

# OPERATOR'S MANUAL

# 6712X-X

SPECIFICATIONS, SERVICE KITS, GENERAL INFORMATION, TROUBLESHOOTING

INCLUDE MANUALS: 6710X-X LOWER PUMP END (PN 97999-600) &  
S-632 GENERAL INFORMATION MANUAL (PN 97999-624)

RELEASED: 2-9-95  
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(REV. D)

**4-1/4" AIR MOTOR**  
**43.6:1 RATIO**  
**4" STROKE**

## EXTRUSION PUMP

**67120-P4X**      **67121-P4X**      **67124-P4X**  
(Carbon Steel)    (Stainless Steel)    (Carbon 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.
- **61268 for repair of Air Motor section.**  
Service Note: The Air Motor Service / Parts Manual is not shipped with the pump but it is included with each service kit. If this Service / Parts Information is needed, request the Air Motor Operator's Manual from ARO (manual 6544X-X, PN 97999-064).
- **63729X-P4X for repair of Lower Pump section.**  
Refer to the chart on page 2 for description of -P4X options.

### SPECIFICATIONS

<b>Model Series</b> (Refer to option chart)	6712X-P4X
<b>Type</b>	Air Operated, Extrusion, Double Acting Pump
<b>Ratio</b>	43.6:1
<b>Air Motor</b>	65440
<b>Motor Repair Kit</b>	61268
<b>Motor Diameter</b>	4-1/4" (10.8 cm)
<b>Stroke</b>	4" (10.2 cm)
<b>Air Inlet (female)</b>	1/2 - 14 N.P.T.F. - 1
<b>Air Exhaust (female)</b>	1-1/4 - 11-1/2 N.P.T.F. - 1
<b>Lower Pump End Series</b>	
models 67120-P4X	67100-P4X
models 67121-P4X	67101-P4X
models 67124-P4X	67100-P4X
<b>Lower Pump Repair Kit</b>	63729X-P4X
<b>Material Outlet (female)</b>	1/2 - 14 N.P.T.F. - 1

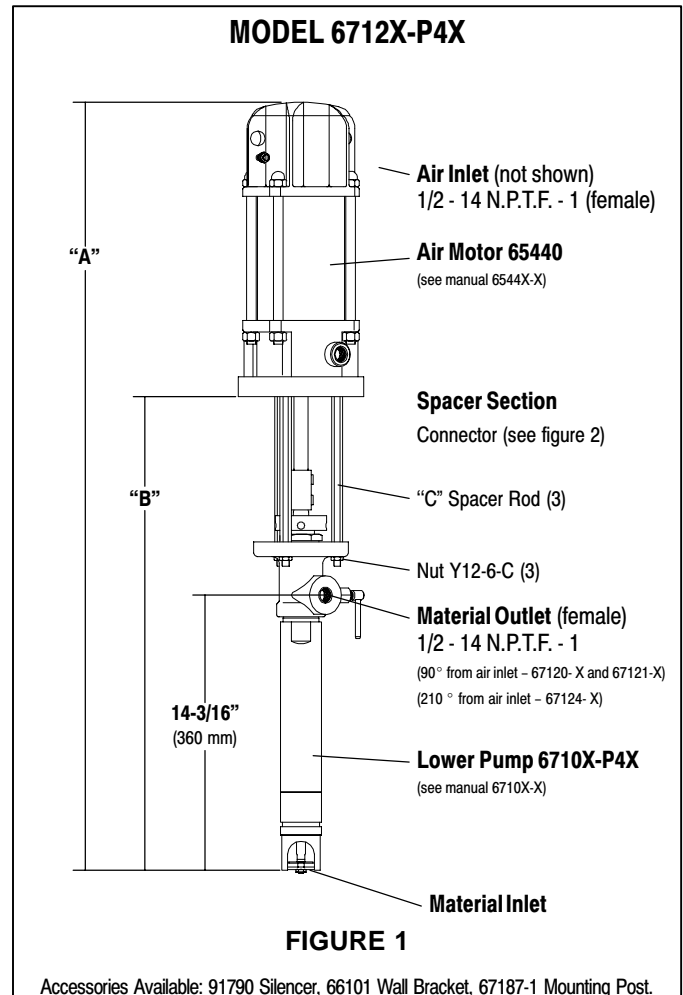
### PERFORMANCE

<b>Air Inlet Pressure Range</b>	0 - 150 p.s.i. (0 - 10.3 bar)
<b>Fluid Pressure Range</b>	0 - 6549 p.s.i. (0 - 451.7 bar)
<b>Max. Rec'd Cycles / Minute</b>	60
<b>Displacement In<sup>3</sup> Per Cycle</b>	2.85
<b>Volume / Cycle</b>	1.6 oz. (46.7 ml)
<b>Cycles Per Gallon</b>	81
<b>Flow @ 60 Cycles / Minute</b>	0.74 g.p.m. (2.8 l.p.m.)
<b>Noise Level @ 60 P.s.i. - 40 C.p.m.</b> ①	80.0 db(A) ②

① Tested with 91790 silencer installed.

② The pump sound pressure level has been updated to an Equivalent Continuous Sound Level (L<sub>Aeq</sub>) to meet the intent of ANSI S1.13-1971, CAGI-PNEUROP S5.1 using four microphone locations.

### PUMP DATA



MODEL	"A" (mm)	"B" (mm)	"C"
67120-P4X	39-5/8" (1006.6)	24-7/16" (620.8)	93962
67121-P4X	39-5/8" (1006.6)	24-7/16" (620.8)	93962
67124-P4X	48-17/32" (1232.6)	33-11/32" (846.9)	93962-2

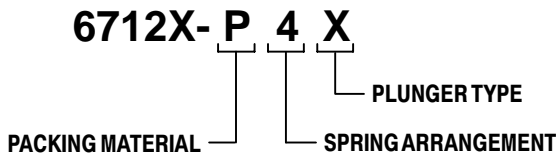
### IMPORTANT

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

- 6712X-X MODEL OPERATOR'S MANUAL
- GENERAL INFORMATION - INDUSTRIAL PISTON PUMPS
- 6710X-X LOWER PUMP END OPERATOR'S MANUAL
- 6544X-X AIR MOTOR OPERATOR'S MANUAL



# PUMP OPTION DESCRIPTION CHART



## PACKING MATERIAL (PACKINGS ARE UPPER AND LOWER UNLESS NOTED)

P UHMW-PE / Glass Filled Teflon staggered (upper)  
UHMW-PE (lower)

## SPRING ARRANGEMENT

4 Multiple Wave Spring

## PLUNGER TYPE

3 Hardened Stainless Steel with Hard Chrome Plating  
8 Hardened Stainless Steel with Alternate Piston

## GENERAL DESCRIPTION

**⚠ WARNING HAZARDOUS PRESSURE.** Do not exceed maximum operating pressure of 6549 p.s.i. (451.7 bar) at 150 p.s.i. (10.3 bar) inlet air 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 4:1 ratio pump it will develop a maximum of 600 p.s.i. (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** Refer to general information sheet for additional safety precautions and important information.

- The Chop - Check pumps are primarily designed for the pumping of heavy viscous material with or without fibrous content. The models can be used with a gravity feed single post lift as a topper type assembly or with a two post lift as a force feed type assembly. 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 air 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 air leaks from the air 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 nuts from the three spacer rods (figure 1).
- Pull the air motor from the lower pump end until motor piston rod is in the “down” position and lower pump end rod is in “up” position.
- Unscrew the three “C” spacer rods from the air motor assembly.
- Remove the two Y15-22-S cotter pins and remove the two 93985 pins. Remove the 93960-( ) connector.

### PUMP CONNECTOR DETAIL

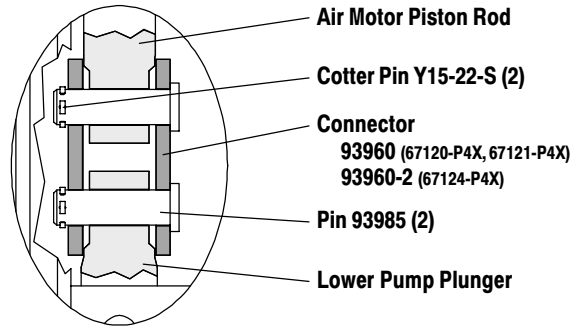


FIGURE 2

### REASSEMBLY

- Align the lower pump end plunger with the air motor piston rod. NOTE: Models 67120-X and 67121-X - Position the air inlet of the air motor 90° from the material outlet (see figure 1). Models 67124-X - Position the air inlet of the air motor 210° from the material outlet.
- Position the 93960-( ) connector in place and insert the two 93985 pins into the connector. Use the two Y15-22-S cotter pins to retain the pins.
- Screw the three “C” spacer rods into the air motor base.
- Align the holes in the lower pump body with the three “C” spacer rods and slide into the holes. Retain using the three nuts.

