

Open Mold Systems

Proportioners for Gel Coat and Chop Applications



GlasCraft® Dispense Systems

Outstanding performance for gel coat and chop applications

Designed for smooth, accurate gel coat application and precise resin metering, GlasCraft Dispense Systems are engineered to deliver reliable performance.

GlasCraft Gel Coat Systems:

- Dispense pigmented, tooling, low-VOC and specialty gel coats
- Offer reliable, highly accurate catalyst percentage
- Provide high-efficiency performance at low spraying pressures
- Available in internal and external mix configurations

GlasCraft Chopper/Wet-out Systems:

- Dispense polyester resin and vinyl ester chemicals
- Allow for infinite adjustment of the catalyst ratio – no tools required
- Offer reliable, highly accurate catalyst percentage
- Provide high-efficiency performance at low spraying pressures
- Available in internal and external mix configurations



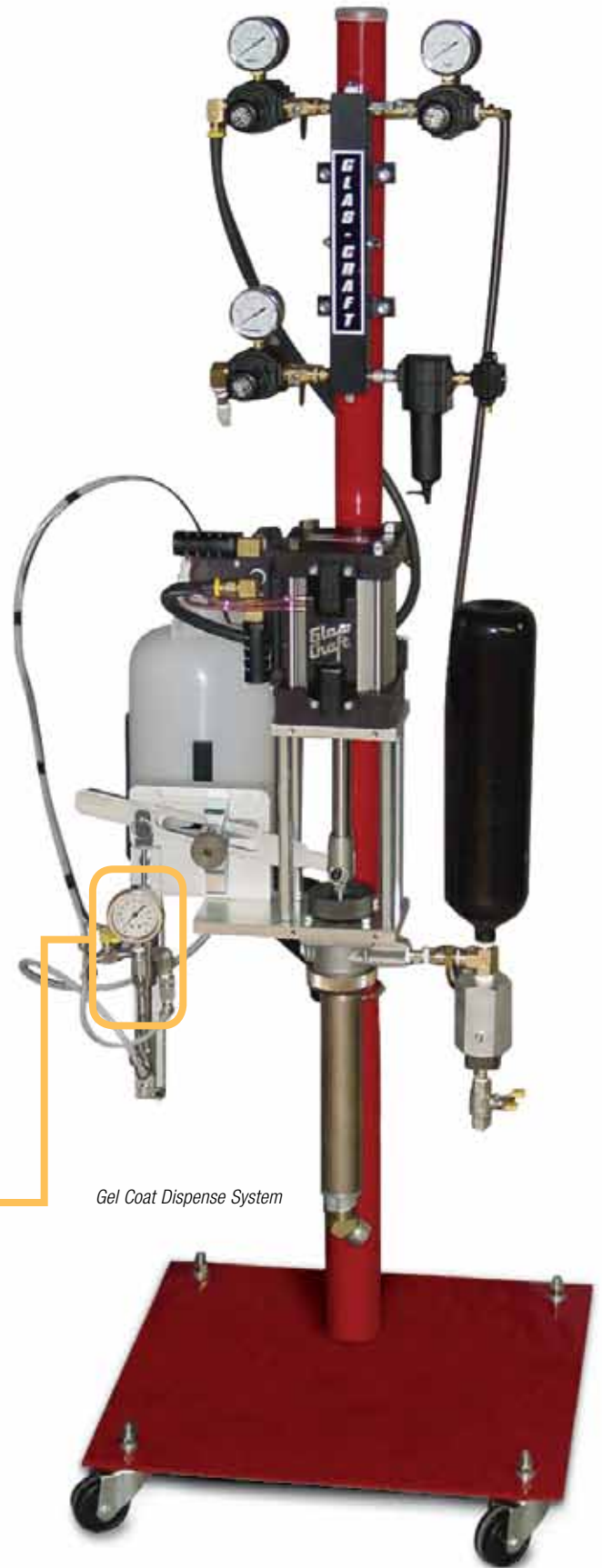
Typical applications:

- Marine and watercraft
- Pool and spa
- Bathware
- Transportation
- Cultured marble





GlasCraft Chopper/Wet-out Dispense System



Gel Coat Dispense System

Dual Upper Seals on Catalyst Pump

- Dual seal prevents leakage – any weepage past the primary seal is returned to the catalyst reservoir, not on the floor

Secondary shaft seal

Primary shaft seal



Long-life Design

- Triple-lip spring-loaded seals, soft seats, stainless steel cylinders and valves provide long wear life

Gel Coat / Resin Pump

Gel Coat / Resin Pump

- Reliable, low-maintenance reciprocating piston pump for moving pigmented, tooling, low-VOC and specialty gel coats and polyester resin
- Piston pump works well with fillers
- Standard pump offers 11:1 ratio
- Develops up to 1300 psi (90 bar, 9.0 MPa)
- Delivers up to 2.5 gpm (9.5 lpm)

Optional pumps:

HVRP 17:1 pump

- Designed for high volume gel coat or polyester resin applications
- Ideal for high volume production shops
- Develops up to 1700 psi (117 bar, 11.7 MPa)
- Delivers up to 4.1 gpm (15.5 lpm)

Low VOC 20:1 pump

- For high-viscosity materials
- Develops up to 2000 psi (138 bar, 13.8 MPa)
- Delivers up to 1.6 gpm (6.1 lpm)



Precision air pilot valve

- Allows fast pneumatic changeover without any parts to wear out

Surge bottle accumulator

- Compensates for pressure spikes

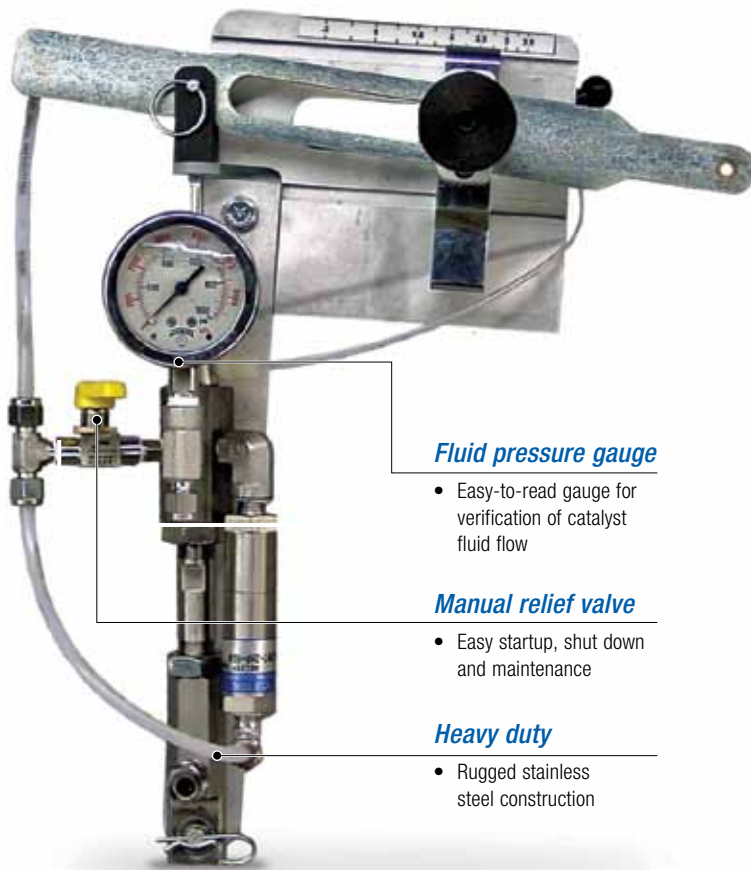
Quick change seal design

- Tool-less quick disconnect allows for easy top seal maintenance
- Lower end is easily removed to service lower seals on pump

Four-inch stroke

- Uses fewer cycles, which means less wear and increased uptime





Fluid pressure gauge

- Easy-to-read gauge for verification of catalyst fluid flow

Manual relief valve

- Easy startup, shut down and maintenance

Heavy duty

- Rugged stainless steel construction

Adjustable-Ratio Catalyst Pump

- Allow for infinite adjustment of catalyst percentage – no tools required
- Ensures proper catalyst percentage and optimal results
- Operates at any desired catalyst percentage*
 - 0.5% to 3.5% for 11:1 system
 - 0.5% to 2.9% for 17:1 system
 - 0.8% to 5.6% for 20:1 system
 - 1.5% to 8.2% for 13:1 G2 system

**Always refer to chemical manufacturer's guidelines for recommended catalyst percentage*

Solutions for the Composites Industry

GlasCraft Multiple Color Gel Coat System

- Ideal for applications that require numerous gel coat colors or continuous change of colors
- Quick, efficient color changes reduce downtime
- Available in two, three, four, five or six-color systems
- Available in internal or external mix
- Flexible design lets you use one system for both resin and gel coat dispensing



GlasCraft G2 Gel Coat System

- Designed to deliver outstanding performance in an economical package
- Along with the RS gun, the G2 provides the industry's best spray pattern with the highest transfer efficiency
- RS gun is standard
- 13:1 available in external mix only
- Delivered fully assembled

Ordering Information / Technical Specifications

Ordering Information

Catalyst Pump

LPA-190-RK Complete rebuild kit
LPA-190-SK Seal kit

13:1 Air Motor (3.25 in)

20840-00 Complete Service Kit
20104-00 Stroke Signal Repair Kit
20841-00 Cylinder Repair Kit
20842-00 Reciprocating Valve Kit
20843-00 Valve Air Kit

11:1 & 20:1 Air Motor (5 in)

20101-00 Complete service kit
20107-00 Pilot valve kit
20106-00 Main valve kit
20104-00 Stroke signal repair kit
20103-00 Rod seal kit
20102-00 Piston rod seal kit

17:1 Air Motor (6 in)

20104-00 Stroke signal repair kit

Fluid Section

21570-00 Repair kit, 11:1 fluid section
19019-00 Repair kit, 13:1 fluid section
21799-00 Repair kit, 17:1 fluid section

Technical Specifications

Gel Coat Dispense Systems

	G2	11:1 or MCG 11:1	HVRP 17:1	20:1 or MCG 20:1
Air requirement	15 cfm @ max output (425 lpm @ 6.8 bar)	35 cfm @ max output (480 lpm @ 6.8 bar)	80 cfm @ max output (620 lpm @ 6.8 bar)	35 cfm @ max output (480 lpm @ 6.8 bar)
Material pump capacity*	1 gpm (3.79 lpm)	2.5 gpm (9.5 lpm)	4.1 gpm (15.5 lpm)	1.6 gpm (6.1 lpm)
Material pump output	.021 gal per cycle; 50 cycles = 1 gal; 13 cycles = 1 liter	.050 gal per cycle; 20 cycles = 1 gal; 5 cycles = 1 liter	.082 gal per cycle; 12 cycles = 1 gal; 3 cycles = 1 liter	.032 gal per cycle; 31 cycles = 1 gal; 8 cycles = 1 liter
Catalyst slave pump range	1.5% to 8.2%	0.5% to 3.5%	0.5% to 2.9%	0.8% to 5.6%

* Material pump capacity is based on 50 cycles per minute. Cycle rates may vary depending on material viscosity, material temperature and volume of air.
All pump outputs are measured at the pump outlet using water as the test media.

Chopper / Wet-out Systems

	11:1	HVRP 17:1	20:1
Air requirement	35 cfm @ 100 psi max output (991 lpm @ 6.8 bar @ max pump output)	80 cfm @ max output (2265 lpm @ 6.8 bar @ max pump output)	35 cfm @ 100 psi max output (991 lpm @ 6.8 bar @ max pump output)
Material pump capacity*	2.5 gpm (9.5 lpm)	4.1 gpm (15.5 lpm)	1.6 gpm (6.1 lpm)
Material pump output	.050 gal per cycle; 20 cycles = 1 gal; 5 cycles = 1 liter	.082 gal per cycle; 12 cycles = 1 gal; 3 cycles = 1 liter	.032 gal per cycle; 31 cycles = 1 gal; 8 cycles = 1 liter
Catalyst slave pump range	0.5% to 3.5%	0.5% to 2.9%	0.8% to 5.6%

* Material pump capacity is based on 50 cycles per minute. Cycle rates may vary depending on material viscosity, material temperature and volume of air.
All pump outputs are measured at the pump outlet using water as the test media.





ABOUT GRACO

PROVEN QUALITY. LEADING TECHNOLOGY.

Founded in 1926, Graco is a world leader in fluid handling systems and components. Graco products move, measure, control, dispense and apply a wide range of fluids and viscous materials used in vehicle lubrication, commercial and industrial settings.

The company's success is based on its unwavering commitment to technical excellence, world-class manufacturing and unparalleled customer service. Working closely with qualified distributors, Graco offers systems, products and technology that set the quality standard in a wide range of fluid handling solutions. Graco provides equipment for spray finishing, protective coating, paint circulation, lubrication, and dispensing sealants and adhesives, along with power application equipment for the contractor industry. Graco's ongoing investment in fluid management and control will continue to provide innovative solutions to a diverse global market.

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