RS Resin Spray Guns
Next Generation Guns for Gel Coat and Chop Applications
A revolution for the FRP industry

Discover the next generation of gel coat and chop guns

Innovations engineered into the Graco RS Resin Spray Gun are sure to make a difference in your production uptime. It's lightweight. Ergonomic. Designed for tool-less operation and quick blade changes. Fast, easy maintenance too.

Discover how the Graco RS Resin Spray Gun's revolutionary design and industry-first features can help boost your company's bottom line.

**Lightweight, high-output cutter**
- Allows you to get the glass output you need with fewer strands of roving
- Fewer strands of roving means less chance of tangling, easier handling and more uptime
- Up to 40% lighter than traditional models for better chopping control

**External anvil adjustment**
- Lets you adjust anvil tension to correct cut variations due to anvil and blade wear
- Simply unlock thumb lever, adjust tension screw and resume spraying
- No disassembly, no tools required – results in more uptime

**Tool-less blade design for more uptime**
- No tools required – easy to change blades in seconds
- Ability to change blades on the production line resulting in more uptime
- Operators never have to touch a blade
- Virtually eliminates nicks and cuts

**Speed control**
- Lets you adjust glass output on the fly
- No tools required

**Change blades in seconds and keep production moving**

Graco's innovative new fiberglass cutter is sure to change the way you work. It’s designed so workers can change the blades in less than a minute – significantly less time than traditional cutter designs. In addition, blades and anvils can be changed right on the production line, resulting in more uptime. Because the blades are pre-loaded in the cartridge, operators never have to handle sharp blades.
Built to spray longer and improve uptime

Both Graco RS Chop and RS Gel Coat Guns offer:

**Lightweight design**
- Up to 44% lighter than traditional models for better spraying control

**Unique needle clamp design**
- Designed to retain the factory adjustment
- Eliminates need to adjust needle setting after routine service

**Quick-disconnect front end**
- Easy shutdown procedures – simply place front end in solvent overnight
- Increases production time, reduces clean-up time
- After cleaning front end, the gun can be set aside for the next shift

**Air Assist Containment (AAC®)**
- More material on the part, less on the floor – saves material costs
- Promotes a healthier work environment due to less overspray
- Standard on all RS guns

**Ergonomic handle**
- Less operator fatigue means consistent quality parts throughout the shift

**Easy maintenance**
- Whole gun may be placed in solvent
- O-rings and seals are solvent-resistant
- Virtually eliminates downtime for unscheduled maintenance

**High-pressure swivel**
- Allows for easy gun manoeuvrability
-Provides more control when spraying in tight areas

How to change a Graco cutter blade

1. Remove locking mechanism
2. Remove used blade cartridge
3. Replace with new blade cartridge

Graco RS Chop Guns and Graco RS Gel Coat Guns are both available in internal and external mix models
When you buy a drum of resin, you pay for every drop of material. It makes good economic sense to put as many of those drops as possible on the mold.

Air Assist Containment (AAC) technology wraps the spray pattern in a containment shield of air – preventing atomized droplets from escaping the spray pattern. Droplets that escape and end up on the floor, wall or employee’s clothing are a waste of money.

AAC creates a spray pattern where the droplets travel to the mold at very low pressure. The low speed or “particle velocity” creates very little turbulence or disturbance in the liquid when the droplet makes contact with the mold. Competitive spray guns with higher “particle velocity” create a great deal of turbulence when the droplets impact the mold. Turbulence creates air entrapment which results in porosity. AAC spraying dramatically reduces the chances of air entrapment and porosity.

**Advanced technology to control and contain your spray pattern**

<table>
<thead>
<tr>
<th>AAC improves your profit picture</th>
</tr>
</thead>
<tbody>
<tr>
<td>• All Graco RS guns feature the patented AAC technology</td>
</tr>
<tr>
<td>• Reduces material waste – which results in more molds per drum of material</td>
</tr>
<tr>
<td>• Precise catalyst delivery and reduced particle velocity assure the highest quality finish</td>
</tr>
<tr>
<td>• Less overspray means a healthier work area for employees</td>
</tr>
</tbody>
</table>

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**External mix technology shown in example**

Graco’s Air Assist Containment: **AFTER** introduction of catalyst

Traditional Air Assist Containment: **BEFORE** introduction of catalyst
ROI Calculator

Lightning-fast blade changes – more uptime

Calculate your return on your investment

If it takes longer than a few minutes to switch the blades on your current chop gun, then you need a Graco RS Chop Gun. You’ll discover that the Graco RS Chop Gun pays for itself with saved labour costs and improved production uptime. Here’s how:

Easy, convenient blade change for improved production uptime

The blade cartridge in the Graco RS Chop Gun adds convenience and speed to the production line. Blades can be switched in under a minute, right on the production line. No more stopping production to switch guns. No more taking the gun to the workbench. Instead, blades can be quickly switched on the production line. The Graco RS Gun significantly reduces downtime due to blade maintenance.

No tools required

The cover to Graco’s cutter assembly is easy to remove and doesn’t require any tools. Neither do the blades.

Old style cutters featured razor blades that needed to be replaced individually. With Graco’s new blade cartridge, you simply remove the entire used blade cartridge and insert a new one. It’s much quicker, with less chance of getting cut.

Reduced labour costs

Some shops have a specialized gun maintenance person whose sole job is to switch blades in chop guns. Because of the Graco RS Gun’s simple, innovative design, this is no longer necessary. Stop and think: what’s the real cost and time spent at your plant to change the blades on your current chop gun? Add it up: stopping the production line, getting the tools to remove the cover and wheel, taking the cutter to the bench, removing blades… it all adds up.

Labour savings alone on the Graco RS Gun will provide a strong return on investment. Use the ROI tool below to determine the savings in your shop.

Fewer cuts

<table>
<thead>
<tr>
<th>LABOUR SAVINGS</th>
<th>EXAMPLE ESTIMATE</th>
<th>ACTUAL ESTIMATE</th>
</tr>
</thead>
<tbody>
<tr>
<td>(including cost of blades)</td>
<td>Typical</td>
<td>Graco RS Chop Gun</td>
</tr>
<tr>
<td>Labour rate per hour</td>
<td>30,00</td>
<td>30,00</td>
</tr>
<tr>
<td>Time to switch blades (hrs)</td>
<td>0,25</td>
<td>0,0083</td>
</tr>
<tr>
<td>Price of blades (4-blade)</td>
<td>1,00</td>
<td>5,00</td>
</tr>
<tr>
<td>Daily labour &amp; blade cost</td>
<td>8,50</td>
<td>5,25</td>
</tr>
<tr>
<td>Number of shifts each day</td>
<td>1</td>
<td>1</td>
</tr>
<tr>
<td>Number of times blades are changed per shift</td>
<td>1</td>
<td>1</td>
</tr>
<tr>
<td>Number of times blades are changed each week (assumes 5-day work week)</td>
<td>5</td>
<td>5</td>
</tr>
<tr>
<td>Weekly cost</td>
<td>42,50</td>
<td>26,25</td>
</tr>
<tr>
<td>Annual cost @ 50 weeks/year</td>
<td>2.125,00</td>
<td>1.313,00</td>
</tr>
<tr>
<td>LABOUR &amp; PARTS SAVINGS</td>
<td><strong>912</strong></td>
<td></td>
</tr>
</tbody>
</table>

This ROI Calculator provides an estimate of savings only. Part prices and time to switch blades are estimates only. Savings generated by this ROI tool are not guaranteed. Actual results may vary depending on equipment, materials and factory conditions.
Minimum Air Flow 6.8 bar (at 100 psi)
- Internal Mix Gel ................................................................. 0.354 meters$^3$ per minute (12.5 scfm)
- Internal Mix Chop .............................................................. 0.064 meters$^3$ per minute (2.25 scfm)
- External Mix ................................................................. 0.06 meters$^3$ per minute (2.0 scfm)
- Cutter ................................. 0.467 meters$^3$ per minute (16.5 scfm)

Maximum Air Pressure .................................................. 8.7 bar, 0.87 MPa (125 psi)

Weight
- Internal Mix Gel: .......................................................... 1.05 kg
- Internal Mix Chop ......................................................... 1.12 kg
- External Mix Gel ......................................................... 0.94 kg
- External Mix Chop ......................................................... 1.04 kg
- Cutter ................................................................. 0.91 kg
- Manual (Guns and Cutter) ................................................ 3A0232

How to read a composite spray tip number

**C S T 5 2 1**
- **CST** = Composite Spray Tip
- **4TH DIGIT** = pattern width code. Double the number to get pattern width at 30cm. In this case, 5 equals a 25cm spray pattern width at a 30cm spraying distance.**
- **LAST TWO DIGITS** = Orifice size. In this case, 21 is equivalent to a .021 diameter orifice.

**EXAMPLE**

How to read an impingement tip part number

**C S T S 7 5**
- **CST** = Composite Spray Tip
- **4TH DIGIT** = S for stainless steel or T for tool steel
- **5TH DIGIT** = Spray pattern width code. Double the number to get pattern width at 45cm. In this case, 7 equals a 35cm pattern width at an 45cm spraying distance.
- **6TH DIGIT** = Orifice size code. Number roughly matches the diameter of the angled hole size. In this case, 5 is equivalent to a .052-inch diameter angled hole.

**EXAMPLE**

<table>
<thead>
<tr>
<th>Airless Composite Spray Tips</th>
<th>Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>CST215</td>
<td>CST223</td>
</tr>
<tr>
<td>CST215</td>
<td>CST223</td>
</tr>
<tr>
<td>CST217</td>
<td>CST227</td>
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<tr>
<td>CST219</td>
<td>CST231</td>
</tr>
<tr>
<td>CST219</td>
<td>CST231</td>
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<td>CST419</td>
<td>CST431</td>
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<td>CST527</td>
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<td>CST421</td>
<td>CST435</td>
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<tr>
<td>CST521</td>
<td>CST535</td>
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</table>

<table>
<thead>
<tr>
<th>Impingement Composite Spray Tips</th>
<th>Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>CSTS42</td>
<td>CSTS64</td>
</tr>
<tr>
<td>CSTS73</td>
<td>CSTS74</td>
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<tr>
<td>CSTS34</td>
<td>CSTS84</td>
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<tr>
<td>CSTS44</td>
<td>CSTS55</td>
</tr>
<tr>
<td>CSTS54</td>
<td>CSTS65</td>
</tr>
</tbody>
</table>

*Pattern size will vary depending on changes in pressure, viscosity and temperature.*
**Guns**

- 258853 Gel coat gun, internal mix with CST521 tip
- 258840 Gel coat gun, external mix with CST521 tip
- 258854 Chop gun, internal mix with CST443 tip, without cutter
- 258852 Chop gun, external mix with CST443 tip, without cutter
- 258970 External mix chop gun with CST443 tip, with cutter
- 258971 Internal mix chop gun with CST443 tip, with cutter
- 24E512 Cutter assembly
- 24E448 4-blade cartridge kit
- 24F602 6-blade cartridge kit
- 24E449 8-blade cartridge kit
- 257754 Hose adapter kit

**Gun Repair Kits**

- 24E415 Solvent AAC assembly fitting kit
- 24E416 Needle clamp assembly kit
- 24E417 Complete needle assembly
- 24E418 Needle repair kit
- 24E419 Needle AAC kit
- 24E420 Catalyst Seat Kit
- 24E421 Resin Seat Kit
- 24E422 Cutter adapter kit
- 24E423 Catalyst check valve
- 24E424 Check valve housing kit
- 24E425 Trigger air valve kit
- 24E428 Seat seal, 6-pack
- 24E435 Tip seal kit, 6-pack
- 24E436 Needle assembly kit, 6-pack
- 24E443 Front head internal check valve
- 24E444 Internal spring check valve kit
- 16C300 Internal mixer kit
- 24E446 Front head external check valve kit
- 24E447 Front head external check valve repair kit

**Head Assemblies**

- 24E426 Horizontal external mix front head kit
- 24E427 Vertical external mix front head kit
- 24E442 Horizontal/vertical internal mix front head kit
ABOUT GRACO

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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Graco reserves the right to make changes at any time without notice.

Graco is certified ISO 9001.