring back into position.
- Reinstall the spacer rods to the pump motor.
- Bring the motor and lower pump together and retain with the three screws and washers.