FRP Systems
Proportioners and Guns for Gel Coat and Chop Applications
Raising the bar for high-performance FRP equipment

Engineered with industry-proven Graco components, Graco FRP (Fiber-Reinforced Plastic) Systems and RS™ (resin spray) applicator guns provide you with a system that is technologically advanced, durable and easy to use.

Lower cost of ownership
• Easy maintenance — fewer wear parts than competitive models
• More uptime for production — longer periods between scheduled maintenance

Quality parts — all day, every day
Your reputation rides on the quality of your end products. With Graco FRP equipment, you’re assured of a consistent catalyst ratio for a consistent cure — resulting in higher quality, finished products.

A smart future investment: MACT-compliant technology
Graco FRP equipment features MACT (Maximum Achievable Control Technologies)-compliant RS spray guns. As regulations change to require new technologies, Graco promises to be a smart investment for the future of your business.

Here’s why. Graco FRP equipment supports MACT requirements with two application tip designs — one for air assisted airless and a second one for impingement spray processes. With Graco, you can switch from air assisted airless to impingement by simply changing the spray tip.
Optional inline heaters provide consistent temperature and viscosity control at the point of application (see page 11).

**Featuring:**
- More consistent spray pattern
- Resin usage monitor
- Linkage and tool-free catalyst adjustment

**Roving Management System**
- Better guides — less tangling, more uptime

**Balanced Graco NXT® Air Motor**
- Provides same output pressure on upstroke and downstroke, resulting in more consistent spray pattern
- Shortened stroke on pump for better spray pattern

**Control Panel**
- Easy user interface with all gauges in one location

**Stable, Lightweight Cart**
- Easy to maneuver
- Strong, durable casters

**New Linkage and Catalyst Pump**
- Truly engineered linkage for superior ratio control
- Allows for infinite adjustment of catalyst percentage — no tools required
- Ensures proper catalyst percentage and optimum results
- Variance of 1% or less

**Gravity Fed Catalyst System**
- Keeps the catalyst pump primed for consistent delivery

**Internal Mix-Chop Gun**

**Optional DataTrak™ Control**
- Monitors resin usage — Helps ensure product quality by tracking resin usage per piece, shift or day
- Tracks cycles for preventive maintenance schedule
- Displays real time flow rate — eliminates material waste due to worn spray tips

**Graco Chop System**
Easy to use, lightweight guns

**Graco RS Chop Gun with Cutter**

**Magnetic Cutter Drum**
- Quick and easy blade changes
- Magnet in cutter head holds blades in place

**Swivel Feature**
(Where the fluid line connects to the gun)
- Allows smooth movement
- Operator can easily pivot in different directions without kinking the hose

**Ergonomic Handle**
- Less operator fatigue

**Graco RS Gel Coat Gun**

**Solvent-Safe**
- Easy shutdown — simply place front end in solvent at end of shift

**Quick-Disconnect Front End**
- Modular design means it’s very easy to get to the specific part you need to replace
- No need to disassemble the entire gun
- Increases productivity, reduces cleanup time

**Constant Control**
- Adjust glass cutting tension output on the production floor in seconds
- No tools needed to make many adjustments

**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
- External anvil adjustment lets you quickly and easily adjust anvil tension

**Optional Quick-Change Blade Cartridges**
- Change blades in a matter of seconds
- Replace the whole cartridge at once, not individual blades
- Greatly reduces the chance of nicks and cuts
- Only available from Graco!

Both Graco RS Gel Coat Guns and Graco RS Chop Guns are available in internal and external mix models.
Fast switch tip design – A Graco Exclusive

Today’s FRP market uses two different technologies. Mechanical Air Atomized (Air Assisted Airless) and Mechanical Non-Air Atomized (Impingement). Using the Graco RS Guns allows you to switch from one technology to the other by simply changing the spray tip. This can be done quickly and cost effectively. Competitive models require time-consuming spray gun head changes and or complete replacement of the spray gun which results in lost time and higher cost conversion.

Exclusive Graco Feature

Only Graco allows you to switch technologies just by changing tips.
Air Assist Containment® (AAC) – control and contain your spray pattern

When you buy a drum of resin or gelcoat, you pay for every drop of material. Graco will help you put as many of those drops as possible on the mold.

Our exclusive Air-Assist Containment (AAC) wraps the spray pattern in a containment shield of air. This prevents atomized droplets from escaping the spray pattern creating a better working environment. 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 material when it is applied to the mold. Competitive spray guns with higher “particle velocity”, create a great deal of turbulence during the application process. Turbulence, or over-atomization, creates air entrapment which can result in porosity issues.

Graco Spray Technology

YES

Graco Air Assist Containment: AFTER introduction of catalyst

Atomized droplets are kept or “contained” in the spray pattern

Resin

Catalyst

NO

Traditional Air Assist Containment: BEFORE introduction of catalyst

Some atomized droplets escape the spray pattern

Resin

Catalyst

The patented AAC is introduced to the spray pattern after the catalyst assuring a complete mix, reducing over spray and providing the highest transter efficiency.

Low Pressure catalyst is delivered into the spray pattern

Graco’s catalyst delivery process assures a complete mix with the gelcoat

Graco Spray Technology

Resin

Catalyst
### Systems

#### Solvent Flush Kits
- **16M560** Diaphragm Pump Solvent Flush Kit - 2.5 gal (9.5 l)
- **16M561** Diaphragm Pump Solvent Flush Kit - 5 gal (19 l)
- **16M893** Pressure Pot Solvent Flush Kit - 2 gal (7.6 l)
- **16M894** Pressure Pot Solvent Flush Kit - 3 gal (11.4 l)
- **16M874** CE Pressure Pot Solvent Flush Kit - 2 gal (7.6 l)

#### Optional Kits
- **16M881** DataTrak Upgrade Kit
- **24M501** 5 gal (19 l) Catalyst Tank Kit
- **16M896** 55 gal (208 l) Drum Cart for Cart, Mast and Boom
- **16M897** 55 gal (208 l) Drum Cart for Pole Cart
- **16M961** Roving Box Kit
- **16N918** Wall Mount Bracket Kit
- **16N791** Boom Kit

#### Hose Kits
- **16M718** Internal Gel Hose Extension 25 ft (7.6 m)
- **16M587** Internal Gel Hose Bundle 25 ft (7.6 m)
- **16M590** Internal Gel Hose Bundle 35 ft (10.7 m)
- **16M719** External Gel Hose Extension 25 ft (7.6 m)
- **16M588** External Gel Hose Bundle 25 ft (7.6 m)
- **16M591** External Gel Hose Bundle 35 ft (10.7 m)
- **16M585** External Gel Hose Bundle 50 ft (15.2 m)
- **16M712** Chop Hose Extension 25 ft (7.6 m)
- **16M586** Chop Hose Bundle 25 ft (7.6 m)
- **16M589** Chop Hose Bundle 35 ft (10.7 m)
- **16M583** Chop Hose Bundle 50 ft (15.2 m)

#### Replacement Outlet Filters
- **224458** 30 mesh, 2-pack
- **238436** 30 mesh, 25-pack
- **224459** 60 mesh, 2-pack
- **238438** 60 mesh, 25-pack
- **224468** 100 mesh (standard option), 2-pack
- **238440** 100 mesh (standard option), 25-pack
- **224469** 200 mesh, 2-pack
- **238442** 200 mesh, 25-pack

#### Pump Kits and Parts
- **W170CS** 17:1 Pump Assembly 75 cc SST
- **W130FC** 13:1 Pump Assembly 100 cc CS
- **W090FC** 9:1 Pump Assembly 150 cc CS
- **M07LNL** 4.5 in FRP NXT Air Motor
- **16N238** 4.5 in FRP NXT Air Motor - Seal Kit
- **17E098** 150 cc FRP Lower - Seal Kit
- **17E099** 150 cc FRP Lower - Connection Kit
- **LW100C** 100 cc FRP Lower - Seal Kit
- **16N232** 100 cc FRP Lower - Connection Kit
- **LW075S** 75 cc FRP Lower
- **16N231** 75 cc FRP Lower - Seal Kit
- **16N242** 75 cc FRP Lower - Connection Kit
- **16N919** Internal Mix Catalyst Pump Assembly
- **16N740** Internal Mix Catalyst Pump Assembly
- **16N741** External Mix Catalyst Pump Assembly

#### Cart/Hose Length
<table>
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<th>Part #</th>
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<th>Cart/Hose Length</th>
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<td>(None)</td>
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* Systems without hoses do not come with guns

** Fluid and air flow rate for 70 cpm
RS Guns

258853 RS Internal Mix Gel Coat Gun, CST521 tip
258840 RS External Mix Gel Coat Gun, CST521 tip
258971 RS Internal Mix Chop Gun with Cutter, CST443 tip
258970 RS External Mix Chop Gun with Cutter, CST443 tip
258854 RS Internal Mix Chop Gun without Cutter, CST443 tip
258852 RS External Mix Chop Gun without Cutter, CST443 tip
24P435 RS Internal Mix Chop Gun (High Flow) with Cutter, CST561 tip
24P436 RS Internal Mix Chop Gun (High Flow) w/o Cutter, CST561 tip

RS Gun Parts
24E512 Cutter assembly
24E448 4-Blade Cartridge Kit, 5-pack
24F602 6-Blade Cartridge Kit, 5-pack
24E449 8-Blade Cartridge Kit, 5-pack
126872 Anvil - Cartridge Cutter Head
126995 Anvil - Individual Blade Cutter Head
6K706 RS RTM and Pour Adapter
24H537 Internal Mix High Flow Kit
24H536 External Mix High Flow Kit
24M569 Roving guide, 2-hole feeder bar

Optional Cutter Chutes
16K759 Open, Short, Adjustable Chute
16K760 Closed, Short, Adjustable Chute
16K762 Open, Long, Adjustable Chute
16K763 Closed, Long, Adjustable Chute
125883 Closed, Long, Wide Chute
125884 Closed, Narrow Chute

Head Assemblies
24E426 External Mix Horizontal Front Head Kit
24E427 External Mix Vertical Front Head Kit
24E442 Internal Mix Chop Front Head Kit
24G615 Internal Mix Gel Front Head Kit

Gun 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
24E445 Internal mixer kit
24E446 Front head external check valve kit
24E447 Front head external check valve repair kit
24F706 Chopper Air Shutoff Valve
16N889 Carbide seat kit

Impingement Composite Spray Tips - For example: CSTS75
1. The first three letters (CST) = Composite Spray Tip.
2. The 4th digit indicates pattern width code.
   Double this number to get pattern width at 12 inches.
   In this case, 5 equals a 10-inch spray pattern width.
3. The last two digits indicate orifice size.
   In this case, 21 is equivalent to a .021" diameter orifice.

Airless Composite Spray Tips - For example: CST521
1. The first three letters (CST) = Composite Spray Tip.
2. The 4th digit indicates pattern width code.
   Double this number to get the pattern width at 12 inches.
   In this case, 5 equals a 10-inch spray pattern width at a 12-inch spraying distance.
3. The last two digits indicates orifice size.
   In this case, 21 is equivalent to a .021" diameter orifice.

### Airless Composite Spray Tips (CSTXXX)

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<th>0.019</th>
<th>0.021</th>
<th>0.023</th>
<th>0.027</th>
<th>0.031</th>
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### Impingement Composite Spray Tips (CSTXXX)

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<th>0.021</th>
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</table>
FRP Accessories

**Heavy Duty Drum Agitator**

- Heavy duty gearbox mixes high viscosity materials
- Leak-free and oil-less gearbox prevents material contamination
- Stainless steel agitator and cover for corrosion resistance
- Twin paddles thoroughly mix finishing materials
- Siphon option allows material transfer through agitator shaft
- Access port for easy sampling and inspection of material during operation

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
<th>Drive</th>
<th>HP</th>
<th>Length (cm)</th>
<th>Material</th>
<th>Manual</th>
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<td>Heavy-duty back-geared agitator with elevator, drum cover and siphon kit</td>
<td>Air</td>
<td>1/2</td>
<td>32 (81.25)</td>
<td>SST</td>
<td>308609</td>
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<td>231413</td>
<td>Same as 231414, except without siphon capability</td>
<td>Air</td>
<td>1/2</td>
<td>32 (81.25)</td>
<td>SST</td>
<td>308609</td>
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<tr>
<td>238157</td>
<td>Heavy-duty back-geared agitator</td>
<td>Air</td>
<td>1/2</td>
<td>32 (81.25)</td>
<td>SST</td>
<td>308609</td>
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<tr>
<td>240209</td>
<td>Same as 238157 with siphon kit</td>
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<td>32 (81.25)</td>
<td>SST</td>
<td>308609</td>
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<td>238250</td>
<td>Siphon tube kit; fits 238157 agitator</td>
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<td>43 (109)</td>
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**In-line Air Filter and Coalescers**

- Reusable filter removes particles down to 5 microns
- Coalescer removes contaminants down to 0.01 microns
- Auto-drain eliminates manual emptying of filters
- Built-in filters change indicator signals replacement to ensure optimal efficiency

<table>
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<th>Part No.</th>
<th>Description</th>
<th>Air Inlet in</th>
<th>Air Outlet in</th>
<th>Air Flow Capacity</th>
<th>Maximum Inlet Pressure</th>
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<td>Air filter/coalescer assembly (both with auto drain)</td>
<td>1/2 npt (f)</td>
<td>1/2 npt (f)</td>
<td>70 CFM</td>
<td>175 psi (1.2 MPa, 12 bar)</td>
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<td>Stage 1 - Air filter with auto drain removes contaminants to 5 microns</td>
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<td>108 CFM</td>
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<td>Stage 2 - Coalescer with auto drain removes particles to 0.01 microns</td>
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<td>70 CFM</td>
<td>175 psi (1.2 MPa, 12 bar)</td>
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<td>3/4 npt (f)</td>
<td>300 CFM</td>
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<tr>
<td>234409</td>
<td>Coalescer with auto drain removes particles to 0.01 microns</td>
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<td>115 CFM</td>
<td>175 psi (1.2 MPa, 12 bar)</td>
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Instruction Manual: 309919
Pail Cover Agitator

- Lift handles for easy moving and color changes
- Locking bolts to secure cover and reduce spills
- Ideal for wall mount pumps or spray packages

<table>
<thead>
<tr>
<th>Part No.</th>
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<td>Round prop</td>
<td>Air</td>
<td>1/4</td>
<td>13.25 (33.6)</td>
<td>SST</td>
<td>307968</td>
<td>224571 Agitator and hose</td>
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<td>Pail cover, round prop</td>
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<td>CS</td>
<td>306670</td>
<td>224571 Agitator and CS pail cover</td>
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<td>224572</td>
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<td>Single round prop (3 blade)</td>
<td>Air</td>
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<td>17.25 (43.8)</td>
<td>SST</td>
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Fluid Heater Kit

- Variable heating levels for consistent viscosity control
- Approved for hazardous locations
- 7250 psi (500 bar) maximum working pressure
- Stainless steel construction is compatible with polyester resins and coats

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<tr>
<th>Part No.</th>
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<td>16N014</td>
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<td>16N119</td>
<td>Heater Mount Kit</td>
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Contact us today!
Call 800-746-1334 to speak with a Graco representative, or visit www.graco.com for more information.