Liquid silicone rubber parts are used in many markets.

Engineering expertise meets manufacturing excellence

Graco Fluid Automation products resulted when Fluid Automation, Inc., a renowned innovator in metering and dispense equipment for liquid silicone rubber (LSR) materials, joined Graco Inc., the recognized world leader in fluid handling systems and components.

From our collective experience, we understand how the smallest error can lead to expensive material waste, costly overhead and likely profit loss. Graco Fluid Automation products are engineered to achieve the highest degree of accuracy—every application, every time.

Graco Fluid Automation provides the highest quality LSR dispensing equipment, created in world class manufacturing facilities and supported with outstanding customer service.

We’re committed to finding you the right solution.
In the manufacturing of liquid silicone rubber (LSR) products, precision is paramount. Material waste is an expensive problem and substandard products are an intolerable failure. Minimize both with the Graco Fluid Automation F4-5 and F4-55.

**Markets:**
- MEDICAL
- INFANT CARE
- CONSUMER PRODUCTS
- AUTOMOTIVE
- INDUSTRIAL PARTS
- WEARABLES
**Precise ratio control, minimal material waste**

The F4-5 and F4-55 systems take the ability to meter material flow to an almost microscopic level. Its helical gear uses multiple gear teeth to measure flow in very small increments. The increased number of measurements offer greater accuracy and assurance the machine is on ratio.

**The result:** More precise mixing, a better end product and less wasted material.

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**Easier operation with Graco Control Architecture™**

The Graco Fluid Automation F4-5 and F4-55 systems feature intuitive user interfaces based on the Graco Control Architecture (GCA) modular system of processing and control components. The GCA system makes maintenance and service easy, thanks to built-in troubleshooting tools.

- Large, bright color screen makes the system easier to use
- Key pad entry makes it easy to program and reduces operator training time
High material costs, pressure drops, decreased throughput and lengthy material changeover processes can have a significant impact on LSR efficiency and productivity.

To help reduce cleaning downtime while increasing production, Graco Fluid Automation engineers have developed revolutionary new straight-thread barrel stack designs for the industry-proven F4-5 and F4-55 meter, mix and dispense systems.

**Easier to clean + assemble**

No tapered national pipe thread (NPT) threads and regulator and mixer enhancements for greater clearance.

Reduces cleaning time by 50 percent so you can spend more time producing parts.

**Reduce pressure drops**

High-flow material passages on the regulator are 225% larger which reduces pressure drops through the barrel stack.

**Reduced thread galling + easier reassembly**

Stackable plastic molded mixers with improved housing and mixer tolerances prevent common side-walling problems. Mixer life is increase by elimination breakage caused by repeated removal and installation.

Plastic mixers can be cleaned or disposed and replaced.
New straight-thread stack designs

Save material costs with customizable mixing

Use only the material you need with both multi-pass and single-pass designs:

Multi-pass mixer
- Supports up to 30 mix elements
- Configure the equipment to run as few mix elements as required: 6, 12, 18, 24, or 30

Single-pass mixer
- Includes 12 mix elements and can be configured to use only required mixers

Increase overall throughput

Two filter options:
- 1-inch diameter filter comes standard, integrated in the stack assembly
- 2.5-inch filter option available
## Ordering + Specifications

### Ordering information

**Select your system**
- 24X160: F4-5 LSR System, 5 Gal
- 24X166: F4-5 LSR System with 5 gallon platen and 24X1218 Caster kit, 5 Gal
- 24X167: F4-5 LSR System, 55Gal w/24X218 Caster Kit
- 24X168: F4-5 LSR System with 5 gallon platen kit, 5 Gal
- 24X169: F4-5 LSR System, 55 Gal

**System accessories**
- 24X218: F4-5SM Caster kit
- 25A100: Continuous level kit F4-5SM
- 25A101: Continuous level kit F4-5M
- 25A102: Dual press kit
- 257729: 5 gal (20 l) Single wiper PTFE Platen
- 25A106: 2nd Press cable kit
- 25A160: 5 gal (20 l) Bucket girdle

**Select your barrel stack**

**Tapered Thread Stack**
- SK556 Stack, 10mm x 12 mix element 3/4 NPT outlet
- SK556-2A Stack, 12mm x 12 mix element 3/4 NPT outlet
- 24R681 Stack, 2 pass, 32 mix element 3/4 NPT outlet
- 25A169 Stack, 2 pass, 24 mix element 1/2 NPT outlet

**Straight Thread Stack (-12 JIC male inlets)**
- 2SA990: 5 pass Stack 21mm X 12 mix element Material check valve only
- 2SA992: 5 pass Stack 23mm X 15 mix element with Fluid shut-offs
- 2SA995: Single Pass Stack 21mm X 12 mix element Material check valve only
- 2SA997: Single Pass Stack 21mm X 12 mix element with Fluid shut-offs
- 2SA998: Single Pass Stack 21mm X 12 mix element with SN751-1A Color Injector

**Orders** should be placed on GEDI or email a purchase order to OhioCS@Graco.com. For a complete listing of kit contents, please refer to the product manual.

### Stack accessories

**Tapered Thread Stack**
- SA920-G: 1/2" Stack regulator
- SA921-G: 3/4" Stack regulator
- SA925-A: 3/4" Stack filter
- SA926-A: 1/2" Stack filter

**Straight Thread Stack**
- 25A899: Stack Regulator with pressure gauge
- 25A892: Stack Regulator
- 25A883*: 2.5" dia Filter Assembly
- 25A890*: 1" dia Filter Assembly
- 25C237: F4 Pressure transducer kit
- 25A897: Stack Valve shut-off

**Color options**
- 25A103: Color flow meter kit, high resolution
- 25A161: Color flow meter kit, standard resolution
- 25A104: 3 qt (3 l) Color tank kit (for F4-5 system)*
- 25A105: 5 gal (11 l) Color tank kit (for F4-55 system)*
- 25A108: Color injector kit (Tapered Thread Stack)
- 25C478: Color Injector Kit (Straight Thread Stack)

**Color hose options**
- 16U447: 3/8" x 3.0m hose, blue
- 16U448: 3/8" x 3.5m hose, blue
- 16U449: 3/8" x 4.0m hose, blue
- 16U450: 3/8" x 5.0m hose, blue

**A & B hose options**
- 24R213: 1/2" x 3.0m hose, black
- 24R214: 1/2" x 4.0m hose, black
- 24R215: 1/2" x 5.0m hose, black
- 24R216: 3/4" x 3.0m hose, black
- 24R217: 3/4" x 4.0m hose, black
- 24R218: 3/4" x 5.0m hose, black
- 12S440: Adapter, -8JIC (m) x -12JIC (f) to connect 1/2" hoses to barrel stack above

### Specifications

**F4-5 Machine Specifications**
- Viscosity range: 50,000 to 5,000,000 cps
- Flow rate: Min: 10g/min Max: 5lb/min @ 500,000 cps
- Maximum output pressure: 3,000 psi (214 bar, 24.1 MPa)
- Ratio range: 1:1
- Pigment ratio range: 0.5% to 6% (Depending on flow rate)
- Air requirements: 10 cfm @ 80 psi (5.5 bar, 0.55 MPa) (max 100 psi [7 bar, 0.7 MPa])
- Power requirements: 95-264 VAC, 50/60 Hz, 2.5A single phase
- Weight: 564 lbs (256 kg)
- Height requirement retracted: 66 in (168 cm)
- Height requirement extended: 87 in (221 cm)

**F4-55 Machine Specifications**
- Viscosity range: 50,000 to 5,000,000 cps
- Flow rate: Min: 10g/min Max: 5lb/min @ 500,000 cps
- Maximum output pressure: 3,000 psi (214 bar, 24.1 MPa)
- Ratio range: 1:1*
- Pigment ratio range: 0.5% to 6% (Depending on flow rate)
- Air requirements: 10 cfm @ 80 psi (5.5 bar, 55 MPa) (max 100 psi [7 bar, 0.7 MPa])
- Power requirements: 95-264 VAC, 50/60 Hz, 2.5A single phase
- Weight: 1,200 lbs (544 kg)
- Height requirement retracted: 69 in (168 cm) low rider frame style
- Height requirement extended: 102 in (259 cm) low rider frame style

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*With optional variable ratio kit; adjustable ratio from 0.8:1 to 1.20:1

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**NOTE:** You have the option to run "off ratio" for additive packages. Graco can run from 0.8 - 1.2%
Small-shot meter, mix and dispense for two-component liquid silicone rubber (LSR)

The single acting design of the mountable Model 622 maintains consistent, accurate pressure, removing any possibility of pressure variations affecting shot sizes. Its high level of ratio accuracy and ability to add a third stream makes it ideal for medical and micro-molding applications.

Model 622 Specifications

- Piston volume: 6, 12, 20 cc
- Ratio: 1:1, fixed
- Shot size: 40 cc maximum (20 cc per cylinder)
- Feed pressure: 3000 psi maximum at barrel inlet
- Additives: Third and fourth stream option
- Controls: PLC

Space-Saving
Mount where it is most convenient or use as a stand-mount or tabletop model

Cost-Saving
A reduced number of components and fewer valves than most designs lowers the cost of cleaning and maintenance

Increased Precision, Less Waste
Single-acting design with closed-loop control provides repeatable pressures and eliminates shot-size variations, thereby reducing waste

Flexible Feeding System
Feed material using cartridges or feed pumps

Increased Efficiency
For small shots, program the 622 to refill after multiple shots rather than after each individual one

Third + Fourth Stream Option
Add colors or other fluid additives through the additional stream program

Optional: Hoses, mixer and manifold
Graco Fluid Automation

Model 633

Air-powered, proportionally controlled meter, mix and dispense for two-component liquid silicone rubber (LSR)

The double-acting plungers of Model 633, driven by a common cylinder, ensure that material is delivered consistently at a 1:1 ratio. Its larger shot size capacity and ability to feed material to multiple locations make Model 633 an excellent solution for high-productivity medical, consumable and electronics manufacturing environments.

Model 633 Specifications

<table>
<thead>
<tr>
<th>Feed:</th>
<th>Either 55 or 5-gallon feed system</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ratio:</td>
<td>1:1 fixed</td>
</tr>
<tr>
<td>Shot size:</td>
<td>Up to 150 cc (75 cc per cylinder)</td>
</tr>
<tr>
<td>Feed pressure:</td>
<td>3,000 psi maximum</td>
</tr>
<tr>
<td>Additives:</td>
<td>Third and fourth stream option</td>
</tr>
<tr>
<td>Controls:</td>
<td>PLC</td>
</tr>
</tbody>
</table>

Flexible
Programmable feed pressure makes it possible to utilize a common tandem feed station for one or more locations. Use third stream option simultaneously to feed different mixes.

Cost-saving
Lower the cost of cleaning and maintenance with a reduced number of components and fewer valves than most designs.

Consistent refills, less waste
The pneumatic proportional air-driven cylinders keep material delivering at a consistent rate.

Material-saving
With ratio tied to the A and B transducers, and an audible and visible refill alarm, the possibility of drawing a vacuum and wasting material is very low.

Third and fourth stream option
Add colors or fluid additives through the additional stream program.

Time-saving operation
A quick refill time of only three seconds at 1700 psi pump pressure keeps manufacturing running at a quick pace.

Wider variability in mold sizes
With a maximum shot size of 150 cc, Model 633 is capable of handling a wide range of manufacturing jobs.

Hoses, mixer and manifold are standard.
Unmatched Quality.

Our focus on continued innovation keeps Graco Fluid Automation at the forefront of fluid handling technology. We typically reinvest three times the industry average into research and development. Our mission is to provide customers with products that result in the lowest total cost of ownership while maximizing product quality and business success.

Global Presence.

With facilities located in Europe, Asia Pacific and the United States, Graco provides a personalized, end-to-end partnership experience. Our engineers will lead the solution planning, testing and refining of your solution in our regional labs to ultimately overseeing the product installation process.

Global Support.

After installation, you’ll receive 24/7 in-person support from our worldwide distribution network of trained and certified distributors who offer relevant experience, product knowledge and responsive service to all our customers.

There is no better reassurance than Graco technology, product innovation and the people committed to helping you succeed all day, every day.

Contact us today!

Call 800-746-1334 to speak with a Graco representative, visit www.graco.com/fluidautomation for more information.