

## ARO Ram Change-Over Procedures:

These steps will instruct you on how to properly change-over an empty container when using an ARO Piston Pump. These steps are applicable with Single-Post Rams that use 5-gallon pails and Two-Post Rams that use 55-gallon drums.

### Step 1:

Close off the air supply to the pump. Relieve air pressure by closing the Lock-Out Valve on the Ram Assembly and adjusting the Piggyback air pressure to ZERO. Relieve fluid pressure in the system by opening the downstream dispense valve / gun.

Step 2: Open the Follower Plate Air Supply Valve that sends air underneath the Follower Plate. Wait ten to 15-seconds for air to accumulate under the Follower.

Step 3: Close the Follower Plate Air Supply Valve and lift the hand lever on the M512LR Ram Control Valve. This should lift the Pump and Follower out of the empty drum.

Step 4: If the drum starts to lift with the Ram, put the M512LR Ram Control Valve back in the middle position and open the Follower Plate air Supply Valve. This will inject more air under the Follower.

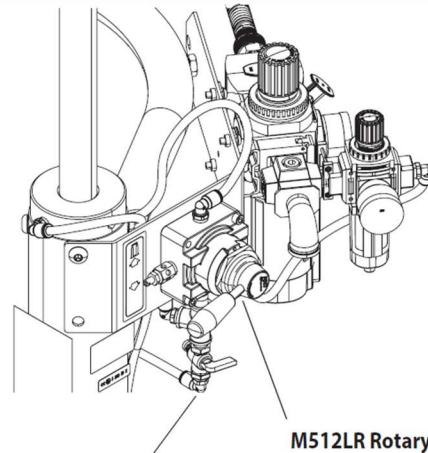
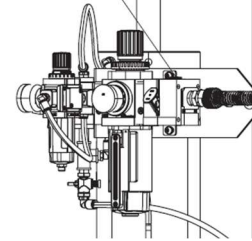
Step 5: After ten to 15-seconds, close the Follower Plate Air Supply Valve and lift the hand lever on the M512LR Ram Control Valve. This will allow the Follower to lift out of the drum.

Repeat the process until the Follower is ready to lift out of the empty drum.

Step 6: As the Follower reaches the top of the empty drum, close the Follower Plate Air Supply Valve and let the Ram fully lift the Pump and Follower.

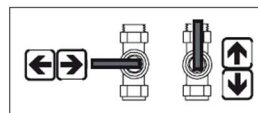
After removing the old drum, clean the follower plate and seals of any debris or material that has begun to harden

Lock-Out Valve



M512LR Rotary Valve

Follower plate air supply valve



Step 4: Place the new fluid container under the Follower. Push down on the Ram Control Valve hand lever and begin lowering the Pump into the container. Properly align the Pump with the container. Make sure your hands are free of the drum and follower.

If there is a liner within the drum, make sure it is clear of the Follower and will not block the pump inlet or prohibit the Follower from entering the drum.



Step 5: Remove the T-Handle from the Follower. As the Follower enters the drum, air will be pushed from the Vent Plug Assembly. When air no longer bleeds from the Vent, and is replaced by material, place the Ram Control Valve in neutral. Replace the T-Handle into the Vent Plug Assembly.



Step 6: Open the Lock-Out Valve and slowly increase air flow to the Pump. Push down on the Ram Control Valve hand lever and the Pump will slowly begin to prime. If your pump has a Bleed Valve in the Pump Body, open the valve and allow air to purge from the Pump. When the air has been evacuated, close the Bleed Valve.

If your pump does not have a Bleed Valve, open a downstream dispense valve and slowly allow the pump to cycle.

Once all the air has been expelled, you may increase the air pressure to the Pump Motor.

