

**4.125 SQ." MOTOR
65 - 2000 P.S.I. RANGE**

67314-B HYDRAULIC POWER MOTOR



**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.

637450 pump repair kit, includes the necessary soft parts for normal service of the entire pump.

SPECIFICATIONS

Models	67314-B
Type	Hydraulic Operated Power Motor
Motor Size	4.125 sq." (26.6 sq. cm)
Stroke	6" (152 mm)
Hydraulic Inlet (female)	1/2 - 14 N.P.T.F. - 2
Hydraulic Outlet (female)	3/4 - 14 N.P.S.M.
Pump Construction	Carbon Steel
Dimension "A"	20-13/32" (518.2 mm)
Dimension "B"	15-11/16" (397.8 mm)
"C" Weep Hole	1/8 - 27 N.P.T.F. - 1
Motor Diameter	8" (203.2 mm)
Maximum Temperature Limits	130° F (54° C)
Mounting Bracket available	95933
Weight	37.75 lbs (17.1 kgs)

PERFORMANCE

Inlet Pressure Range	65 - 2000 p.s.i. (4.5 - 137.9 bar)
Required H-power @ 50 c.p.m.	3.2 @ 1200 (82.8 bar)
Hydraulic flow required @ 50 c.p.m.	11 g.p.m. (41.6 l.p.m.)
Maximum Thrust generated	8250 lbs
Maximum recommended cycles / minute	50
Noise Level	N/A

GENERAL DESCRIPTION

The 4.125 square inch hydraulic motor is a general purpose power unit and is used on many ARO industrial 2-ball, 4-ball and chop-check pumps. It utilizes tie rod type construction for serviceability and connects to the various lower pump ends by tie rods.

Due to frictional losses in the system, a greater horsepower is required to run the motor. Power supplies generating less than shown as required in the Performance Specifications above will work with the motor but at a reduced pressure or cycle rate.

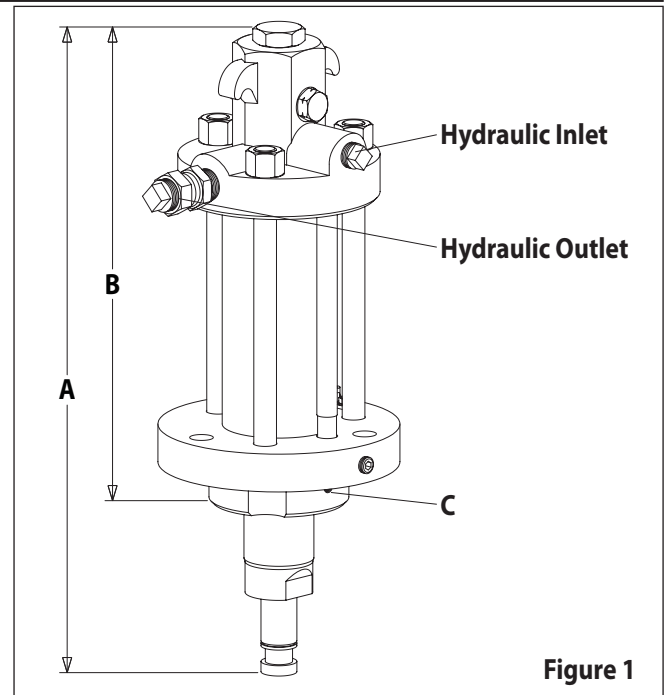


Figure 1

OPERATING AND SAFETY PRECAUTIONS

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

⚠ 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.

⚠ WARNING A pressure relief valve must be used to prevent over-pressurization of the system and possible component rupture.

⚠ WARNING Excessive hydraulic oil temperature can cause fire. The unit is rated for operation up to 130° F (54° C). Be sure return lines are sized larger than supply lines and similarly pressure rated.

⚠ WARNING Never service or disassemble the unit or unit components without relieving hydraulic system pressure first. The high pressures involved could cause serious injury.

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.

A replacement warning label is available upon request, pn \ 94576.

PARTS LIST / 67314-B

Item	Description (size)	(Qty)	Part No.
1	Top Plug	(1)	94549
✓ 2	"O" Ring (3/32" x 1-3/16" o.d.)	(1)	Y330-120
✓ 3	Nut (1/4" - 28)	(3)	94794
4a	Spool	(1)	94551
4b	Sleeve	(1)	94552
✓ 5	Ball (0.3750" diameter)	(2)	Y16-112
✓ 6	Spring	(2)	96611
✓ 7	"O" Ring (3/32" x 11/16" o.d.)	(2)	Y330-112
8	Trip Plug	(2)	96610
9	Cylinder Head	(1)	95866
✓ 10	"O" Ring (3/32" x 3-7/16" o.d.)	(2)	Y330-152
11	Sleeve Washer	(1)	94553
12	Retaining Ring	(1)	Y147-18
13	"O" Ring (3/32" x 1-3/4" o.d.)	(3)	Y330-129
14	Piston Screw	(1)	95869
15	Piston	(1)	95870
✓ 16	Wear Ring	(1)	95871
✓ 17	Seal	(1)	95872
18	Trip Rod	(1)	96626
19	Trip Washer	(2)	96627
20	Trip Spring	(1)	94558
✓ 21	"O" Ring (1/16" x 2-1/4" o.d.)	(1)	Y325-34
22	Piston Rod	(1)	95873
23	Cylinder	(1)	95867
✓ 24	"O" Ring (3/32" x 1-7/8" o.d.)	(1)	Y330-131

INSTALLATION

Use only flexible tubing for inlet and outlet porting to hydraulic source to prevent wear of components.

Be sure return lines are sized larger than supply lines and similarly pressure rated.

Inspect the system hoses frequently for wear or damage and, if necessary, replace them immediately. Never plug hose leaks with your finger, tape or any similar devices.

- **Do not use PTFE tape on the inlet and outlet port fittings. Loctite® 571 pipe thread sealant or equivalent is the recommended sealant.**
- **Tighten the inlet and outlet fittings to 50 - 70 ft lbs (67.8 - 94.9 Nm).**

SERVICE

NOTE: The 67314-B hydraulic motor will contain about one pint of hydraulic fluid. Drain this fluid before attempting any disassembly.

NOTE: Do not disassemble this motor except in a clean area. Any dust or dirt contamination of this assembly will shorten the service life of this motor and other system components.

NOTE: All power supply pumps should have a ten micron filter on the return line and a 100 mesh filter on the inlet. Failure to maintain filters will shorten service life of this motor and other system components.

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Item	Description (size)	(Qty)	Part No.
25	Piston Rod Adapter	(1)	95875
26	Motor Base	(1)	95868
27	Plug (1/4 - 18 N.P.T.F.)	(1)	Y227-3-L
✓ 28	Polypack Rod Seal	(1)	95903
29	Bushing	(1)	95904
✓ 30	Wiper	(1)	95905
31	Seal Retainer	(1)	95874
✓ 32	"O" Ring (1/16" x 5/8" o.d.)	(2)	Y330-14
✓ 33	Back-up Ring	(2)	Y118-14
34	Hydraulic Tube	(1)	94563
35	Washer (49/64" i.d. x 1-1/4" o.d. x 1/16")	(3)	F15-9-C
36	Hex Cap Screw (3/4" - 16 x 1")	(3)	95876
37	Nut (3/4" - 16)	(3)	96272
✓ 38	Spring Follower	(2)	96609
39	Pipe Plug (1/2 - 14 N.P.T.)	(1)	Y17-13-C
40	Pipe Plug (3/4 - 14 N.P.T.)	(1)	Y17-14-C
41	Screw (1/4" - 14 x 1/2")	(1)	Y334-104-C
42	Ground Lug	(1)	93004
43	Cap Screw (3/8" - 24 x 1-1/2")	(6)	Y157-64
44	Swivel Union (3/4 - 14 N.P.T.F. - 1 male x 3/4 - 14 N.P.S.M. female)	(1)	75367
45	Retaining Ring	(1)	Y145-4
	Temperature Label (not shown)	(1)	94574
✓	Included in Service Kit		637450

TROUBLE SHOOTING

If the 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.

Motor is running beyond recommended temperature operating conditions.

- Hydraulic oil cooling system is not working.
- Piston seals are worn, replace seals.

Leakage from weep hole in retainer.

- Detection of rod seal wear, when the amount this exceeds is 5 cc / day, replace wiper and rod seal.
- Preventive maintenance issue, consult the factory for recommendations.

Motor stalls at fully retracted or extended position.

- Insufficient pressure to motor (65 p.s.i. / 4.5 bar minimum).
- Springs need to be replaced.
- Valve is damaged, service hydraulic motor.

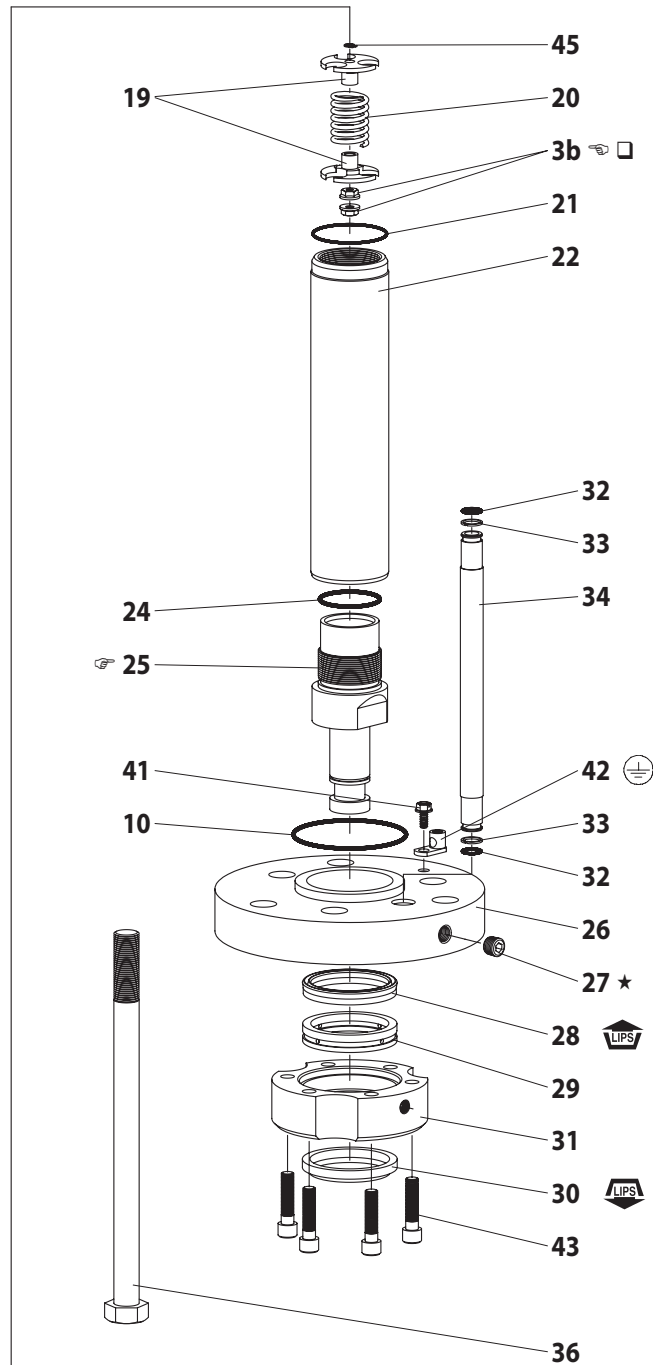
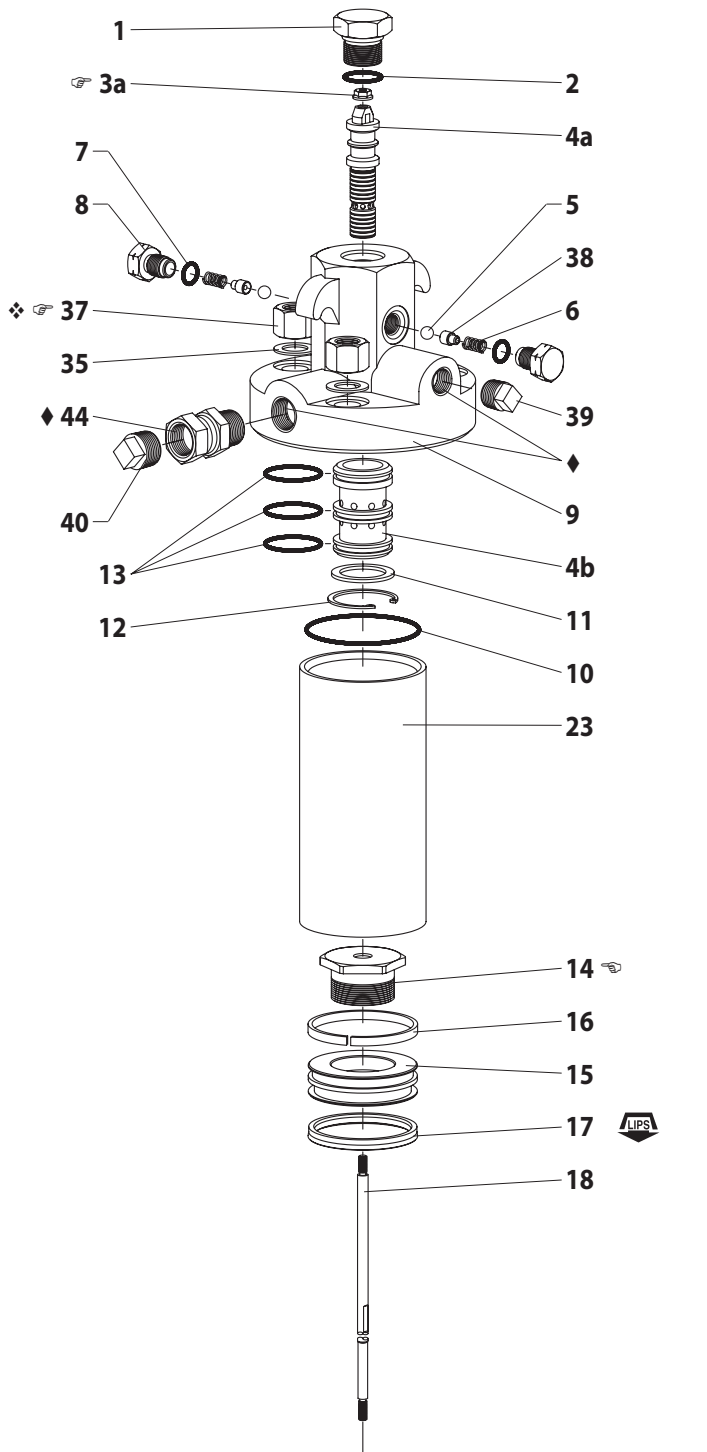


Figure 2

TORQUE REQUIREMENTS

NOTE: DO NOT OVERTIGHTEN FASTENERS.

- (3a, 3b) 90 - 110 in. lbs (10.2 - 12.4 Nm).
- (14) 100 - 120 ft lbs (135.6 - 162.7 Nm).
- (25) 100 - 120 ft lbs (135.6 - 162.7 Nm).
- (37) 44 - 56 ft lbs (59.7 - 75.9 Nm).

LUBRICATION / SEALANTS

- ◆ Apply Loctite 571 pipe thread sealant or equivalent.
- ★ Apply Loctite 572 sealant to threads.
- ❖ Apply Loctite 271 to the middle 7 - 9 threads.
- ◻ See reassembly instruction step #5.

DISASSEMBLY

All threads are right hand. Refer to figure 2, page 3. These procedures are for the installation of repair kit parts. **Disconnect power supply and relieve all system pressure prior to servicing.** Carefully remove the parts, inspect parts for damage, nicks or excessive wear and determine if any parts will need replacement.

1. Remove (1) top plug and remove (2) "O" ring.
2. Remove (8) trip plug and remove (5) ball, (38) spring follower, (6) spring and (7) "O" ring.
3. Move piston rod to the fully retracted position and pull (4a) spool out of (4b) sleeve through the top.
4. Using the flats on (18) trip rod to hold, remove and discard (3a) nut. **DO NOT RE-USE.** The trip rod wrench flats are only accessible through the port holes that retain the (8) trip plug. This will require a narrow width open-end wrench.

NOTE: Be very careful when removing the spool from the valve. The finish of this part is critical for proper motor performance. Any nicks, scratches or dirt may damage the set.

5. Remove (43) cap screws.
6. Slide (31) seal retainer, (29) bushing and (30) wiper off (22) piston rod and (25) piston rod adapter.
7. Remove (37) tie rod nuts and (35) washers.
8. Clamp (9) cylinder head and remove (26) motor base by tapping with a soft hammer, then remove (10) "O" ring and (28) polypack rod seal.
9. Remove (34) hydraulic tube from (9) cylinder head and remove (32) "O" rings and (33) back-up rings.
10. Remove (22) piston rod assembly and (23) cylinder from (9) cylinder head and remove (10) "O" ring.
11. Separate (22, 17, 21, 16, 15, 14) piston rod assembly from (23) cylinder.
12. Remove (17) seal and (16) wear ring from (15) piston.
13. If further disassembly is required, such as removal of (22) piston rod, (4) valve spool assembly, or (45, 20, 19, 18) shifter assembly, see next section. (Order "O" rings separately.)

Removal of (4) sleeve and spool assembly.

14. Remove (12) retaining ring and (11) sleeve washer from (9) cylinder head. Push the (4b) sleeve carefully down through the (9) cylinder head using a soft faced tool.

NOTE: The finish of the upper face of the sleeve is critical for intended operation. Any nicks or scratches may damage the entire (4) set.

Removal of (22) piston rod.

15. Place the (22, 21, 17, 16, 15, 14) piston rod assembly in a vertical position with the (25) piston rod adapter in a heavy vise.

NOTE: Never clamp on the (22) piston rod.

16. Grip the flats on the (14) piston screw and unthread.
17. Remove (21) "O" ring from (22) piston rod.
18. Remove the (18, 19, 20, 45) trip rod assembly.
19. Using the flats on the (18) rod, remove and discard the two (3b) nuts. **DO NOT RE-USE.**

REASSEMBLY

Thoroughly clean and lubricate all seals. Replace all soft parts with new ones included in the repair kit.

1. Install (28) rod seal and (10) "O" ring into (26) motor base.
2. Install (30) wiper into (31) seal retainer and slip in (29) bushing.
3. Slide (25, 22) piston rod assembly into (26) motor base and retainer assembly from step #2 above.
4. Insert (21) "O" ring onto (22) piston rod and place (15) piston on it.
5. Assemble (45) retaining ring, (19) trip washer, (20) trip spring and (19) trip washer to (18) trip rod, securing with one (3b) nut. **NOTE: Orient the two (3b) nuts such that the flanges are facing each other.** NOTE: (3b) nut to be hand tight. While holding (18) trip rod on flats, assemble (3b) nut to (18) trip rod and tighten to 90 - 110 in. lbs (10.2 - 12.4 Nm).
6. Place (18, 19, 20, 45, 3b) shifter assembly into (22) piston rod and thread (14) piston screw into (22) piston rod.
7. Torque (14) piston screw to 100 - 120 ft lbs (135.6 - 162.7 Nm) with (25) piston rod adapter in a heavy vise.
8. Put (17) seal and (16) wear ring on (15) piston.
9. Push (22) piston rod to fully extended position and place (23) cylinder over the piston assembly.
10. Seat the (23) cylinder onto the motor base. NOTE: Petroleum jelly is recommended for ease of assembly on all "O" rings and inside the cylinder.
11. Replace the three (13) "O" rings on (4b) valve sleeve.
12. Push (4b) valve sleeve / spool set straight into (9) cylinder head.
13. Place (11) sleeve washer behind (4b) valve sleeve and retain this with (12) retaining ring.
14. Put two (33) back-up rings and two (32) "O" rings onto (34) hydraulic tube with back-up rings on the hydraulic tube first.
15. Push tube assembly (34, 33, 32) into (26) motor base.
16. Place (10) "O" ring on (9) cylinder head, lower (9) cylinder head onto the (23) cylinder and (34) hydraulic tube with the (18) trip rod through the center of the valve.
17. Feed (36) bolts through (26) motor base and apply (35) washers and (37) nuts to the bolts. Tighten fasteners alternately and apply 44 - 56 ft lbs (59.7 - 75.9 Nm). NOTE: Must alternately rundown fasteners to prevent cutting the (10) "O" rings.
18. Assemble (31) seal retainer, retaining with six (43) cap screws.
19. Move piston to the retracted position.
20. Pull (18) trip rod through the head and place the (4a) spool on the trip rod. Using the (3a) nut and the trip rod flats, tighten the (3a) nut to 90 - 110 in. lbs (10.2 - 12.4 Nm).
21. Carefully push the spool / trip rod into the sleeve, creating the (4) valve.
22. Place (2) "O" ring on (1) top plug and tighten in (9) cylinder head.
23. Place (7) "O" ring on (8) trip plug. Place (5) ball in (9) cylinder head and (6) spring and (38) spring follower in (8) trip plug.
24. Thread the (8) trip plug into the (9) cylinder head.

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