

1:1 Ratio Adapter Kit

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EN

Contains fittings and fluid recirculation hoses needed for running 1:1 two-component intumescent epoxies on XM™ PFP Systems. For professional use only.

Proportioners leave the factory set up for materials which are higher volume and/or viscosity on the “A” side, and lower volume and/or viscosity on the “B” side. 1:1 mix ratio machines will normally change the “B” side circulation return hose from 3/8 in. to 1/2 in. ID to balance the recirculation speeds.

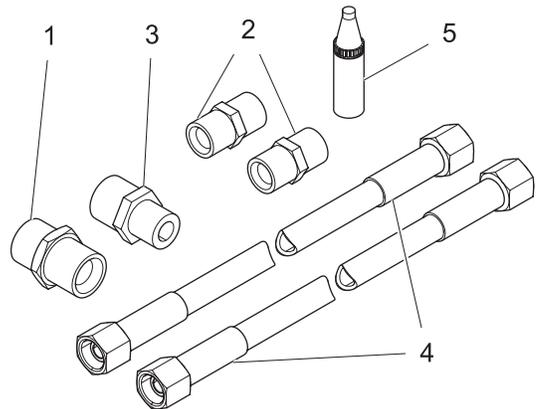
1:1 mix ratio machines also use outlet hose bundles which are 3/4 in. on both sides. The outlet fittings on the machine and the inlet fittings on the mix manifold must be changed on the “B” side from 1/2 in. to 3/4 in.

Kit No. 24X461

This kit is used on new 1:1 machines or for converting existing machines to 1:1 mix ratio with the addition of 16T122 (3/4 x 3/4) outlet hose bundle (sold separately).



Important Safety Instructions
Read all instructions in this manual and the warnings and instructions in the XM PFP System manual. Save all instructions.



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See **Installation** instructions on page 2.

Parts

Ref.	Part	Description	Qty
1	160032	NIPPLE; 1.25 hex x 2 in, 3/4-14 npt	1
2	158491	NIPPLE; 7/8 hex, 1/2-14 npt	1
3	C20461	NIPPLE, reducing, 1.25 hex; 3/4 npt x 1/2 npt	1
4	H75004	HOSE, coupled, 7250 psi, 0.50 in. ID, 4 ft	1
5	110110	SEALANT, pipe, sst; 6 ml	1

Installation

When running 1:1 mix ratio materials the:

- recirculation hose is changed from 3/8 in to 1/2 in ID

NOTE: If the “B” side viscosity is higher than the “A” side viscosity on a 1:1 mix material, the circulation rate may balance better by using the 1/2 in. return hoses on the “B” side and the 3/8 in. return hose on the “A” side.

- B side outlet fitting is from 1/2 in to 3/4 in.
- mix manifold inlet fitting is changed from 1/2 in to 3/4 in.

1. Relieve pressure. See XM PFP instruction manual.
2. Remove 3/8 x 6 ft recirculation hose and fitting from the back of the B side dosing valve.

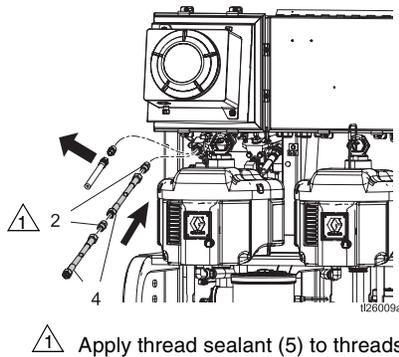
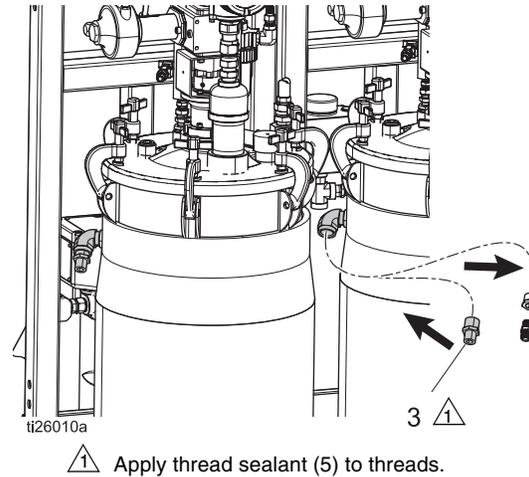


FIG. 1

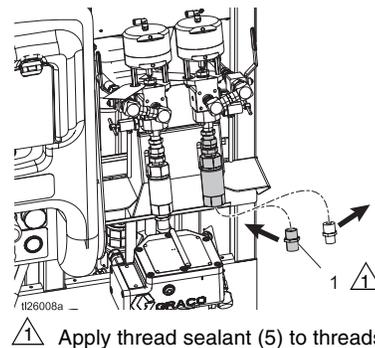
3. Connect the two hoses (4) with fitting (2).
4. Connect the second fitting (2) and hoses (4) to the back of the B side dosing valve.
5. Remove the 3/8 nipple and bushing from the B side feed module tank return and replace with the 3/4 x 1/2 in nipple (3).



⚠ Apply thread sealant (5) to threads.

FIG. 2

6. Disconnect hose from the B side outlet check valve. Remove outlet fitting and replace with 3/4 nipple (1).



⚠ Apply thread sealant (5) to threads.

FIG. 3

7. Replace the 1/2 x 3/4 nipple on the inlet of the B side ball valve on the mix manifold with the 3/4 x 3/4 nipple that comes with the 16T122 3/4 x 3/4 hose bundle.

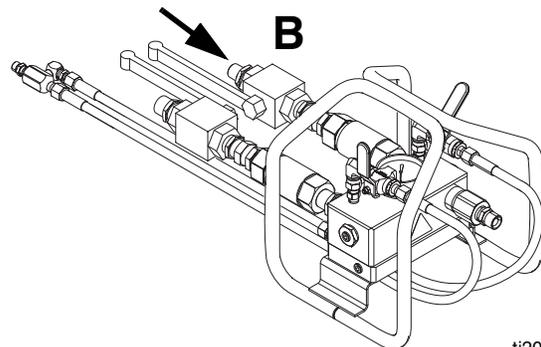


FIG. 4

Graco Information

For the latest information about Graco products, visit www.graco.com.

For patent information, see www.graco.com/patents.

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Phone: 612-623-6921 **or Toll Free:** 1-800-328-0211 **Fax:** 612-378-3505

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Graco Headquarters: Minneapolis

International Offices: Belgium, China, Japan, Korea

GRACO INC. AND SUBSIDIARIES • P.O. BOX 1441 • MINNEAPOLIS MN 55440-1441 • USA

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