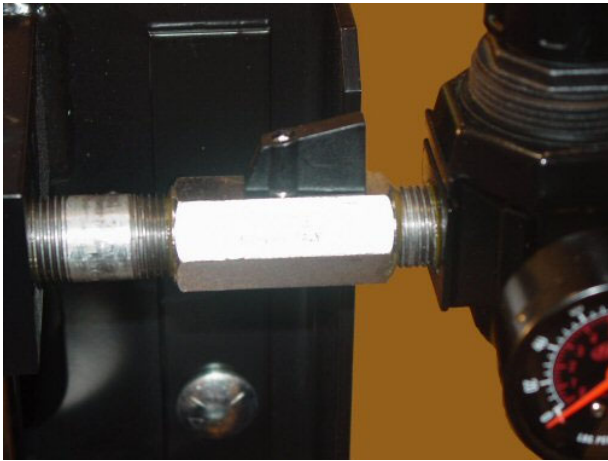


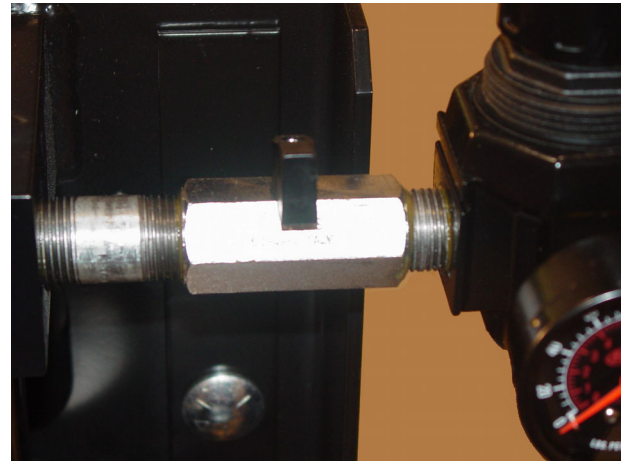
Liquid Control



**Changing a material pail on a
ram feed transfer pump**



Transfer Pump ON position



Transfer Pump OFF position

Turn the transfer pump air supply valve to the OFF position.



Adjust ram air pressure regulator to a low setting. Move the ram control valve to the up position, slowly increase the pressure setting and let the ram rise all the way to the top. Use caution as you raise the ram so you don't pinch the compressed air or grease supply hoses.



Pail Ejector Valve Open



Pail Ejector Valve Closed

Turn the pail ejector valve to the open position. Doing so will force air between the ram plate and empty pail bottom.

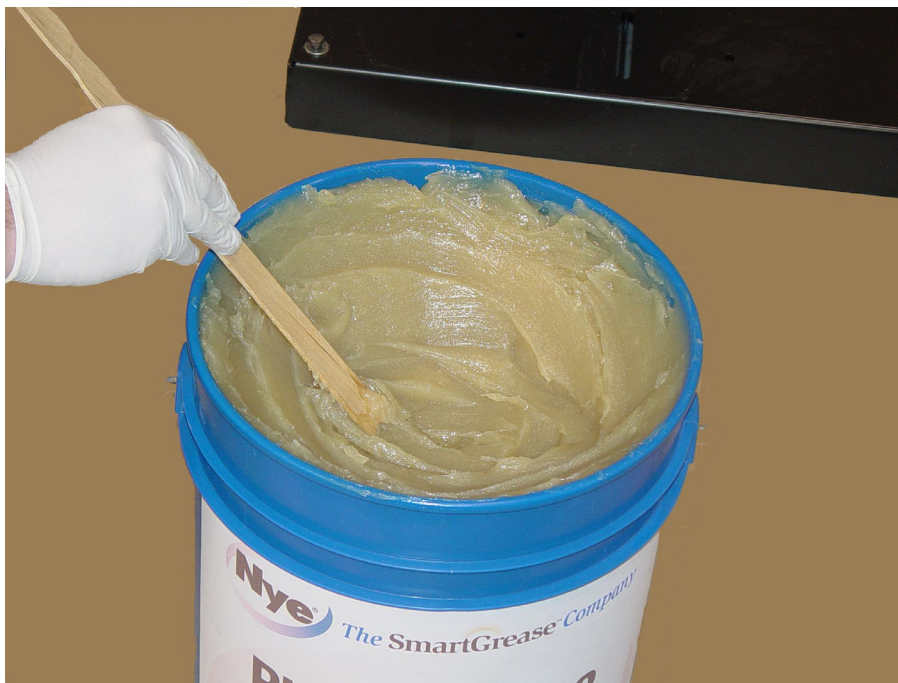
Turn the pail ejector valve to the closed position once the pail has been separated from the follower plate.



Place the new pail near the ram pump.
Clean the ram plate and seal as required.



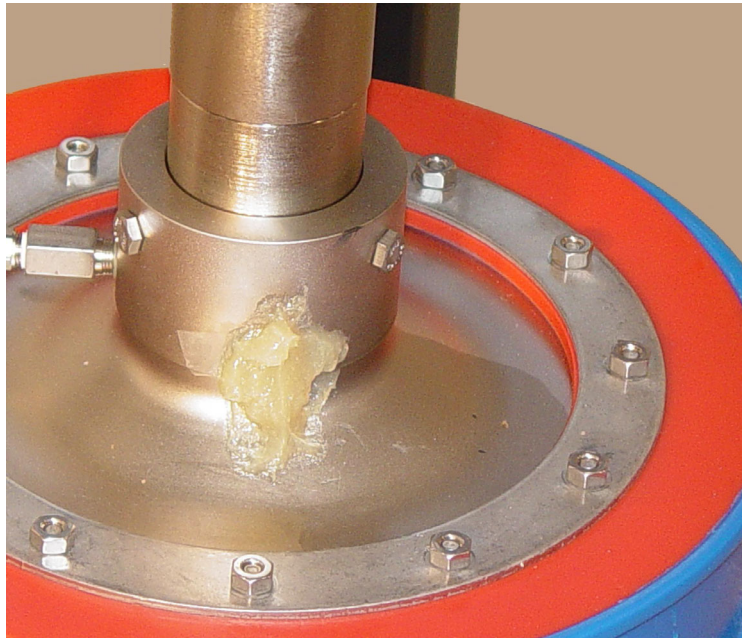
Remove the ram plate bleeder plug.
The ram plate bleeder port will allow the bleeding of air between the ram plate and the grease.



Using a plastic squeegee; concave the grease, transferring the grease from the center of the pail to the sides of the pail. This will allow air to be pushed to the center of the material and out the ram plate bleeder port as the ram plate is pressed into the pail.



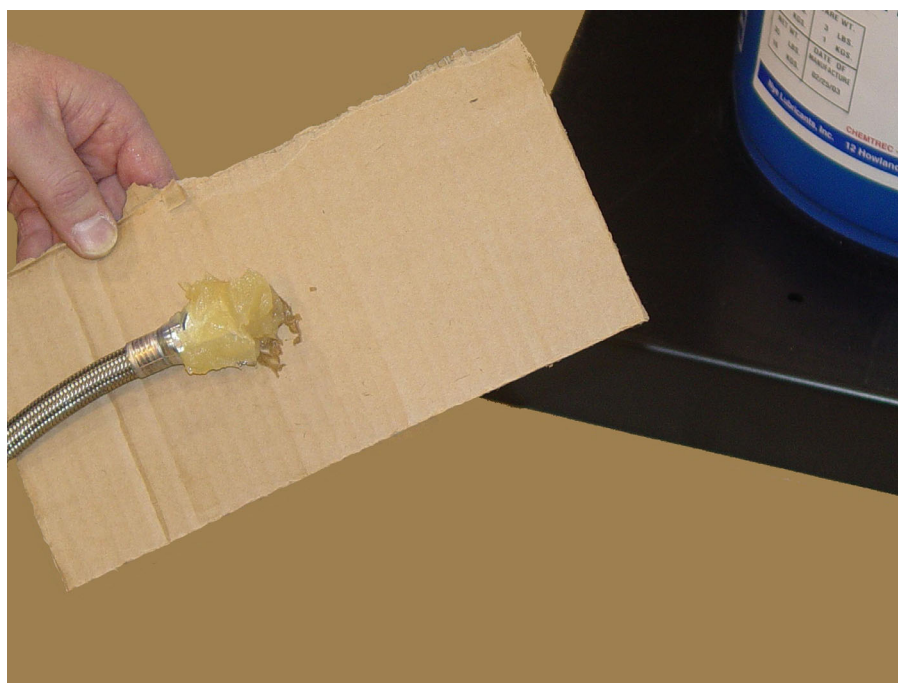
Adjust ram air pressure regulator to a low setting. With the ram plate bleeder plug removed; center the new pail into position under the ram plate. Move the ram pump ram control valve to the down position.



When the ram plate is aligned with the pail, increase the air pressure to the ram until the air/grease purge from the ram plate bleeder port. Reinstall the ram plate bleeder plug when the ram plate is purged of air. *If the ram plug can not be installed due to high material pressure or flow, place the ram control valve to the neutral position (center position) to reduce the pressure on the ram.*



Open the pump tube bleeder valve to purge the pump tube. To tell if the air is completely gone watch the pump shaft movement as it cycles. A smooth pumping action indicates that no air is being compressed. Close the pump tube bleeder valve.



From the end of the material outlet hose or line; cycle the pump slowly. Capture the grease that contains air. When the grease is clear of air, (smooth flow with no sputtering) stop the transfer pump. It is very important to purge the material of air to the dispensing system. Your ram/transfer pump is now ready for operation.