



Gelcoat Dispense Systems

Low-Emission Gelcoat Systems for the Composites Industry



GLASCRAFT
COMPOSITES EQUIPMENT BY GRACO

PROVEN QUALITY. LEADING TECHNOLOGY.

GlasCraft® Gelcoat Dispense Systems

Designed for smooth, accurate gelcoat application, GlasCraft Gelcoat Dispense Systems are engineered to deliver reliable performance. Built with fewer wear items, GlasCraft equipment consumes fewer replacement parts. With reduced service expenses and less revenue lost due to downtime, GlasCraft's Gelcoat Systems are highly economical to own and operate.

GlasCraft Gel-Coat Systems:

- Dispense pigmented, tooling, low-VOC and specialty gelcoats
- Offer reliable, highly accurate catalyst percentage
- Provide high-efficiency performance at low spraying pressures
- Available in internal and external mix configurations

Typical applications:

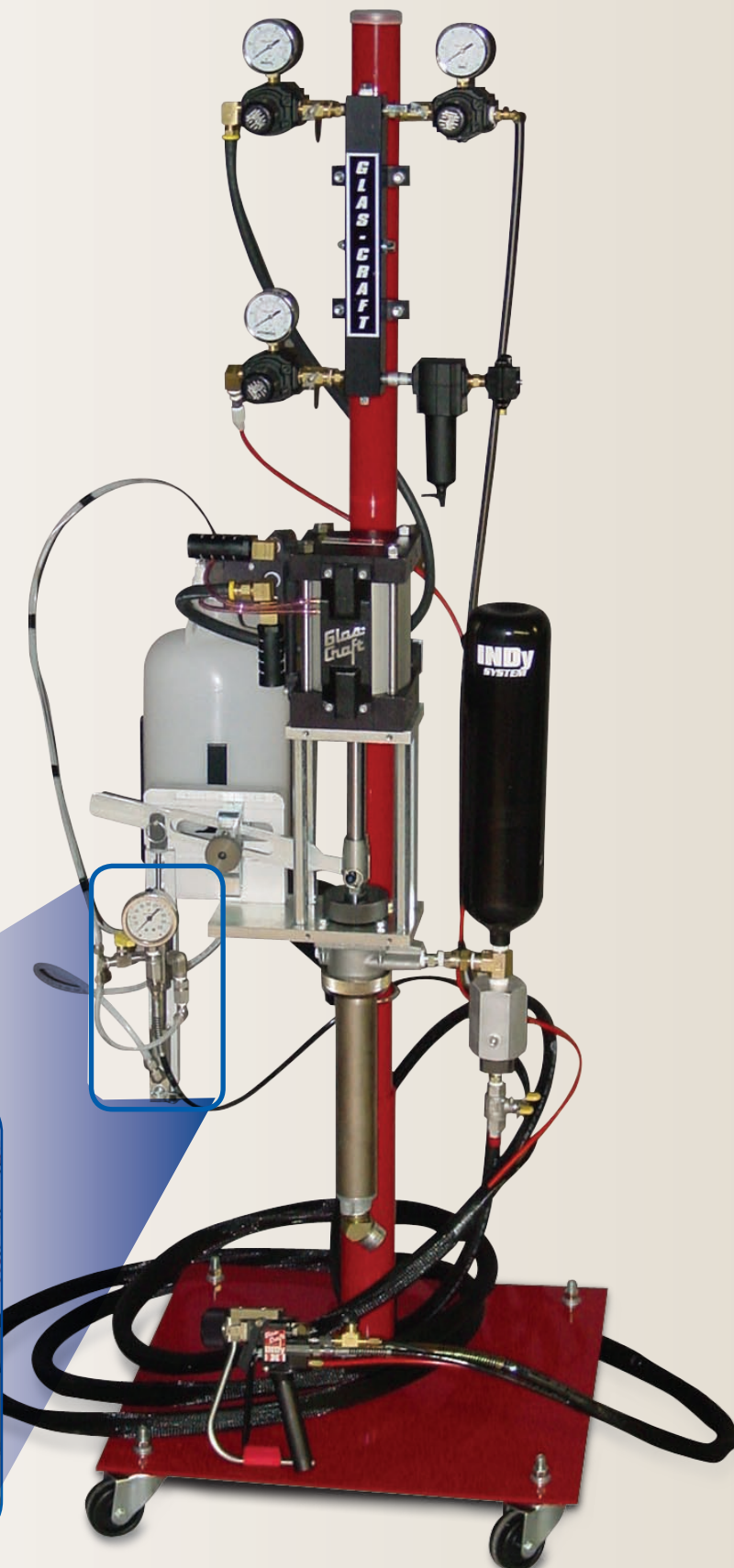
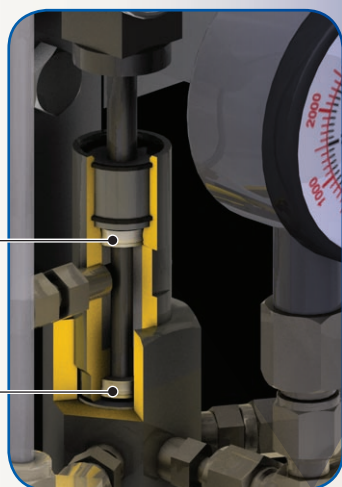
- Marine and water craft
- Pool and spa
- Bathware
- Transportation
- Cultured marble

Dual Upper Seals on Catalyst Pump

- Dual seal prevents leakage – any weepage past the primary seal is returned to the catalyst reservoir, not on the floor

Secondary shaft seal

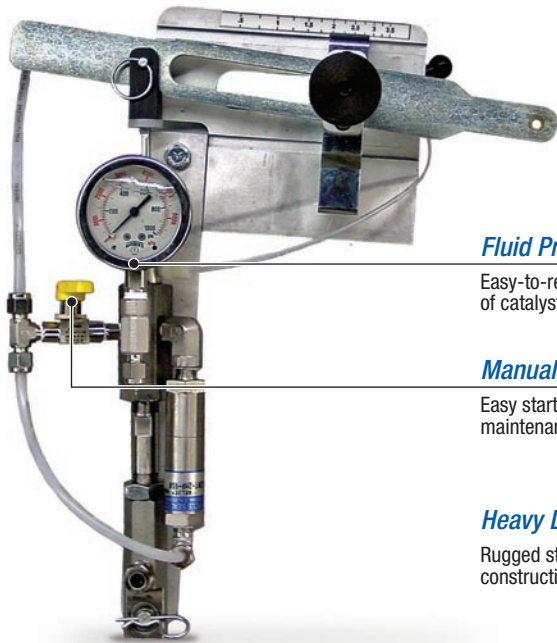
Primary shaft seal



Long-life Design

- Triple-lip spring-loaded seals and hardened cylinders, seats and valves provide long wear life

GlasCraft INDY X Gelcoat Dispense System



Fluid Pressure Gauge

Easy-to-read gauge for verification of catalyst fluid flow

Manual Relief Valve

Easy startup, shut down and maintenance

Heavy Duty

Rugged stainless steel construction

Adjustable-Ratio Catalyst Pump

- Allow infinite adjustment of catalyst percentage – no tools required
- Ensures proper catalyst percentage and optimal results
- Operates at any desired catalyst percentage
 - 0.5% to 3.5% for 11:1 system
 - 0.5% to 2.9% for 17:1 system
 - 0.8% to 5.6% for 20:1 system
 - 1.5% to 8.2% for 13:1 G2 system

Gelcoat Pump

- Reliable, low-maintenance reciprocating piston pump for moving pigmented, tooling, low-VOC and specialty gelcoats
- Piston pump works well with fillers
- Standard pump offers 11:1 ratio
- Develops up to 89 bar (8.9 MPa, 1300 psi)
- Delivers up to 9.5 lpm (2.5 gpm)

Optional resin pumps:

HVRP 17:1 pump

- Designed for high volume gelcoat or polyester resin applications
- Ideal for high volume production shops
- Develops up to 117 bar (11.7 MPa, 1700 psi)
- Delivers up to 15.5 lpm (4.1 gpm)

20:1 pump

- For high-viscosity materials
- Develops up to 138 bar (13.8 MPa, 2000 psi)
- Delivers up to 6.0 lpm (1.6 gpm)



Precision Air Pilot Valve

Allows fast pneumatic changeover without any parts to wear out

Surge Bottle Accumulator

Compensates for pressure spikes

Quick Change Seal Design

- Tool-less quick disconnect allows easy top seal maintenance
- Lower end is easily removed to service lower seals on pump

4" Stroke

Uses fewer cycles, which means less wear and increased uptime

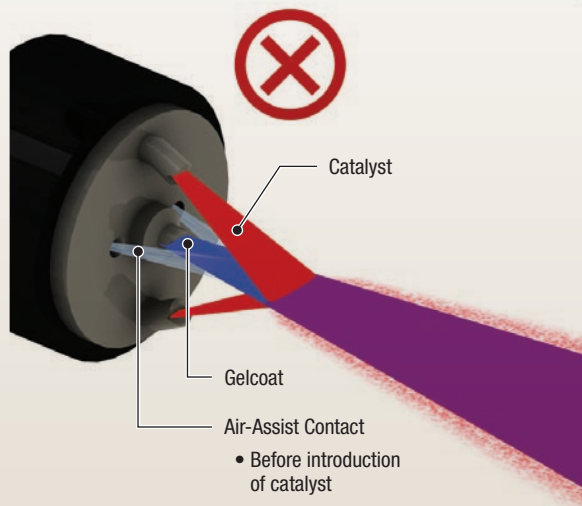
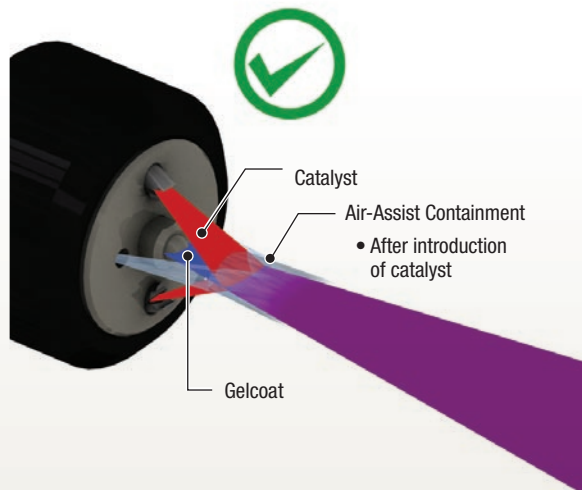
Air-Assist Containment

Advanced technology to control and contain your spray pattern

When you buy a drum of resin or gelcoat, you pay for every drop of material. It makes good economic sense to put as many of those drops as possible on the mold.

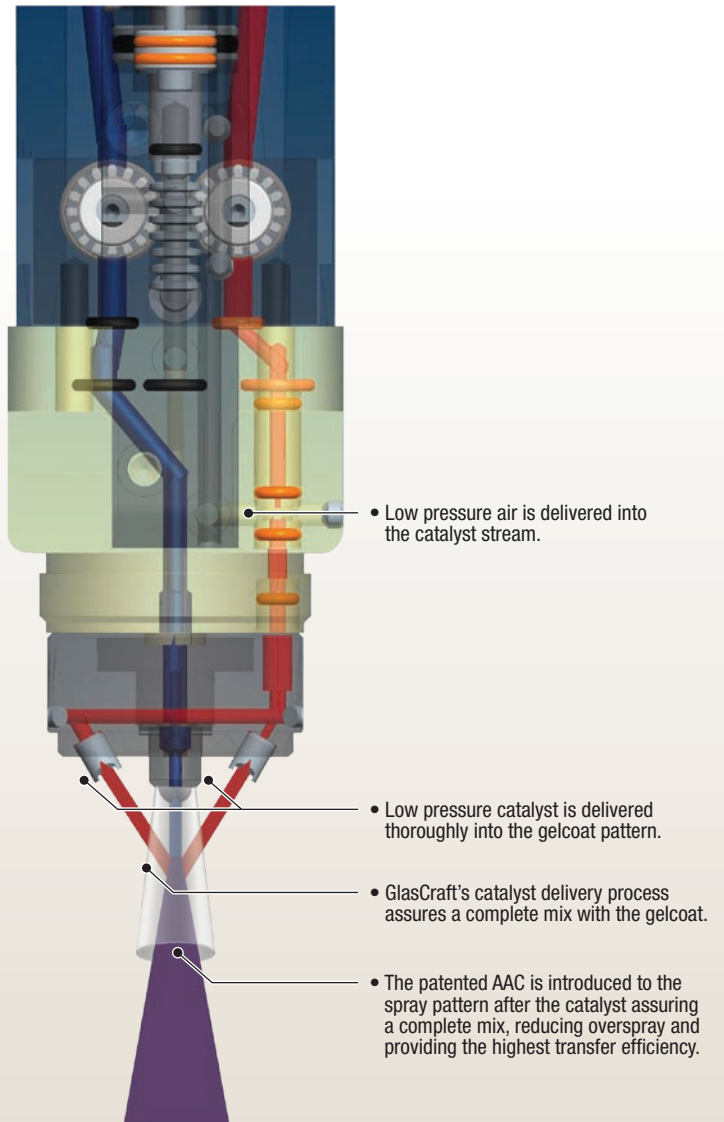
GlasCraft's exclusive Air-Assist Containment (AAC) wraps the spray pattern in a containment shield of air – preventing atomized droplets from escaping the spray pattern. Droplets that escape and end up on the floor, wall or employee's clothing are a waste of money.

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.



AAC improves your profit picture

- All GlasCraft external mix spray guns feature the patented AAC technology
- Reduces material waste – which results in more molds gelcoated per drum of material
- Precise catalyst delivery and reduced particle velocity assure the highest quality finish
- Less overspray means a healthier work area for employees



GlasCraft Gelcoat Spray Guns

Uniform spray pattern

GlasCraft's Gelcoat guns feature the patented AAC feature to produce the most uniform and consistent low-emission spray pattern with stabilizing air streams.

Formula Guns

- Air-actuated trigger provides immediate response, virtually eliminating hot and cold spots
- No-needle design eliminates needle adjustments
- Special hardened valves are engineered for today's low VOC formulations
- Fluid control occurs via air-operated piston that opens and closes internal ball valves
- Easy access to valve packings for quick maintenance and increased uptime
- Feature AAC technology for uniform spray pattern with minimal overspray



Formula Internal Mix Gun

- Precision check valves automatically balance fluid pressures
- Extended mix area results in the best mix



Formula X External Mix Gun

- Unique catalyst delivery assures complete integration to the gelcoat spray pattern
- Easy visual verification of catalyst flow
- No solvent needed to flush

INDy Spray Guns

- Volume control assures the highest quality finish with minimal porosity
- Simple material valve and seat design is easy to maintain, resulting in increased uptime
- Features AAC for excellent pattern control and less wasted material
- Ergonomic, lightweight design reduces operator fatigue



INDy Internal Mix Gun

- Fully adjustable pattern control and precision check valves to automatically balance fluid pressures
- Extended mix area results in the best mix



INDy X External Mix Gun

- Unique catalyst delivery assures complete integration to the gelcoat spray pattern
- No solvent needed to flush

What's the difference between external and internal mix guns?

External mix guns:

- Ideal for gelcoat applications
- Chemical is mixed outside the gun
- Operators can see the catalyst being added to the mix
- Does not require a solvent flush

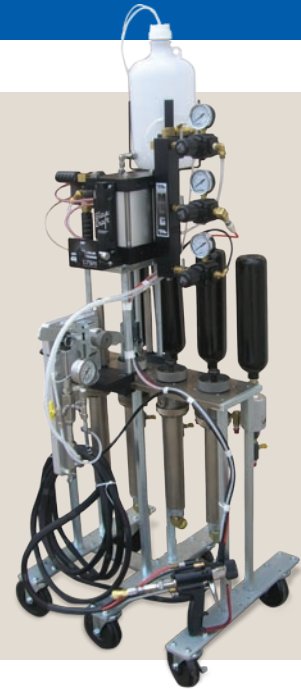
Internal mix guns:

- Ideal for chopper and wet-out systems
- Ensures the best possible mix
- Requires a solvent flush for maintenance

Solutions for the Composites Industry

GlasCraft Multiple Colour Gelcoat System

- Ideal for applications that require numerous gelcoat colours or continuous change of colours
- Quick, efficient colour changes reduce downtime
- The standard two-colour system can be expanded with additional colours by adding optional fluid section kits
- Flexible design lets you use one system for both resin and gelcoat dispensing



GlasCraft G2-SSP Gelcoat System

- Designed to deliver outstanding performance in an economical package
- Along with the INDy X gun, the G2-SSP provides the optimal spray pattern with the highest transfer efficiency
- INDy X gun is standard
- Optional Formula X gun is available
- 13:1 External mix only
- Delivered fully assembled



Technical Specifications

	G2-SSP	INDy/Formula 11:1 or MCG 11:1	INDy/Formula 20:1 or MCG 20:1	HVRP 17:1
Air requirement	425 lpm @ 6.8 bar (15 cfm @ max output)	480 lpm @ 6.8 bar (35 cfm @ max output)	480 lpm @ 6.8 bar (35 cfm @ max output)	620 lpm @ 6.8 bar (80 cfm @ max output)
Material pump capacity*	3.79 lpm (1 gpm)	9.5 lpm (2.5 gpm)	6.0 lpm (1.6 gpm)	15.5 lpm (4.1 gpm)
Material pump output	80 ccm/cycle; 50 cycles = 1 gal; 13 cycles = 1 liter	190 ccm/cycle; 20 cycles = 1 gal; 5 cycles = 1 liter	120 ccm/cycle; 31 cycles = 1 gal; 8 cycles = 1 liter	310 ccm/cycle; 12 cycles = 1 gal; 3 cycles = 1 liter
Catalyst slave pump range	1.5% to 8.2%	0.5% to 3.5%	0.8% to 5.6%	0.5% to 2.9%

* Material pump capacity is based on 50 cycles per minute. Higher cycle rates can be achieved depending on material viscosity, material temperature and volume of air. All pump outputs are measured at the pump outlet using water as the test media.

Accessories - Spray Tips

Part Number	Orifice	Part Number	Orifice	Part Number	Orifice
23005-C4	0.04	23005-M5	0.05	LPA2 147 2325	0.023
23005-C5	0.05	23005-M6	0.06	LPA2 147 2340	0.023
23005-C6	0.06	23005-P4	0.04	LPA2 147 2350	0.023
23005-C7	0.07	23005-TC6	0.06	LPA2 147 2365	0.023
23005-C8	0.08	23005-TC7	0.07	LPA2 147 2625	0.026
23005-C9	0.09	23005-TC8	0.08	LPA2 147 2640	0.026
23005-E4	0.04	23005-TE7	0.07	LPA2 147 2650	0.026
23005-E5	0.05	23005-TG7	0.07	LPA2 147 2665	0.026
23005-E6	0.06	23047-J1	0.012	LPA2 147 3125	0.031
23005-E7	0.07	23047-J2	0.014	LPA2 147 3140	0.031
23005-E8	0.08	23047-J3	0.022	LPA2 147 3150	0.031
23005-E9	0.09	23047-M1	0.012	LPA2 147 3165	0.031
23005-G4	0.04	23047-M2	0.014	LPA2 147 3625	0.036
23005-G5	0.05	23047-M3	0.022	LPA2 147 3640	0.036
23005-G6	0.06	23047-N1	0.012	LPA2 147 3650	0.036
23005-G7	0.07	23047-N2	0.014	LPA2 147 3840	0.038
23005-G8	0.08	23047-N3	0.022	LPA2 147 3850	0.038
23005-G9	0.09	23047-P1	0.012	LPA2 147 4325	0.043
23005-J4	0.04	23047-P2	0.014	LPA2 147 4340	0.043
23005-J5	0.05	23047-P3	0.022	LPA2 147 4350	0.043
23005-J6	0.06	LPA2 147 1525	0.015	LPA2 147 4365	0.043
23005-J7	0.07	LPA2 147 1540	0.015	LPA2 147 5225	0.052
23005-J8	0.08	LPA2 147 1550	0.015	LPA2 147 5240	0.052
23005-J9	0.09	LPA2 147 1565	0.015	LPA2 147 5250	0.052
23005-K3	0.04	LPA2 147 1825	0.018	LPA2 147 5265	0.052
23005-K4	0.04	LPA2 147 1840	0.018	LPA2 147 6225	0.062
23005-K5	0.05	LPA2 147 1850	0.018	LPA2 147 6240	0.062
23005-K6	0.06	LPA2 147 1865	0.018	LPA2 147 6250	0.062
23005-K7	0.07	LPA2 147 2125	0.021	LPA2 147 6265	0.062
23005-K8	0.08	LPA2 147 2140	0.021	LPA2 147 7240	0.072
23005-K9	0.09	LPA2 147 2150	0.021	LPA2 147 7250	0.072
23005-M4	0.04	LPA2 147 2165	0.021	LPA2 147 7840	0.078

PFR Option

Part Number	Item
20335-XX	Roller cover
20335-01	Roller cover, 230 mm x 13 mm (9 in x ½ in) nap
20335-02	Roller cover, 230 mm x 19 mm (9 in x ¾ in) nap
20335-03	Roller cover, 12 in x ½ in nap
20335-04	Roller cover, 230 mm x 19 mm (9 in x ¾ in) nap
20335-05	Roller cover, 460 mm x 13 mm (18 in x ½ in) nap
20335-06	Roller cover, 18 in x ¾ in nap
20337-XX	Pole extension assembly
20337-01	Pole extension assembly, 0.5 m (1.5 ft)
20337-02	Pole extension assembly, 0.9 m (3 ft)
20337-03	Pole extension assembly, 1.8 m (6 ft)
22275-00	PFR adapter fitting
22276-00	PFR swivel fitting
22277-00	Gun roller adapter kit
22912-XX	Pressure roller assembly
22912-01	Pressure roller assembly, 23 cm (9 in)
22912-02	Pressure roller assembly, 30 cm (12 in)
23003-00	Spray tip spacer
23550-00	INDy Gun
23750-00	Formula Gun Assembly

Formula/INDy Screw on AAC Gun Head Kit

23570-00 Internal Mix Gel - Screw on AAC Gun Head Kit
NOTE: 23570 requires a regulator assembly which is not included in the kit. The following must be ordered for a complete regulator assembly.

Regulator Assembly

3165	Ball valve
4342-04	Elbow fitting
7884-07	Elbow fitting
8115-03	Nipple fitting
9704-53	Black AAC tubing (Order quantity = hose length plus 1 meter (3 feet))
18199-02	Regulator
18318-02	Gauge
20182-00	AAC decal

Formula High / High Filled Resin Mixer Conversion Parts

20310-90	3/8 in mixing element
23760-01	3/8 in front mixer housing

Small Diameter Airless/Non-Atomized

Material Tip Conversion Parts

20333-00	Gasket
22274-00	Tip spacer
23002-00	Retaining nut
LPA2 147 XXXX	Spray tip
23047-XX	Spray tip
23760-00	Gun front housing – For Formula Gun only
23502-00	Gun front housing – For INDy Gun only

Repair Kits

Formula Gun

23792-00	Gun air kit
23793-00	Gun seal kit
23732-00	Gun fluid valve kit

INDy Gun

23530-00	Complete rebuild kit
23538-00	Maintenance kit

Catalyst Pump

LPA-190-RK	Complete rebuild kit
LPA-190-SK	Seal kit

11:1 & 20:1 Air Motor (130 mm - 5 in)

GCO423	Complete service kit
GCO429	Pilot valve kit
GCO428	Main valve kit
GCO427	Gasket kit
GCO426	Stroke signal repair kit
GCO425	Rod seal kit
GCO424	Piston rod seal kit

17:1 Air Motor (150 mm - 6 in)

21380-01	Complete service kit
GCO426	Stroke signal repair kit
21381-00	Bushing rod
21382-01	Air unit
22343-00	Valve repair kit
22344-00	Pilot valve kit

Fluid Section

21570-00	Repair kit, 11:1 fluid section
21799-00	Repair kit, 17:1 fluid section
21277-00	Repair kit, 20:1 fluid section



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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