

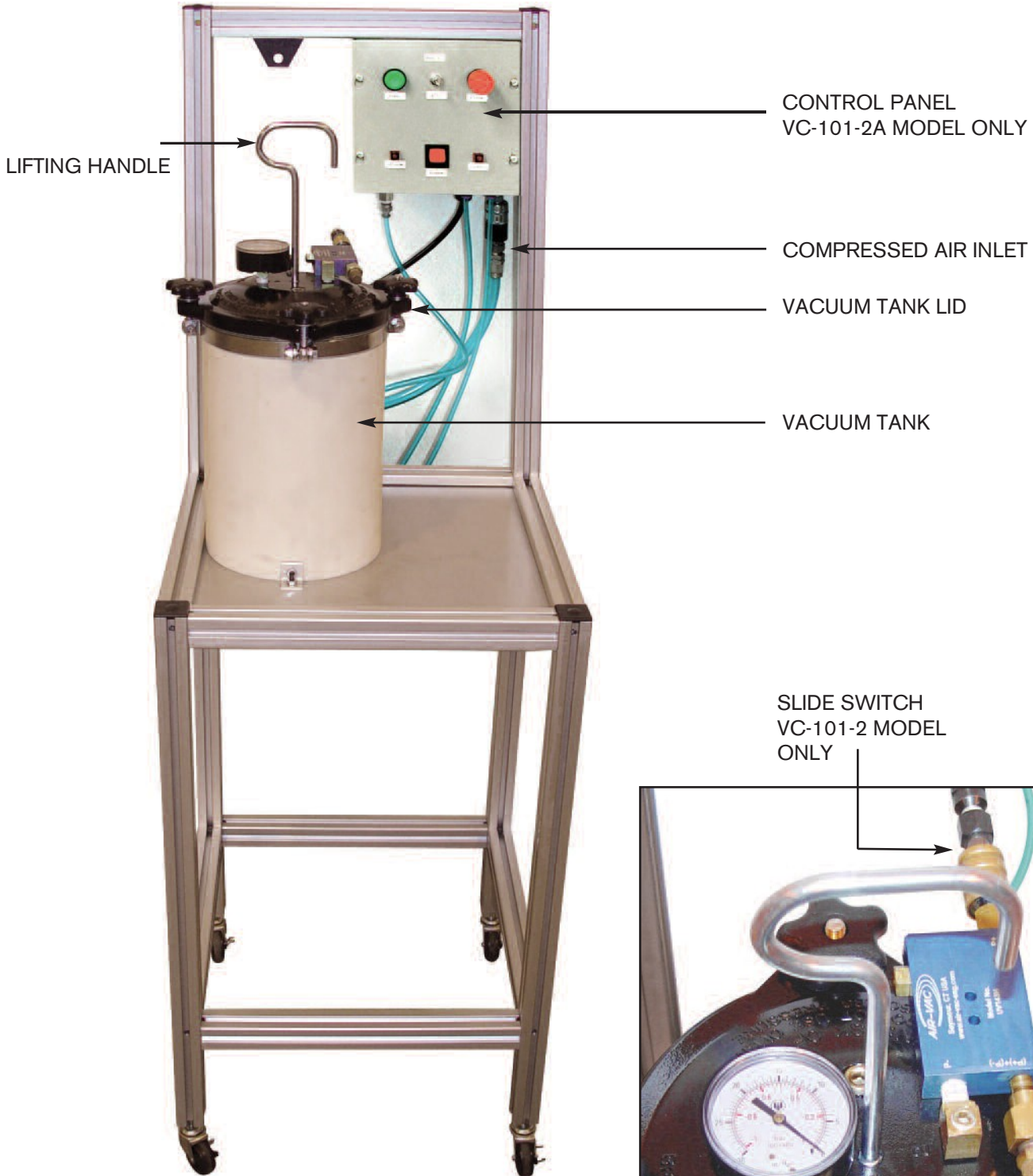


Vacuum Tank
VC-101-2(A)
Operations Manual

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DESCRIPTION AND LAYOUT



PROCEDURES

WARNING:

- Read all instructions before operating this equipment.
- Wear proper protective gear.

AIR PRESSURE:

- 75-80 PSI

ELECTRIC:

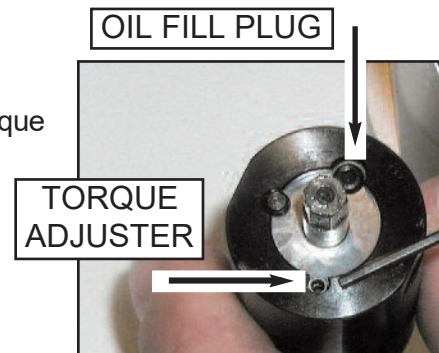
- 5 AMP 110 VAC

SETTING UP VACUUM TANK:

- Connect 3/8" I.D. air hose to air inlet with full flow 3/8" fittings.
- Plug electric cord into surge protected power strip plugged into 110 VAC outlet.
- Turn power switch on.

USING VACUUM FILL SYSTEM:

1. Remove lid from tank.
2. Remove the oil fill plug from the pulse unit and turn torque adjuster all the way out counter-clockwise.
Note: Make sure the driving blade is not blocking the oil fill hole.

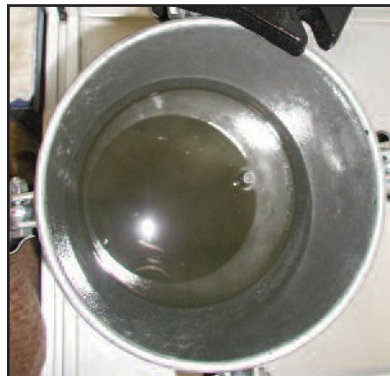


3. Set pulse unit or units into the tank and onto the plate. Note: Make sure the plate is in the raised position.
4. Pour Manufacturer Recommended Hydraulic Pulse Fluid into the tank so that the fluid level is approximately 1 inch (25 mm) from the top of the liner casing being serviced.
Note: Insure that the Manufacturer Recommended Hydraulic Pulse Fluid is stirred vigorously to insure consistency.
5. Put lid back on tank.

STEP 3



STEP 4



PROCEDURES

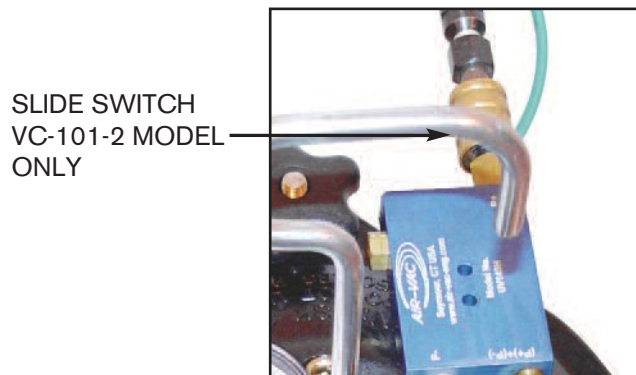
PROCEDURE FOR USING VACUUM FILL TANK SYSTEM

USING VACUUM FILL SYSTEM:

6. If you have the VC-101-2A, with the switch in the *auto* position, push the start button and proceed to step 10.



7. If you have the VC-101-2 slide the slide switch over so the vacuum starts.



8. After ten minutes with the vacuum in the green, lower the plate down into the oil.
9. After 30 seconds with plate lowered, turn the vacuum off. Once the normal air pressure returns, raise the plate on the inside of the tank.
10. Remove the lid from the tank.
11. Remove the excess oil from the top of the Pulse Unit so that the oil is level with the top of the oil fill hole.
12. Draw off the recommended amount of oil from the Pulse Unit and install Oil Fill Plug back into the Pulse Unit.
13. You are now ready to test your tool.

FILL, DRAW, AND TORQUE TABLE

Key Model of this Tool Group	Full Volume of Liner Oil in Pulse Unit (approx.)	Volume to be Removed from the Full Volume (approx.)	Torque to Tighten Liner Casing Setter (approx.)	Torque to Tighten Liner Casing Setter (approx.)	Load to Press on Rear Liner Plate	Load to Press on Rear Liner Plate
					Hydraulic Press	P.T.R.F.
Model	cc's	cc's	NM	Ft-Lbs	Tons	Ft-Lbs/Nm
ALPHA-45(S)(D) & 61(D)	5.0	0.45+/-0.05	70+/-5	52+/-4		
ALPHA-50(S)(D) & L61(D)	5.0	0.50+/-0.05	70+/-5	52+/-4		
ALPHA-50MC, 60MC & 70MC	5.0	0.45+/-0.05	70+/-5	52+/-4		
ALPHA-60(S)(D)	6.2	0.55+/-0.05	85+/-5	63+/-4		
ALPHA-70(S)(C)(CH)	8.8	0.80+/-0.1	110+/-5	81+/-4	2	40/54
ALPHA-80	12.0	1.00+/-0.1	135+/-5	100+/-4	2	40/54
ALPHA-80MC & 90MC	6.2	0.55+/-0.05	85+/-5	63+/-4		
ALPHA-90	14.0	1.00+/-0.1	150+/-5	110+/-4	3	60/81
ALPHA-100	19.0	1.70+/-0.1	185+/-10	137+/-7	3	60/81
ALPHA-100MC & 101MC	12.0	0.80+/-0.1	135 +/-5	100+/-4	2	40/54
ALPHA-110MC	12.0	0.95+/-0.1	135+/-5	100+/-4	2	40/54
ALPHA-130	24.0	2.00+/-0.1	185+/-10	137+/-7	3	60/81
ALPHA-130MC	24.0	1.80+/-0.1	185+/-10	137+/-7	3	60/81
ALPHA-140 & 140MC	31.5	2.30+/-0.1	200+/-10	148+/-7	3.5	70/95
ALPHA-160	48.0	2.40+/-0.1	260+/-10	192+/-7	4	80/108
ALPHA-180	48.0	4.80+/-0.1	290+/-10	214+/-7	4	80/108
ALPHA-T40D(S), T42D(S)(P), T45(S)(D)(P), T46(D), T47(S)(D)(P), T50(D) & T52(D)	5.0		70+/-5	52+/-4		
ALPHA-T60(D) & T62(D)(MI)	6.2		85+/-5	63+/-4		
ALPHA-T65(S) & T70(S)(C)(CH)	8.8	0.75+/-0.05	110+/-5	81+/-4	2	40/54
ALPHA-T80	12.0	0.80+/-0.05	135+/-5	100+/-4	2	40/54
ALPHA-T90	14.0	0.95+/-0.05	150+/-5	110+/-4	3	60/81
ALPHA-T100	19.0	1.40+/-0.1	185+/-10	137+/-7	3	60/81
ALPHA-T130	24.0	1.80+/-0.1	185+/-10	137+/-7	3	60/81
ALPHA-T140	31.5	1.90+/-0.1	200+/-10	148+/-7	3.5	70/95
BP-T40 & BP-T50	5.6	0.30+/-0.01	85+/-5	63+/-4	1	20/27
BP-T60	6.2	0.41+/-0.01	85+/-5	63+/-4	1	20/27
U-50EC	5.0	0.15	50+/-5	37+/-4		
U-60EC	8.5	0.35	70+/-5	52+/-4		
U-80EC	9.0	0.40	70+/-5	52+/-4	3	60/81
U-100EC	18.0	0.90	70+/-5	52+/-4	3	60/81
U-300SD, U-310SD, U-350(S)(D)	5.0	0.15	50+/-5	37+/-4		
U-410(S)(D)	8.5	0.35	70+/-5	52+/-4		
U-480, U-501	9.0	0.40	70+/-5	52+/-4	3	60/81
U-610, U-610T	13.0	0.55	70+/-5	52+/-4	3	60/81
U-700, U-700T	18.0	0.90	70+/-5	52+/-4	3	60/81
U-800, U-800T	20.0	1.00	90+/-5	67+/-4	3	60/81
U-900, U-900T	25.0	1.25	100+/-5	74+/-4	3	60/81
U-1000, U-1000T	32.0	1.70	110 +/-5	81+/-4	3	60/81
U-1301, U-1301T	38.0	2.00	120+/-10	89+/-7	4	80/108

FILL, DRAW, AND TORQUE TABLE

Key Model of this Tool Group	Full Volume of Liner Oil in Pulse Unit (approx.)	Volume to be Removed from the Full Volume (approx.)	Torque to Tighten Liner Casing Setter (approx.)	Torque to Tighten Liner Casing Setter (approx.)	Load to Press on Rear Liner Plate	Load to Press on Rear Liner Plate
					Hydraulic Press	P.T.R.F.
Model	cc's	cc's	NM	Ft-Lbs	Tons	Ft-Lbs/Nm
UA-40(S)(D)MC, 400AMC & UA-50(S)(D)MC, 500AMC	7.0	0.35+/-0.1	85+/-5	63+/-4	1.5	30/41
UA-60(S)MC & 600AMC	8.2	0.40+/-0.1	85+/-5	63+/-4	1.5	30/41
UA-70(S)MC & 700AMC	10.3	0.70+/-0.05	110+/-5	81+/-4	2	40/54
UA-80AMC & 800AMC	12.0	0.80+/-0.05	110+/-5	81+/-4	2	40/54
UA-90MC, 90AMC, 900AMC	15.8	0.90+/-0.05	150+/-5	110+/-4	3	60/81
UA-100MC, 100AMC, 1000AMC	21.7	1.50+/-0.1	185+/-5	137+/-7	3	60/81
UA-130MC, 130AMC, 1300AMC	29.4	1.50+/-0.1	185+/-10	137+/-7	3	60/81
UA-150MC	35.7	2.0+/-0.1	200+/-10	148+/-7	3	60/81
UAT-30D(SD)	5.0	0.19+/-0.01	85+/-5	63+/-4	1	20/27
UAT-40(S)(D), UAT-50(S)(D)	5.6	0.26+/-0.01	85+/-5	63+/-4	1	20/27
UAT-60(S)(D)	6.2	0.35+/-0.01	85+/-5	63+/-4	1	20/27
UAT-70(S)	8.8	0.60+/-0.05	110+/-5	81+/-4	2	40/54
UAT-80	12.0	0.80+/-0.05	135+/-5	100+/-4	2	40/54
UAT-90	14.0	0.90+/-0.05	150+/-5	110+/-4	3	60/81
UAT-100	21.5	1.40+/-0.1	185+/-10	137+/-7	3	60/81
UAT-130	24.0	1.40+/-0.1	185+/-10	137+/-7	3	60/81
UAT-150	31.5	2.0+/-0.1	290+/-10	214+/-7	4.5	90/122
UAT-180	39.0	3.8+/-0.1	320+/-10	236+/-7	4.5	90/122
UAT-200	81.5	5.60+/-0.1	320+/-10	236+/-7	4.5	90/122
UBP-65	8.0	0.70+/-0.05	85+/-5	63+/-4	3	60/81
UBP-T40 & T50	5.6	0.35 -0.04	85+/-5	63+/-4	1	20/27
UBP-T60	6.2	0.45+/-0.05	85+/-5	63+/-4	1	20/27
UDBP-T40 & T50	5.6	0.35 -0.04	85+/-5	63+/-4	1	20/27
UDBP-T60	6.2	0.45+/-0.05	85+/-5	63+/-4	1	20/27
UDBP-T70	8.8	0.70+/-0.05	110+/-5	81+/-4	2	40/54
UDBP-TA40	5.6	0.26+/-0.01	85+/-5	63+/-4	1.5	30/41
UDBP-TA50	5.6	0.28+/-0.01	85+/-5	63+/-4	1.5	30/41
UDBP-TA60	6.2	0.37+/-0.01	85+/-5	63+/-4	1.5	30/41
UDBP-TA70(P)	8.8	0.60+/-0.05	110+/-5	81+/-4	2	40/54
UDP-A60MC	5.6	0.30+0.05	85+/-5	63+/-4	1.5	30/41
UDP-A80MC	8.8	0.65+0.05	110+/-5	81+/-4	2	40/54
UDP-TA40	5.6	0.28+/-0.01	85+/-5	63+/-4	1.5	30/41
UDP-TA40D	5.6	0.28+/-0.01	85+/-5	63+/-4	1.5	30/41
UDP-TA50	5.6	0.28+/-0.01	85+/-5	63+/-4	1.5	30/41
UDP-TA50D	5.6	0.28+/-0.01	85+/-5	63+/-4	1.5	30/41
UDP-TA55	6.2	0.37+/-0.01	85+/-5	63+/-4	1.5	30/41
UDP-TA55D	6.2	0.37+/-0.01	85+/-5	63+/-4	1.5	30/41
UDP-TA60	6.2	0.37+/-0.01	85+/-5	63+/-4	1.5	30/41
UDP-TA60D	6.2	0.37+/-0.01	85+/-5	63+/-4	1.5	30/41
UEP-50(D) & 50MC(D)	5.5	0.35+/-0.05	70+/-5	52+/-4	1	20/27
UEP-60(D) & 60MC(D)	6.8	0.55+/-0.05	85+/-5	63+/-4	1	20/27
UEP-70 & 70MC	8.8	0.65+/-0.05	110+/-5	81+/-4	2	40/54
UEP-80 & 80MC	14.0	0.90+/-0.05	150+/-5	110+/-4	3	60/81
UEP-100 & 100MC	19	1.50+/-0.05	185 /-10	137+/-7	3	60/81

FILL, DRAW, AND TORQUE TABLE

Key Model of this Tool Group	Full Volume of Liner Oil in Pulse Unit (approx.)	Volume to be Removed from the Full Volume (approx.)	Torque to Tighten Liner Casing Setter (approx.)	Torque to Tighten Liner Casing Setter (approx.)	Load to Press on Rear Liner Plate	Load to Press on Rear Liner Plate
					Hydraulic Press	P.T.R.F.
Model	cc's	cc's	NM	Ft-Lbs	Tons	Ft-Lbs/Nm
UL-30(D)	5.0	0.31+/-0.01	85+/-5	63+/-4		
UL-40(D), UL-40A(D)MC	5.0	0.35+/-0.01	85+/-5	63+/-4	1	20/27
UL-50(S)(D) & 50(D)MC, UL-40(D)MC, UL-50A(D)MC	5.0	0.45+/-0.05	85+/-5	63+/-4	1	20/27
UL-60(S)(D), 60MC, 60AMC	6.8	0.55+/-0.05	85+/-5	63+/-4	1	20/27
UL-70, UL-70MC, 70AMC	8.0	0.65+/-0.05	110+/-5	81+/-4	2	40/54
UL-80	14.0	0.80+/-0.05	110+/-5	81+/-4	2	40/54
UL-90, UL-90MC, 90AMC, 900AMC	14.0	0.95+/-0.05	150+/-5	110+/-4	3	60/81
UL-100	19	1.50+/-0.05	185+/-10	137+/-7	3	60/81
UL-100MC, 100AMC	21.5	1.60+/-0.1	185+/-10	137+/-7	3	60/81
UL-130	27.0	1.70+/-0.1	185+/-10	137+/-7	3	60/81
UL-130MC, 130AMC	24.0	1.60+/-0.1	185+/-10	137+/-7	3	60/81
UL-150	36.6	2.60+/-0.1	200+/-10	148+/-7	3	60/81
ULT-30 (D)(S)	5.0	0.30+/-0.01	85+/-5	63+/-4	1	20/27
ULT-40(S)(D) & 50(S)(D)(C),	5.6	0.35 -0.04	85+/-5	63+/-4	1	20/27
ULT-60(S)(D)(C)	6.2	0.45+/-0.05	85+/-5	63+/-4	1	20/27
ULT-70(S)(C)(CH)	8.8	0.70+/-0.05	110+/-5	81+/-4	2	40/54
ULT-80	12.0	0.85+/-0.05	110+/-5	81+/-4	2	40/54
ULT-90	14.0	1.00+/-0.05	150+/-5	110+/-4	3	60/81
ULT-100	21.5	1.60+/-0.1	185+/-10	137+/-7	3	60/81
ULT-130	24.0	1.60+/-0.1	185+/-10	137+/-7	3	60/81
ULT-150	31.5	2.20+/-0.1	200+/-10	148+/-7	3.5	70/95
ULT-180	39.0	3.30+/-0.1	260+/-10	192+/-7	4	80/108
UX-450(S)(D)	5.0	0.50+/-0.05	70+/-5	52+/-4		
UX-500(S)(D)(C)	5.0	0.50+/-0.05	70+/-5	52+/-4		
UX-612(S)(D)(C)(A)	6.2	0.65+/-0.05	85+/-5	63+/-4		
UX-622(D)	6.2	0.65+/-0.05	85+/-5	63+/-4		
UX-700(S)(D)(C) & 80EC	8.8	0.80+/-0.1	110+/-5	81+/-4	2	40/54
UX-800(S)(C) & ST800	12.0	0.80+/-0.1	135+/-5	100+/-4	2	40/54
UX-900(S)(C) & 120EC	14.0	0.95+/-0.1	150+/-5	110+/-4	3	60/81
UX-1000(S)(C) & 130EC	19.0	1.50+/-0.1	185+/-10	137+/-7	3	60/81
UX-1300(S), T1300 & TL1300	24.0	1.80+/-0.1	185+/-10	137+/-7	3	60/81
UX-1400	31.5	2.00+/-0.1	200+/-10	148+/-7	3.5	70/95
UX-1620	33.5	2.20+/-0.1	200+/-10	148+/-7	4	80/108
UX-T700, T700L & TL700	8.8	0.70+/-0.05	110+/-5	81+/-4	2	40/54
UX-T800 & TL800	12.0	0.80+/-0.05	135+/-5	100+/-4	2	40/54
UX-T900 & TL900	14.0	0.95+/-0.05	150+/-5	110+/-4	3	60/81
UX-T1000 & TL1000	19.0	1.40+/-0.1	185+/-10	137+/-7	3	60/81
UX-T1400 & TL1400	31.5	1.90+/-0.1	200+/-10	148+/-7	3.5	70/95
UX-T1620 & TL1620	33.5	2.10+/-0.1	200+/-10	148+/-7	4	80/108
UXR-1820(MC)	48.0	3.50+/-0.1	260+/-10	192+/-7	4	80/108
UXR-2000(S)(MC)	84.0	7.00+/-0.2	300+/-10	221+/-7	4	80/108
UXR-2400S(MC)	105.0	11.00+/-0.2	650+/-10	480+/-7	5	100/74
UXR-3000S	185.0	14.00+/-0.2	700+/-10	517+/-7	5	100/74
UXR-T1820 & TL1820	48.0	3.50+/-0.1	260+/-10	192+/-7	4	80/108
UXR-T2000 & TL2000	84.0	6.00+/-0.1	300+/-10	221+/-7	4	80/108
UXR-T2400S	105.0	10.50+/-0.2	650+/-10	480+/-7	5	100/74
UXR-T3000S	185.0	13.50+/-0.2	700+/-10	517+/-7	5	100/74



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