



# FRP Systems

Proportioners and Guns for Gel Coat and Chop Applications



PROVEN QUALITY. LEADING TECHNOLOGY.

# Consistent ratio for a consistent cure

## Raising the bar for high-performance FRP equipment

Engineered with industry-proven Graco components, Graco FRP Proportioners and RS™ applicator guns provide you with a system that is technologically advanced, long lasting, and affordable.

### Ratio assurance

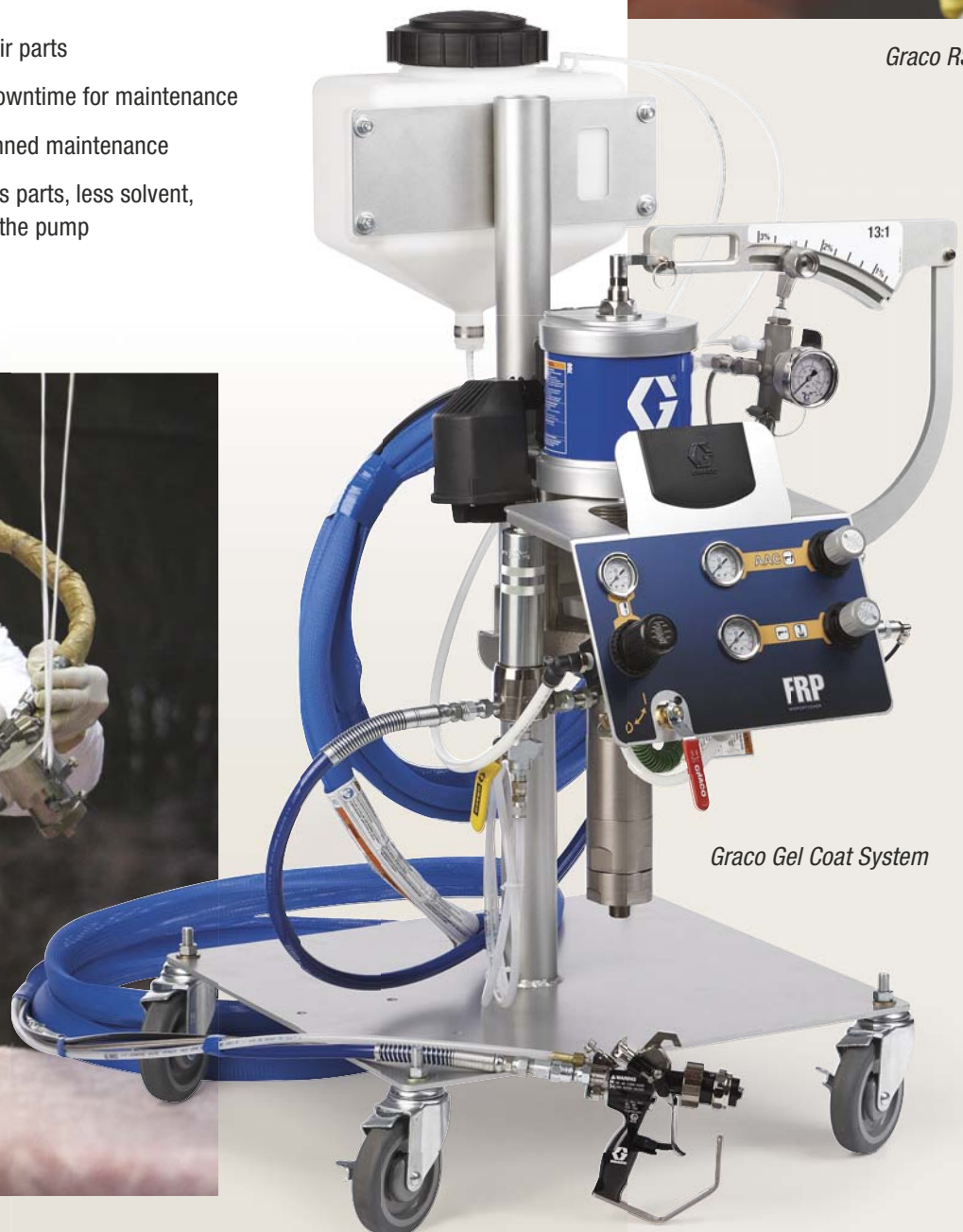
As you know, not enough catalyst in the mix creates soft spots that take longer to cure. With Graco FRP Proportioners, you're assured of a consistent ratio for a consistent cure – resulting in higher quality parts and end products. In fact, the system is optimized for ratio stability.

### Lower cost of ownership

- Easy maintenance – fewer repair parts
- Long-lasting seals mean less downtime for maintenance
- Pumps last longer between planned maintenance
- No surge bottle necessary – less parts, less solvent, and less resin needed to prime the pump

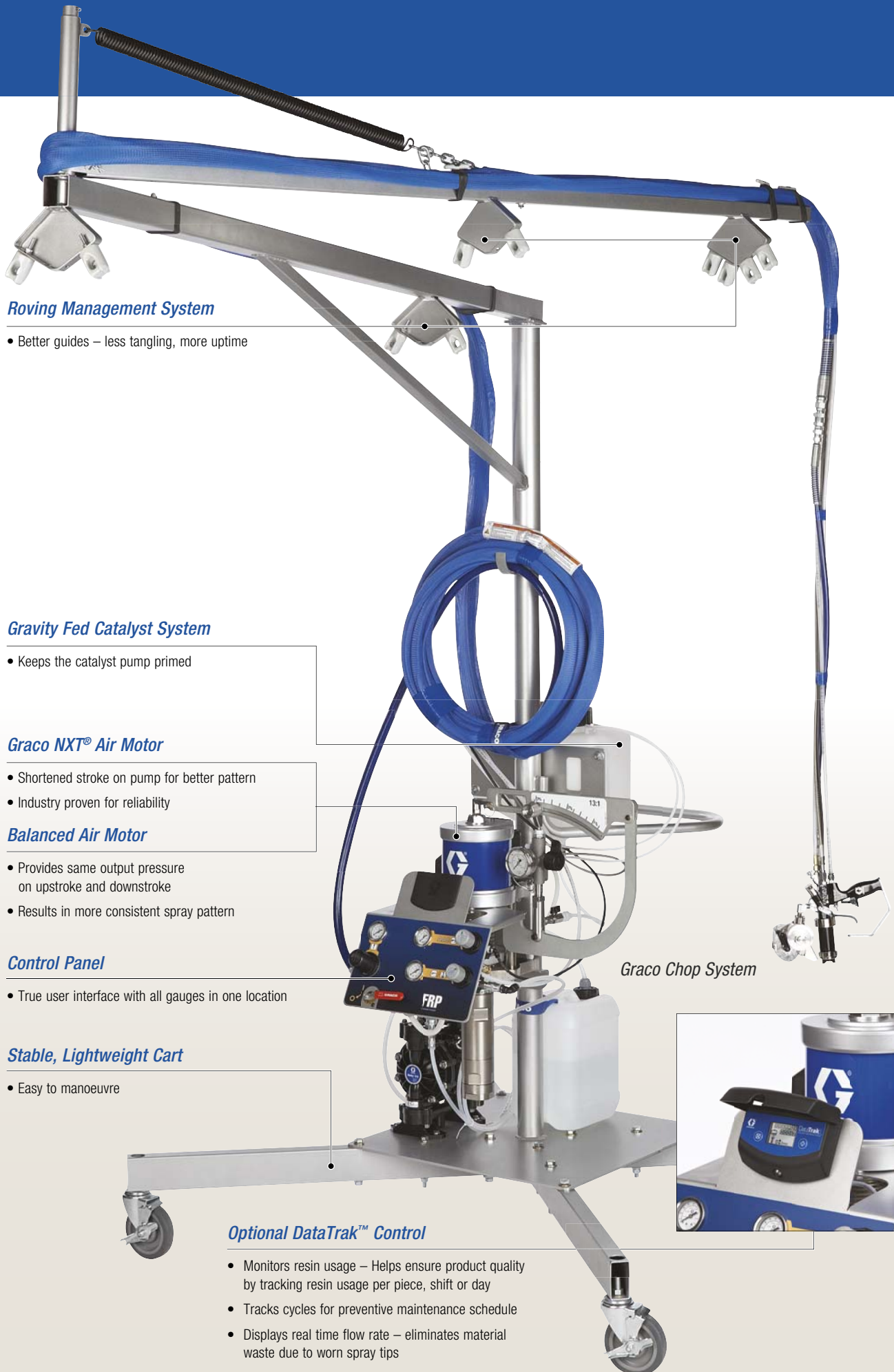


*Graco RS Gun*



*Graco Gel Coat System*





### *Roving Management System*

- Better guides – less tangling, more uptime

### *Gravity Fed Catalyst System*

- Keeps the catalyst pump primed

### *Graco NXT® Air Motor*

- Shortened stroke on pump for better pattern
- Industry proven for reliability

### *Balanced Air Motor*

- Provides same output pressure on upstroke and downstroke
- Results in more consistent spray pattern

### *Control Panel*

- True user interface with all gauges in one location

### *Stable, Lightweight Cart*

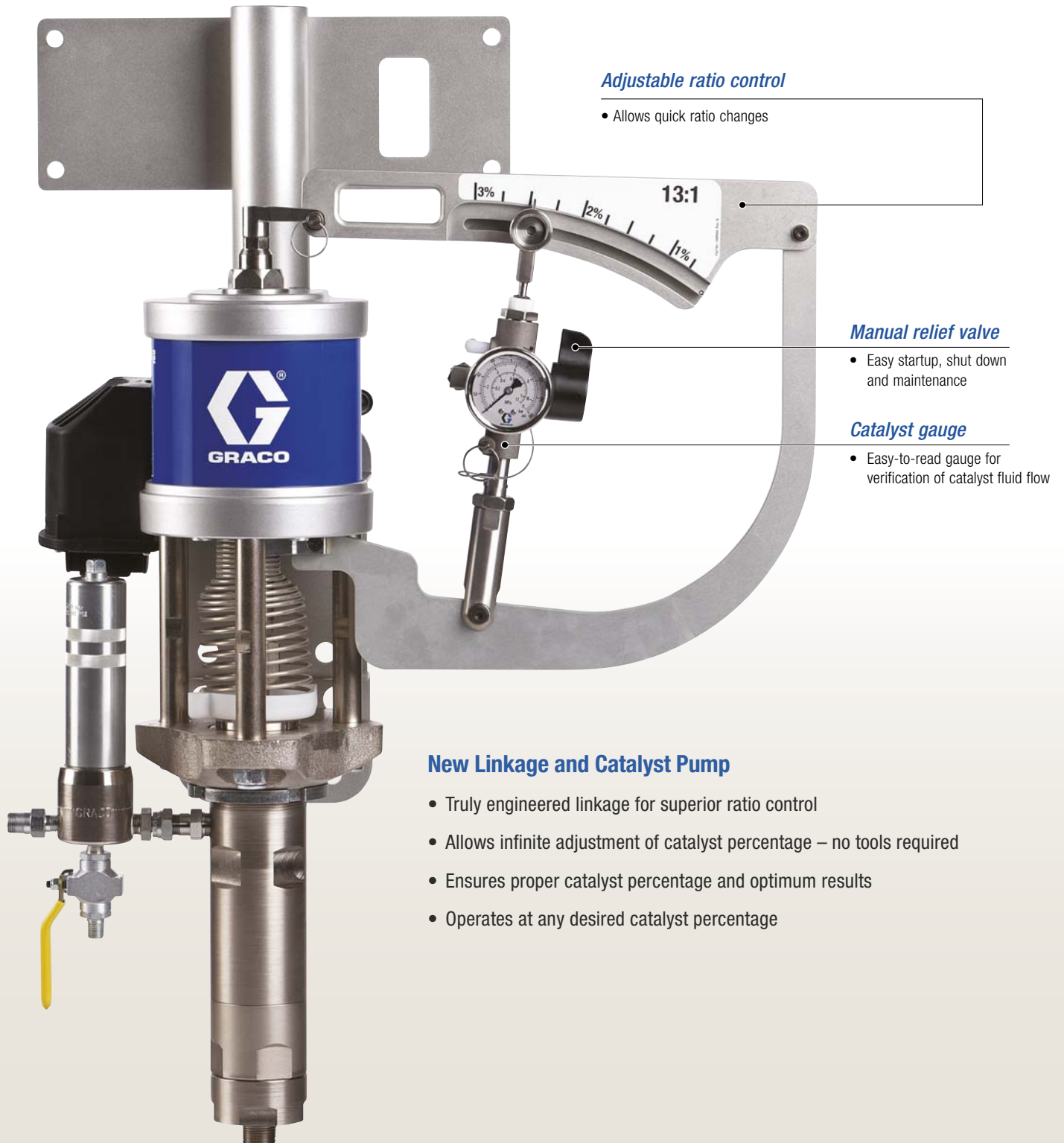
- Easy to manoeuvre

### *Graco Chop System*

### *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

# Engineered for superior ratio control



# A revolution for the FRP industry

## Discover the next generation of gel coat and chop guns

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

### Quick-disconnect front end

- Increases production time, reduces clean-up time
- Easy shutdown procedures – simply place front end or whole gun in solvent

### 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

### Lightweight, high-output cutter

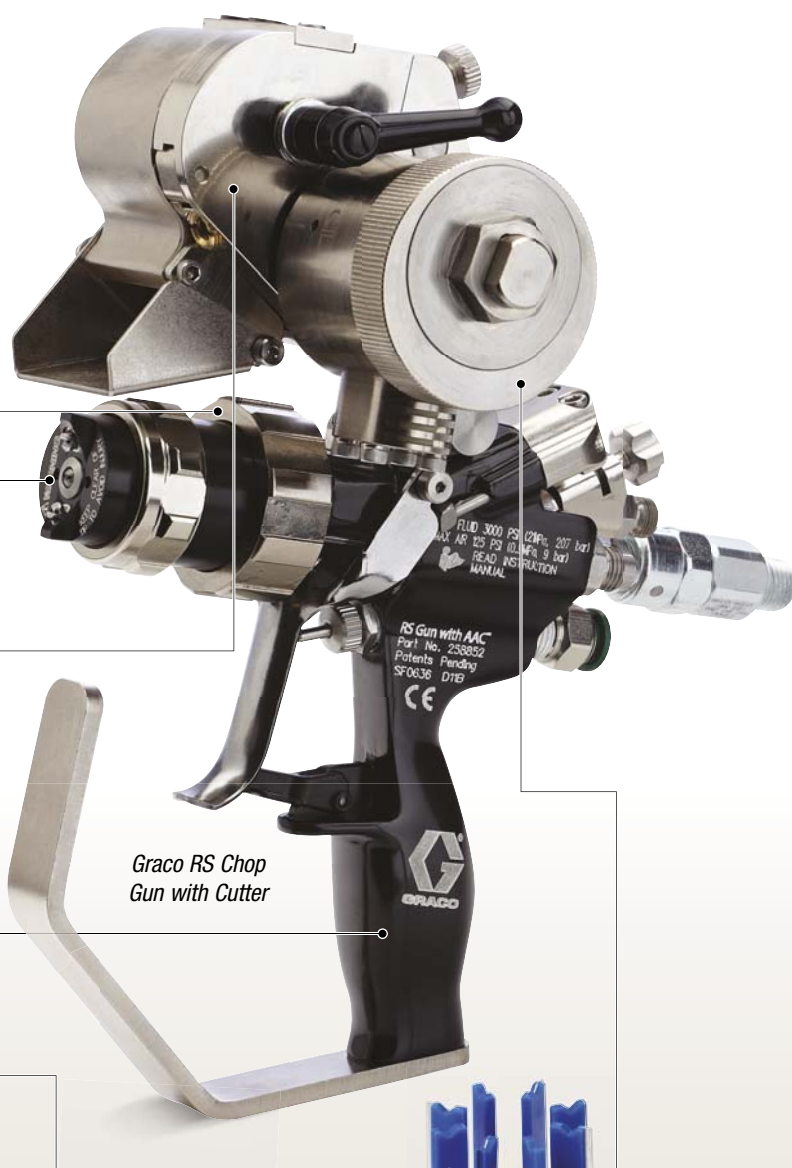
- Allows you to get the glass output you need with fewer strands of roving
- Fewer strands of roving means less chance of tangling, easier handling and more uptime
- External anvil adjustment lets you adjust anvil tension to correct cut variations due to anvil and blade wear

### Lightweight and ergonomic handle

- Less operator fatigue

### Tool-less blade design for more uptime

- No tools required – easy to change blades in seconds



Graco RS Chop Gun with Cutter



Graco RS Gel Coat Gun

### Speed control

- Lets you adjust glass output on the fly

### Unique needle clamp design

- Designed to retain the factory adjustment
- Eliminates need to adjust needle setting after routine service

Graco RS Chop Guns and Graco RS Gel Coat Guns are both available in internal and external mix models.



# System Ordering Information

			No Cart		Cart		Cart, Mast and Boom	
			Hose Length*		Hose Length*		Hose Length*	
			Part #	m (ft)	Part #	m (ft)	Part #	m (ft)
<b>13:1 Ratio</b> Max Air Consumption** – 35 scfm Max Fluid Output** – 5.7 lpm (1.5 gpm)	Internal Mix	Gel	16R065	7.6 (25)	16R002	7.6 (25)	16R053	7.6 (25)
			16R068	10.7 (35)	16R044	10.7 (35)	16R056	10.7 (35)
			16R071	15.2 (50)	16R047	15.2 (50)	16R059	15.2 (50)
			16R074	(None)	16R050	(None)	16R062	(None)
		Chop	16R135	7.6 (25)	16R123	7.6 (25)	16R004	7.6 (25)
			16R138	10.7 (35)	16R114	10.7 (35)	16R126	10.7 (35)
			16R141	15.2 (50)	16R117	15.2 (50)	16R129	15.2 (50)
			16R144	(None)	16R120	(None)	16R132	(None)
	External Mix	Gel	16R030	7.6 (25)	16R001	7.6 (25)	16R018	7.6 (25)
			16R033	10.7 (35)	16R009	10.7 (35)	16R021	10.7 (35)
			16R036	15.2 (50)	16R012	15.2 (50)	16R024	15.2 (50)
			16R039	(None)	16R015	(None)	16R027	(None)
		Chop	16R100	7.6 (25)	16R088	7.6 (25)	16R003	7.6 (25)
			16R103	10.7 (35)	16R079	10.7 (35)	16R091	10.7 (35)
			16R106	15.2 (50)	16R082	15.2 (50)	16R094	15.2 (50)
			16R109	(None)	16R085	(None)	16R097	(None)
<b>17:1 Ratio</b> Max Air Consumption** – 35 scfm Max Fluid Output** – 3.8 lpm (1 gpm)	Internal Mix	Gel	16R205	7.6 (25)	16R006	7.6 (25)	16R193	7.6 (25)
			16R208	10.7 (35)	16R184	10.7 (35)	16R196	10.7 (35)
			16R211	15.2 (50)	16R187	15.2 (50)	16R199	15.2 (50)
			16R214	(None)	16R190	(None)	16R202	(None)
	External Mix	Gel	16R170	7.6 (25)	16R005	7.6 (25)	16R158	7.6 (25)
			16R173	10.7 (35)	16R149	10.7 (35)	16R161	10.7 (35)
			16R176	15.2 (50)	16R152	15.2 (50)	16R164	15.2 (50)
			16R179	(None)	16R155	(None)	16R167	(None)

\* Systems without hoses do not come with guns \*\* Fluid and air flow rate for 70 cpm



## Solvent Flush Kits

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

## Heater Kits

- 16N018 Viscon® HP Heater Kit (120V - 4 kW)
- 16N019 Viscon HP Heater Kit (240V - 4 kW)
- 16N016 Viscon HP Hazardous Locations Heater Kit (120V - 4 kW)
- 16N017 Viscon HP Hazardous Locations Heater Kit (240V - 4 kW)
- 16N014 Viscon Heater Kit (120V - 2.1 kW)
- 16N015 Viscon Heater Kit (240V - 2.1 kW)
- 16N119 Heater Mount Kit

## Optional Kits

- 16M881 DataTrak Upgrade Kit
- 24M501 19 l (5 gal) Catalyst Tank Kit
- 16M896 208 l (55 gal) Drum Cart for Cart, Mast and Boom
- 16M897 208 l (55 gal) Drum Cart for Pole Cart
- 16M961 Roving Box Kit
- 16N918 Wall Mount Bracket Kit
- 16N761 Boom Kit

## Hose Kits

- 16M718 Internal Gel Hose Extension 7.6 m (25 ft)
- 16M587 Internal Gel Hose Bundle 7.6 m (25 ft)
- 16M590 Internal Gel Hose Bundle 10.7 m (35 ft)
- 16M584 Internal Gel Hose Bundle 15.2 m (50 ft)
- 16M719 External Gel Hose Extension 7.6 m (25 ft)
- 16M588 External Gel Hose Bundle 7.6 m (25 ft)
- 16M591 External Gel Hose Bundle 10.7 m (35 ft)
- 16M585 External Gel Hose Bundle 15.2 m (50 ft)
- 16M712 Chop Hose Extension 7.6 m (25 ft)
- 16M586 Chop Hose Bundle 7.6 m (25 ft)
- 16M589 Chop Hose Bundle 10.7 m (35 ft)
- 16M583 Chop Hose Bundle 15.2 m (50 ft)

## 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

- W17CFS 17:1 Pump Assembly 75 cc SST
- W13DFC 13:1 Pump Assembly 100 cc CS
- M07LNL 4.5 in FRP NXT Air Motor
- 16N238 4.5 in FRP NXT Air Motor - Seal Kit
- LW100C 100 cc FRP Lower
- 16N232 100 cc FRP Lower - Seal Kit
- 16N243 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
- 16N740 Internal Mix Catalyst Pump Assembly
- 16N741 External Mix Catalyst Pump Assembly
- 16N919 Catalyst Pump Rebuild Kit



# Gun Ordering Information



## RS Guns

- 258853 RS Internal Mix Gel Coat Gun, includes CST521 tip
- 258840 RS External Mix Gel Coat Gun, includes CST521 tip
- 258971 RS Internal Mix Chop Gun with Cutter, includes CST443 tip
- 258970 RS External Mix Chop Gun with Cutter, includes CST443 tip
- 258854 RS Internal Mix Chop Gun without Cutter, includes CST443 tip
- 258852 RS External Mix Chop Gun without Cutter, includes CST443 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
- 123672 Anvils
- 16K768 RS RTM and Pour Adapter
- 24H337 Internal Mix High Flow Kit
- 24H336 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

## Airless Composite Spray Tips (CSTXXX)

		ORIFICE SIZE - INCHES											
Fan Width	IN (MM)	0.015	0.017	0.019	0.021	0.023	0.027	0.031	0.035	0.043	0.051	0.061	0.071
	4 102	215	217	219	221	223	227	231	235				
	6 152	315	317	319	321	323	327	331	335	343	351		
	8 203	415	417	419	421	423	427	431	435	443	451	461	471
	10 254	515	517	519	521	523	527	531	535	543	551	561	571
	12 305	615	617	619	621	623	627	631	635	643	651	661	671

## Impingement Composite Spray Tips (CSTXXX)

		ORIFICE SIZE - INCHES							
Fan Width	IN (MM)	0.018	0.021	0.036	0.042	0.052	0.062	0.070	0.081
	6 152	S31	S32	S33	S34	S35	S36	S37	
	8 203	S41	S42	S43	S44	S45	S46	S47	
	10 254	S51	S52	S53	S54	S55	S56	S57, T57	S58
	12 305	S61	S62	S63	S64	S65	S66, T66	S67	S68
	14 356	S71	S72	S73	S74	S75	S76	S77	S78
	16 406	S81	S82	S83	S84	S85	S86	S87	S88
	18 457	S91	S92						

## HOW TO READ A COMPOSITE SPRAY TIP NUMBER

### Airless Composites 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.

### Impingement Composite Spray Tips - For example: CSTS75

1. The first three letters (CST) = Composite Spray Tip.
2. The 4th digit indicates S for stainless steel or T for tool steel.
3. The 5th digit indicates spray pattern width code.  
Double the number to get pattern width at 18 inches.  
In this case, 7 equals a 14-inch pattern width at an 18-inch spraying distance.



## 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 is certified ISO 9001.

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