INSTRUCTIONS-PARTS LIST 307–428

This manual contains important warnings and information.
READ AND KEEP FOR REFERENCE.

INSTRUCTIONS

GRACO

First choice when quality counts.™

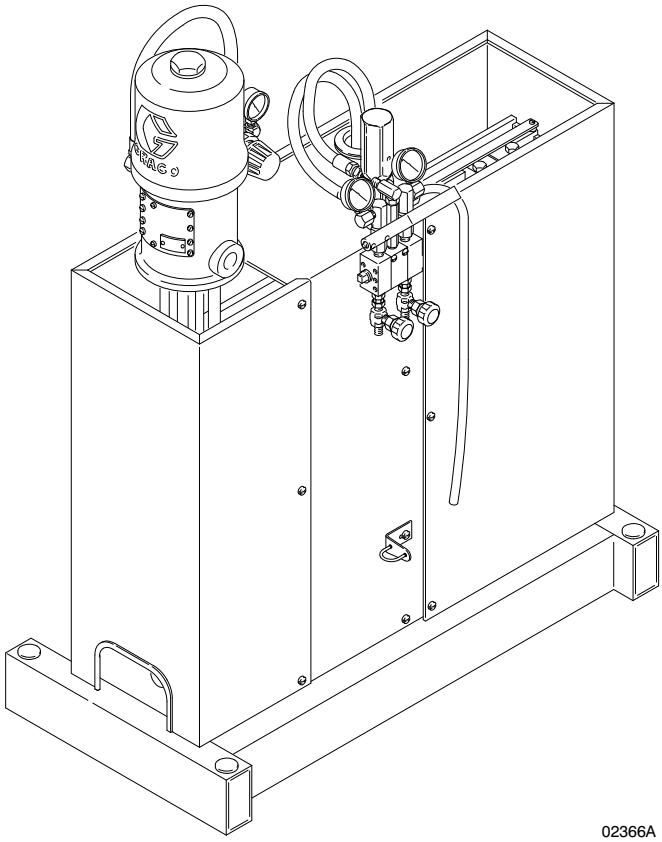
Rev. P
Supersedes N

AIR-POWERED PRESIDENT®

Variable Ratio Hydra-Cat® Proportioning Pump

120 psi (0.8 MPa, 8 bar) Maximum Working Air Pressure

Model No.	Variable Ratio Range
Model 226–933, Series B	1.0:1 to 4.5:1
Model 226–934, Series B	1.0:1 to 4.5:1
Model 226–935, Series C	0.9:1 to 4.5:1
Model 226–936, Series C	0.9:1 to 4.5:1
Model 226–937, Series C	0.9:1 to 4.5:1
Model 226–938, Series C	1.3:1 to 6.0:1
Model 226–939, Series C	1.7:1 to 7.5:1
Model 686–632, Series A*†	



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CE

***Model 686–632 is not CE certified.**

†Model 686–632 does not include pump lowers.

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Graco Inc. is registered to I.S. EN ISO 9001

Table of Contents

Specifications

The following chart gives specifications for the President Hydra-Cat Pumps using No. 10 weight oil. The volumetric ratio is expressed as the proportion of the volume of fluid of the primary pump compared to the volume of fluid of the secondary pump. Models with the same ratio range (for example, Models 226–933 and 226–934) have different volume outputs and piston effective areas.

As an example, Model 226–933 has a maximum volumetric ratio of 1.0:1. At this setting the primary and secondary pumps combined will deliver an output of 4.0 gpm (15.2 liter/min). The minimum volumetric ratio for Model 226–933 is 4.5:1, and the combined output at that setting is 2.4 gpm (9.1 liter/min).

Model* Number	Pump		Volumetric Ratio Adjustment		Volume Output gpm (liter/min) at 40 cpm		Stall Pressure with 100 psi (0.7 MPa, 7 bar) Inbound Air psi (MPa, bar)	
	Primary	Secondary	Maximum	Minimum	Maximum	Minimum	Maximum	Minimum
226–933	215–932	215–932	1.0:1	4.5:1	4.0 (15.2)	2.4 (9.1)	260 (2.4, 24)	630 (4.3, 43)
226–934	215–930	215–930	1.0:1	4.5:1	2.5 (9.5)	1.4 (5.3)	620 (4.2, 42)	1070 (7.3, 73)
226–935	222–012	222–012	0.9:1	4.5:1	1.5 (5.7)	0.9 (3.4)	1150 (7.9, 79)	1730 (12.1, 121)
226–936	222–015	222–015	0.9:1	4.5:1	1.2 (4.5)	0.7 (2.6)	1220 (8.4, 84)	2230 (15.3, 153)
226–937	222–017	222–017	0.9:1	4.5:1	1.1 (4.1)	0.7 (2.6)	1350 (9.3, 93)	2400 (16.5, 165)
226–938	222–017	222–019	1.3:1	6.0:1	1.0 (3.8)	0.7 (2.6)	1450 (9.9, 99)	2600 (17.9, 179)
226–939	222–015	222–019	1.7:1	7.5:1	0.9 (3.4)	0.7 (2.6)	1650 (11.3, 113)	2330 (16.0, 160)

*The Model number is given on a plate attached to the safety panels.

Symbols

Warning Symbol

⚠ WARNING

This symbol alerts you to the possibility of serious injury or death if you do not follow the instructions.

Caution Symbol

⚠ CAUTION

This symbol alerts you to the possibility of damage to or destruction of equipment if you do not follow the instructions.

⚠ WARNING

INSTRUCTIONS

EQUIPMENT MISUSE HAZARD

Equipment misuse can cause the equipment to rupture or malfunction and result in serious injury.

- This equipment is for professional use only.
- Read all instruction manuals, tags, and labels before operating the equipment.
- Use the equipment only for its intended purpose. If you are uncertain about usage, call your Graco distributor.
- Do not alter or modify this equipment. Use only genuine Graco parts and accessories.
- Check equipment daily. Repair or replace worn or damaged parts immediately.
- Do not exceed the maximum working pressure of the lowest rated system component. Refer to the **Technical Data** on page 35 for the maximum working pressure of this equipment.
- Use fluids and solvents which are compatible with the equipment wetted parts. Refer to the **Technical Data** section of all equipment manuals. Read the fluid and solvent manufacturer's warnings.
- Do not use hoses to pull equipment.
- Route hoses away from traffic areas, sharp edges, moving parts, and hot surfaces. Do not expose Graco hoses to temperatures above 82°C (180°F) or below –40°C (–40°F).
- Wear hearing protection when operating this equipment.
- Do not lift pressurized equipment.
- Comply with all applicable local, state, and national fire, electrical, and safety regulations.

⚠ WARNING

INJECTION HAZARD

Spray from the gun/dispense valve, hose leaks or ruptured components can inject fluid into your body and cause extremely serious injury, including the need for amputation. Fluid splashed in the eyes or on the skin can also cause serious injury.

- Fluid injected into the skin might look like just a cut, but it is a serious injury. **Get immediate medical attention.**
- Do not point the gun/dispense valve at anyone or at any part of the body.
- Do not put your hand or fingers over the spray tip/nozzle.
- Do not stop or deflect leaks with your hand, body, glove or rag.
- Do not “blow back” fluid; this is not an air spray system.
- Always have the tip guard and the trigger guard on the gun when spraying.
- Check the gun diffuser operation weekly. Refer to the gun manual.
- Be sure the gun/dispense valve trigger safety operates before spraying/dispensing.
- Lock the gun/dispense valve trigger safety when you stop spraying/dispensing.
- Follow the **Pressure Relief Procedure** on page 15 whenever you: are instructed to relieve pressure; stop spraying/dispensing; clean, check, or service the equipment; and install or clean the spray tip/nozzle.
- Tighten all fluid connections before operating the equipment.
- Check the hoses, tubes, and couplings daily. Replace worn, damaged, or loose parts immediately. Permanently coupled hoses cannot be repaired; replace the entire hose.
- Use only Graco approved hoses. Do not remove the spring guard that is used to help protect the hose from rupture caused by kinks or bends near the couplings.

PLURAL COMPONENT FLUID HAZARD

Before using this equipment, read the fluid manufacturer’s warnings and determine all facts relating to the fluids used, including any of the potential hazards relating to toxic fumes, fires, explosions, reaction times, and exposure of human beings to the individual components or their resultant mixtures.

- Know the specific hazards of the fluid you are using.
- Store hazardous fluid in an approved container. Dispose of hazardous fluid according to all local, state and national guidelines.
- Always wear protective eyewear, gloves, clothing and respirator as recommended by the fluid and solvent manufacturer.
- Graco does not manufacture or supply any of the reactive chemical components that may be used in this equipment and is not responsible for their effects. Graco assumes no responsibility for loss, damage, expense or claims for personal injury or property damage, direct or consequential, arising from the use of such chemical components.

⚠ WARNING

FIRE AND EXPLOSION HAZARD

Improper grounding, poor ventilation, open flames or sparks can cause a hazardous condition and result in a fire or explosion and serious injury.

- Ground the equipment and the object being sprayed. Refer to **Grounding** on page 8.
- If there is any static sparking or you feel an electric shock while using this equipment, **stop spraying/dispensing immediately.** Do not use the equipment until you identify and correct the problem.
- Provide fresh air ventilation to avoid the buildup of flammable fumes from solvents or the fluid being sprayed/dispensed.
- Keep the spray/dispense area free of debris, including solvent, rags, and gasoline.
- Electrically disconnect all equipment in the spray/dispense area.
- Extinguish all open flames or pilot lights in the spray/dispense area.
- Do not smoke in the spray/dispense area.
- Do not turn on or off any light switch in the spray/dispense area while operating or if fumes are present.
- Do not operate a gasoline engine in the spray/dispense area.

MOVING PARTS HAZARD

Moving parts, such as the air motor piston, can pinch or amputate your fingers.

- Keep clear of all moving parts when starting or operating the pump.
- Before servicing the equipment, follow the **Pressure Relief Procedure** on page 15 to prevent the equipment from starting unexpectedly.

Definition of Terms

VRHC: An abbreviation for Variable Ratio Hydra-Cat Pump. This system automatically proportions and mixes two or three fluids in a prescribed ratio, which is variable within the ranges listed on the cover of this manual.

BASE: Also called polyol or resin, is one of two reactive chemicals used in a plural component system.

REDUCER: Also called true solvent or diluent, is used to thin the base.

CATALYST: Also called hardner or activator, is the fluid which reacts with the base fluid.

PART: An undefined unit of measurement. When you determine the size of the unit (ounce, pint, gallon), use that measurement consistently in setting up your system.

Installation

The Typical Installations in Figs. 1 and 2 are only guidelines to setting up the complete VRHC system. Two types of applications are shown: an airless spray dispensing system for spraying light viscosity fluids, and a dispensing system for medium viscosity fluids. For assistance in designing a system to suit your particular needs, contact your Graco distributor.

KEY

E Air Supply
F Base Supply
G Catalyst Supply
H Base Supply Pump
J Air Shutoff Valve
K Catalyst Supply Pump
L Air Line Filter
M Air Line Lubricator (location shown)
N Mixer Manifold Reducer Inlet
P Static Mixer
R Primary Pump Inlet
T Secondary Pump Inlet
U Reducer Pump
V Airless Spray Gun
W Dispensing Valve
X Grounded Fluid Hose
8 Air Pressure Gauge
13 Air Regulator
45 Bleed–type Master Air Valve
46 Pressure Relief Valve
104 Pressure Gauge
119 Sampling Valves
120 Mixer Manifold
123 Primary Proportioning Pump
124 Secondary Proportioning Pump

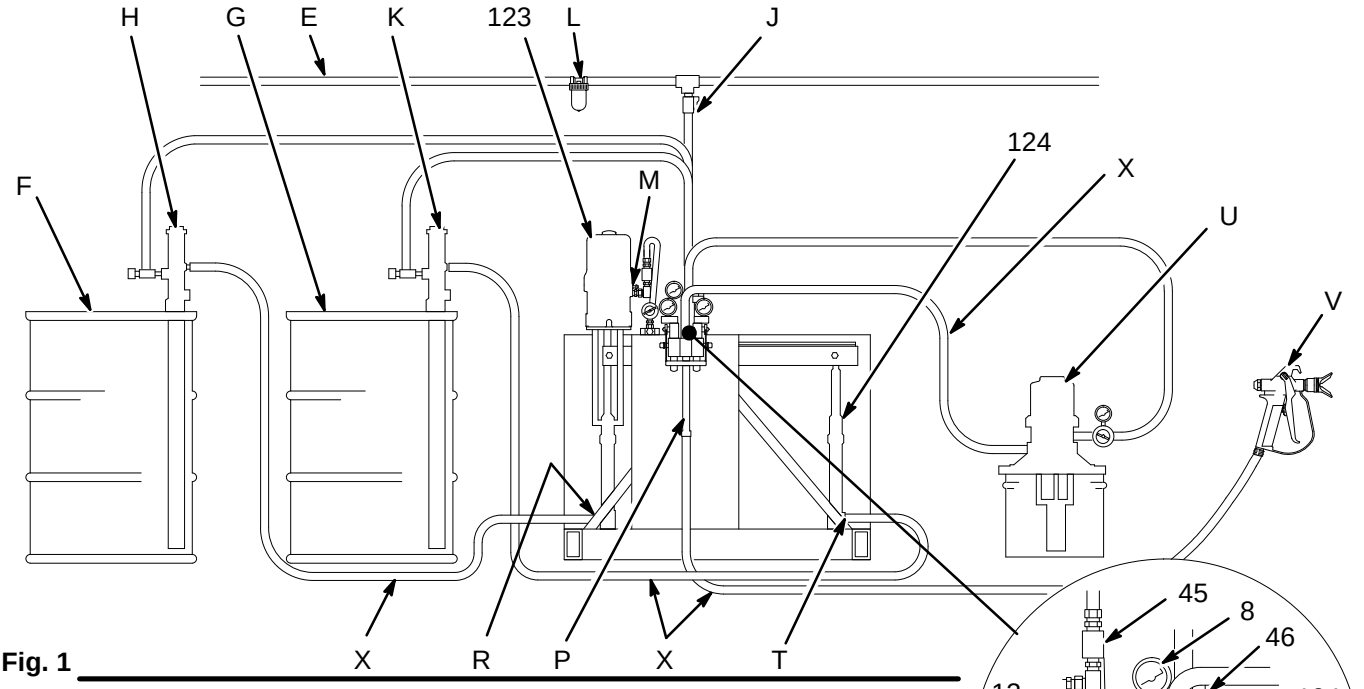


Fig. 1

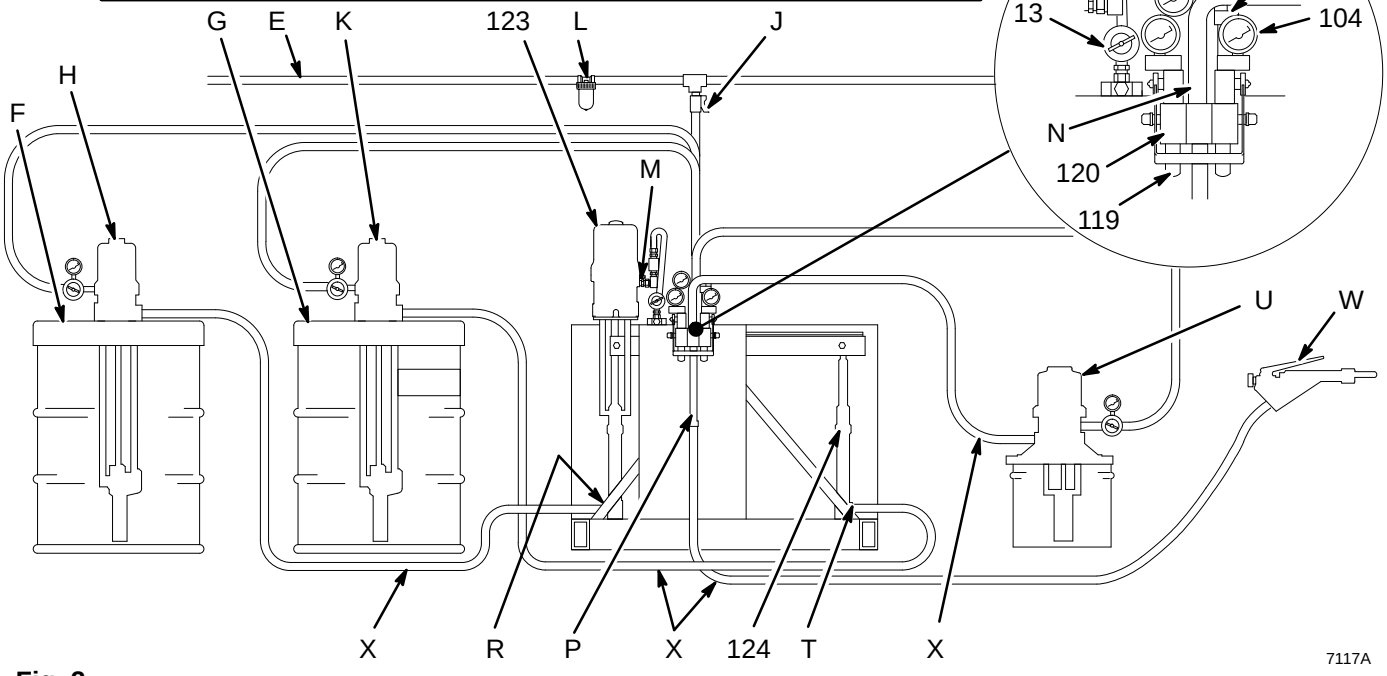


Fig. 2

Installation

NOTE: Reference numbers and letters in the text refer to Figures 1 to 18 and the Parts drawings.

Location

Sit the proportioner on a flat floor positioner.

Connect the Solvent Flush Supply Line

Remove the safety panels (38,39,40). See Fig. 4 on page 9. Connect a grounded fluid hose (X) from the solvent flush pump to the 3/8 npt solvent flush inlet (N) of the mixer manifold.

Connect the Fluid Supply Lines

Connect grounded fluid hoses to the 3/4 npt(f) pump inlet fittings (R,T). If the unit will be pressure fed from separate supply pumps, install a fluid pressure gauge at each inlet.

NOTE: Pressurized fluid supplies must not exceed 1/4 the operating fluid pressure of the President pump. Pressure above that level will feed through the pump and improper proportioning will result.

Connect the Static Mixer to the Manifold

Connect a static mixer (P) to the 1/2 npt(m) manifold outlet. Connect a grounded fluid hose and spray gun or dispensing valve to the end of the static mixer.

Tighten all fittings. Replace the safety panels (38,39,40).

System Accessories

Refer to Figures 1 and 2 and the **Accessories** on page 29.

NOTE: To ensure maximum pump performance, be sure all accessories are properly sized to meet your system requirements.

In the air line, install an air filter (L) to remove harmful dirt and moisture from the compressed air supply. Downstream from the air filter, the air regulator (13) and the bleed-type master air valve (45), install an air line lubricator (M) to provide automatic lubrication to the motor.

⚠ WARNING

The bleed-type master air valve (45) is required in your system to relieve air trapped between this valve and the pump after the pump is shut off. Trapped air can cause the pump to cycle unexpectedly, resulting in serious injury, including amputation.

Connect the Air Supply Line

Connect a grounded air supply hose to the 1/2 npt(f) port of the air manifold (37). Open the bleed-type master air valve (45), and using the pressure gauge (8), set the air regulator (13) to the desired pressure. See Figures 1 and 2 and the parts drawing on page 31.

Pressure Relief Valve

Before operating the VRHC, make sure all components have rated working pressures of 2900 psi (20 MPa, 200 bar) or greater. For more information about the pressure relief valve, see Instruction Manual 308–547.

Installation

Grounding

⚠ WARNING

FIRE AND EXPLOSION HAZARD
Before operating the pump, ground the system as explained below. Also read the section **FIRE AND EXPLOSION HAZARD** on page 5.

1. *Pump:* use the ground wire and clamp (supplied). See Fig. 3. Loosen the grounding lug locknut (W) and washer (X). Insert one end of the ground wire (Y) into the slot in lug (Z) and tighten the locknut securely. Connect the other end of the wire to a true earth ground.

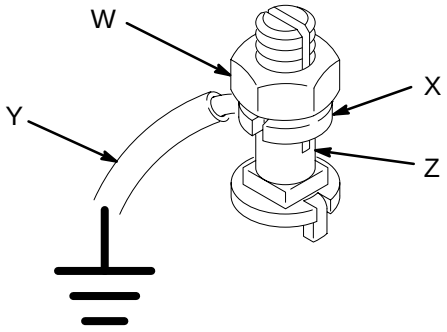


Fig. 3

2. *Air and fluid hoses:* use only electrically conductive hoses.

3. *Air compressor:* follow manufacturer's recommendations.

4. *Spray gun/dispense valve:* ground through connection to a properly grounded fluid hose and pump.

5. *Fluid supply container:* follow your local code.

6. *Object being sprayed:* follow your local code.

7. *Solvent pails used when flushing:* follow your local code. Use only metal pails, which are conductive, placed on a grounded surface. Do not place the pail on a nonconductive surface, such as paper or cardboard, which interrupts the grounding continuity.

8. *To maintain grounding continuity when flushing or relieving pressure*, hold a metal part of the spray gun/dispense valve firmly to the side of a grounded *metal* pail, then trigger the gun/valve.

Ratio Adjustment

Understanding the terms used with the **Variable Ratio Hydra-Cat® (VRHC) System,** how it functions, and how to find and set the correct ratio(s) for your application, is the key to easier, more versatile operation of your proportioning system.

Be sure to read and understand the following information before operating the equipment.

Terms

The **ratio** refers to the simultaneous output of a certain volume of fluid by the primary and secondary pumps.

The **primary pump** (123) is directly under the air motor; it usually pumps the base fluid.

The **secondary pump** (124) is on the opposite end of the lever arm (49). It usually pumps the catalyst. One or two secondary pumps may be used: one for pumping catalyst and the other for reducer injection. If two secondary pumps are used, then two ratios exist.

The **ratio index clamp** (30) is used to adjust the ratio of the secondary pump(s).

There are three main points to remember when applying the use of ratios:

1. Determine the ratio required.
2. Calculate the ratio setting.
3. Set the ratio on the VRHC System.

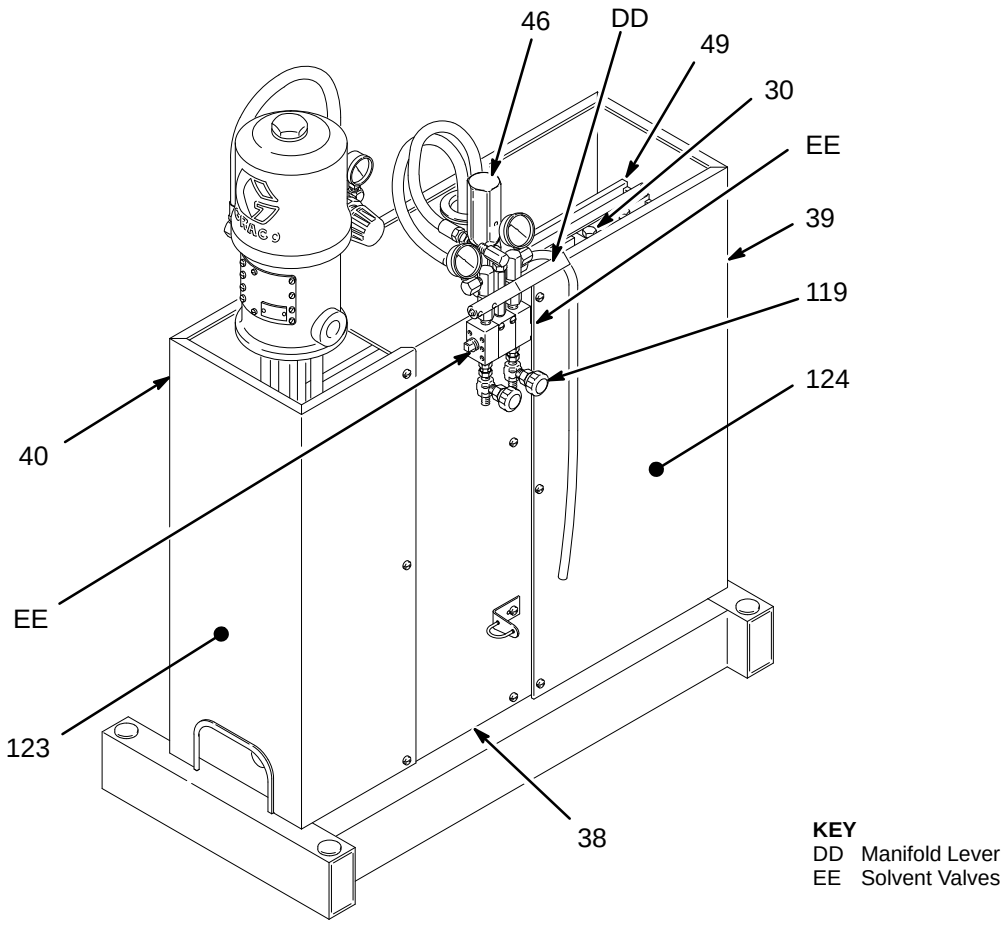


Fig. 4

Determining the Ratio

Determine your system conditions

If these are your conditions – one primary pump, one secondary pump, fluids are ready-to-spray viscosity – set the ratio as explained under **Setting the Secondary Pump(s)** on page 14.

If these are your conditions – one primary pump and one secondary pump, fluids are NOT ready-to-spray viscosity – the ratio must be determined after the reducer is added to the base, as instructed in **Procedure 1**.

If these are your conditions – two secondary pumps, one for pumping the catalyst and one for reducer injection – determine the ratio as instructed in **Procedure 2** if the mixing instructions say to reduce the base by a certain number of parts reducer, or as in **Procedure 3** if the instructions say to reduce the base by a percentage.

NOTE: Evaporation of the reducer in the base causes changes to the ratio. To prevent evaporation, store the base in closed containers.

NOTE: Some reducers have very little ability to lubricate and may cause seals to dry out. To prolong seal life, be sure your pump seals are compatible with the base's reducer. Contact your Graco distributor for the correct seals to use.

Procedure 1: Base Is Pre-reduced

When adding reducer to the base before proportioning with the VRHC System, determine the ratio of the base/reducer mixture to the catalyst in order to set the secondary pump at the correct position.

In this example, the instructions on the can say, "Mix 5 parts base to 1 part catalyst. Then reduce 3 parts of this mixture to 1 part reducer."

1. Add the parts of the base and catalyst to find the parts mixture.

   5 parts base
   + **1** parts catalyst
   6 parts mixture

2. The next statement on the can says, "Reduce 3 parts of the mixture." So divide the parts of the mixture by 3 to find the parts reducer.

   6 parts mixture
   ÷ **3** part catalyst
   2 parts reducer

3. To determine the ratio of the secondary pump, add the appropriate parts of base and reducer to find the parts combined base/reducer.

   5 parts base
   + **2** parts reducer
   7 parts combined base/reducer to 1 part catalyst:

   Result: The ratio of the secondary pump is 7:1.

Procedure 2: Reducer Injection by a Third Displacement Pump

Using the same can instructions as in Procedure 1, you know you need:

5 parts base
2 parts reducer (see Procedure 1, Step 2)
1 part catalyst

1. Treat each secondary pump as a separate assembly. The ratio of base to catalyst is 5:1, so set the catalyst pump for a 5:1 ratio.

2. The ratio of base to reducer is 5:2. But since the number on the right side of the ratio must always be one, divide the base proportion by the reducer portion.

   5 parts base
   + **2** part catalyst
   2.5 parts base

Procedure 3: Reducer Injection by a Third Displacement Pump

Use this procedure if the mixing instructions say to reduce the base by a percentage.

In this example, the instructions on the can say, "Mix 6 parts base to 1 part catalyst; reduce the base 20%."

1. Treat each secondary pump as a separate assembly. The ratio of base to catalyst is 6:1, so set the catalyst pump for a 6:1 ratio.

2. Convert the percentage to a fraction. 20% equals 1/5 or a ratio of 5:1. The ratio of base to reducer is 5:1, so set the reducer pump for a 5:1 ratio.

Set the Ratio

Fig. 5 shows the relationship between the primary pump and the secondary pump.

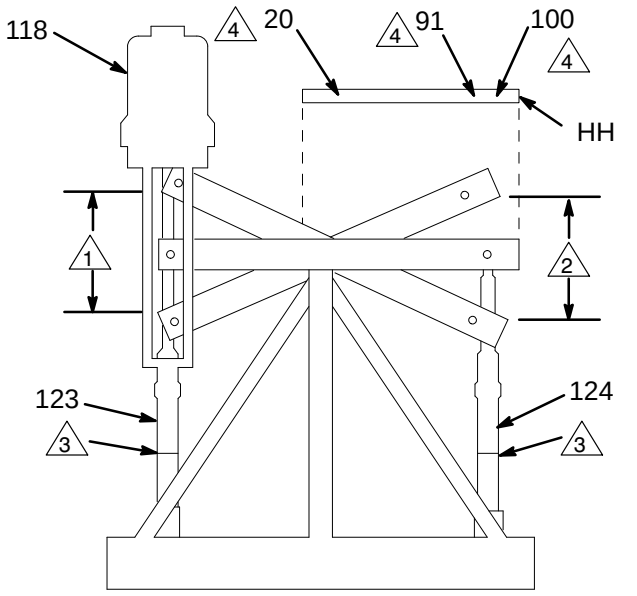
To set the secondary pump on a standard VRHC System with only two pumps, refer to **Setting the Secondary Pump(s)** on page 14.

To set the secondary pump on a non-standard VRHC System or for an additional secondary pump, refer to **Calculate the Ratio Setting**, on page 12.

NOTE: The **91 index setting** provides equal primary and secondary pump stroke lengths. 100 is 1.1 times the primary pump stroke, allowing adjustability on both sides of the nominal ratio setting of 91. If the same primary and secondary pump models are used, a 91 setting will give a 1:1 ratio. If different pump models are used, you must know the pump's effective area to determine the setting. The displacement pumps effective areas are listed in the **Pump Specifications Chart**, following.

Pump Specifications Chart

Pump	Effective Area	Max. Stroke	Secondary Conn. Rod
222–019	0.277 in.^{2}	4.75”	177–113
221–026	0.278 in.^{2}	4.0”	177–116
222–017	0.370 in.^{2}	4.75”	177–113
222–015	0.443 in.^{2}	4.75”	177–113
221–074	0.470 in.^{2}	4.25”	177–115
222–012	0.554 in.^{2}	4.75”	177–113
215–930	0.884 in.^{2}	4.4”	177–115
215–932	1.478 in.^{2}	4.25”	177–114



KEY
HH Lever Arm Index

1 Primary Stroke – 4” (102 mm)
2 Secondary Stroke
3 Effective Area
4 Index Setting

Fig. 5

Relationship Between Primary and Secondary Pump

Moving the secondary pump closer to the primary pump (to a lower index setting) reduces the secondary stroke length, reducing its fluid output. Moving the secondary pump further from the priming pump (to a higher index setting) increases the secondary stroke length, which increases its fluid output.

Calculate the Ratio Setting

In this example,

- A 5:1 ratio of base to catalyst is required.
- A 3:1 ratio of base to reducer is required.
- The base/primary pump Model is 221–074; its effective area is 0.470 in.^{2}
- The catalyst/secondary pump Model is 221–026; its effective area is 0.278 in.^{2}
- The solvent/secondary pump Model is 221–026; its effective area is 0.278 in.^{2}

1. To determine the base to catalyst setting.

   a. Multiply the primary pump's effective area by 91 (nominal ratio setting).

0.47	primary pump's effective area
× **91**	nominal ratio setting
42.77	answer a

   b. Multiply the catalyst pump's effective area by the ratio required.

0.278	catalyst pump's effective area
× **5**	ratio required
1.39	answer b

   c. Divide answer a by answer b to determine the index setting.

42.77	answer a
÷ **1.39**	answer b
30.8	catalyst pump index setting

2. To determine the base to reducer setting:

   a. Multiply the primary pump's effective area by 91 (nominal ratio setting).

0.47	primary pump's effective area
× **91**	nominal ratio setting
42.77	answer a

   b. Multiply the reducer pump's effective area by the ratio required.

0.278	reducer pump's effective area
× **3**	ratio required
0.834	answer c

   c. Divide answer a by answer c to determine the index setting.

42.77	answer a
÷ **0.834**	answer c
51.3	reducer pump index setting

3. To make sure the index setting does not exceed the secondary pump's maximum stroke length:

   a. Multiply the index setting by 0.044 (a constant number).

30.8	catalyst pump setting
× **0.044**	constant
1.355	catalyst pump stroke length

51.2	reducer pump setting
× **0.044**	constant
2.257	reducer pump stroke length

   b. See the **Pump Specifications Chart** on page 11 for the pumps' maximum stroke length. Do not use an index setting which will exceed the maximum stroke length for your pump model.

4. To make sure the index setting does not go below the secondary pump minimum ratio setting, see the **Ratio Setting Charts** on page 13.

5. These numbers (**1.355** and **2.257** from step 3.a.) do not exceed the pump maximum stroke nor do they go below the minimum ratio setting, so set the catalyst pump at the 30.8 index setting and the reducer pump at the 51.3 index setting.

Calculate the Ratio Setting (continued)

Ratio Setting Chart 1

(Models 226–933, 226–934, 226–935, 226–936, 226–937)

Volumetric Ratio	Ratio Setting
0.91 : 1.0	100*
1.00 : 1.0	91
1.25 : 1.0	73
1.50 : 1.0	61
1.75 : 1.0	52
2.00 : 1.0	46
2.25 : 1.0	40
2.50 : 1.0	36
2.75 : 1.0	33
3.00 : 1.0	30
3.25 : 1.0	28
3.50 : 1.0	26
3.75 : 1.0	24
4.00 : 1.0	23
4.25 : 1.0	21
4.50 : 1.0	20

Ratio Setting Chart 2

(Models 226–938)

Volumetric Ratio	Ratio Setting
1.30 : 1.0	93
1.33 : 1.0	91
1.50 : 1.0	81
1.75 : 1.0	69
2.00 : 1.0	61
2.25 : 1.0	54
2.50 : 1.0	49
2.75 : 1.0	44
3.00 : 1.0	40
3.25 : 1.0	37
3.50 : 1.0	35
3.75 : 1.0	32
4.00 : 1.0	30
4.50 : 1.0	27
5.00 : 1.0	24
5.50 : 1.0	22
6.00 : 1.0	20

Ratio Setting Chart 3

(Models 226–939)

Volumetric Ratio	Ratio Setting
1.70 : 1.0	90
1.80 : 1.0	85
2.00 : 1.0	77
2.25 : 1.0	68
2.50 : 1.0	61
2.75 : 1.0	56
3.00 : 1.0	51
3.50 : 1.0	44
4.00 : 1.0	38
4.50 : 1.0	34
5.00 : 1.0	30
5.50 : 1.0	28
6.00 : 1.0	26
6.50 : 1.0	24
7.00 : 1.0	22
7.50 : 1.0	21

*Models 226–935, 226–936, 226–937 only.

Setting the Secondary Pump(s)

The numbers in the Ratio Setting columns of Charts 1, 2 and 3, or the pump settings calculated from the procedures in the section, **Calculate the Ratio Setting**, correspond to the scale numbers on the lever arm (49) of the VRHC. See Fig. 6.

⚠ WARNING

To reduce the risk of serious injury whenever you are instructed to relieve pressure, always follow the **Pressure Relief Procedure** on page 15.

1. Relieve the pressure.
2. Flush the unit as instructed on page 16 before setting the pump.
3. Remove the safety panel (39). See Fig. 8 on page 17.
4. Loosen the four capscrews (16) holding the secondary pump(s) in place.
5. Open the fluid outlet and lift or push the lever arm (49) to the horizontal position.
6. Move the secondary pump so that the line on the index clamp (30) is at the desired setting on the scale (26).
7. With the secondary pump as vertical as possible, tighten the four screws (16) to 50 ft-lb (78 N.m).
8. Replace the safety panel (39).

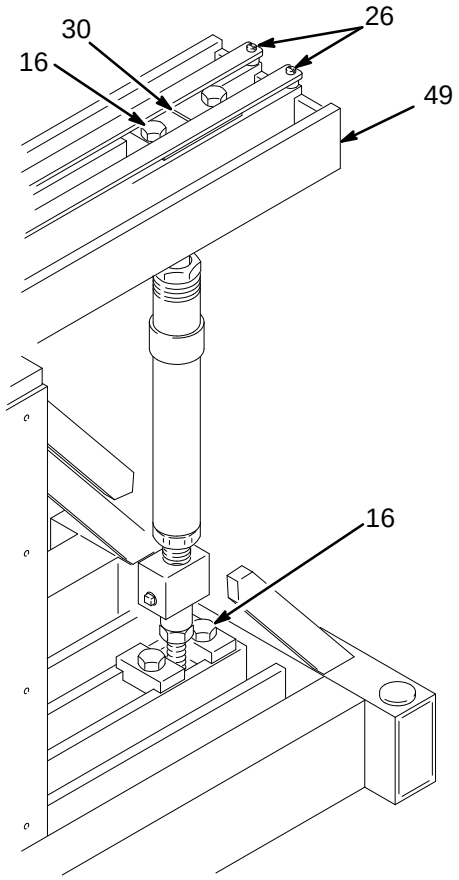


Fig. 6

Operation

Pressure Relief Procedure

⚠ WARNING

INJECTION HAZARD

The system pressure must be manually relieved to prevent the system from starting or spraying/dispensing accidentally. Fluid under high pressure can be injected through the skin and cause serious injury. To reduce the risk of an injury from injection, splashing fluid, or moving parts, follow the **Pressure Relief Procedure** whenever you:

- are instructed to relieve the pressure,
- stop spraying/dispensing,
- check or service any of the system equipment,
- or install or clean the spray tip/nozzle.

1. Lock the gun/valve trigger safety.
2. Close the bleed-type master air valve (required in your system).
3. Unlock the gun/valve trigger safety.
4. Hold a metal part of the gun/valve firmly to the side of a grounded metal pail, and trigger the gun/valve to relieve pressure.
5. Lock the gun/valve trigger safety.
6. Open the drain valve (required in your system), having a container ready to catch the drainage.
7. Leave the drain valve open until you are ready to spray/dispense again.

If you suspect that the spray tip/nozzle or hose is completely clogged, or that pressure has not been fully relieved after following the steps above, ***very slowly*** loosen the tip guard retaining nut or hose end coupling and relieve pressure gradually, then loosen completely. Now clear the tip/nozzle or hose.

Operation

The pumps, mixer manifold and other components were tested with lightweight oil at the factory. Before operating the pump, thoroughly flush the VRHC to prevent contamination of the fluids.

System Flushing

NOTE: Flush the mixer, hose and gun/valve often enough to prevent fluid from reacting or curing in them. Contact your fluid manufacturer for the effective pot life of the fluid you are using.

1. Put the pump intake hoses into a 5 gallon (20 liter) container of compatible solvent. Refer to the fluid manufacturer's recommendations.
2. Start the pump as explained below.
3. Do not install the spray tip/nozzle yet. Hold a metal part of the gun/valve firmly to the side of a grounded metal pail. Using the lowest possible fluid pressure, trigger the gun/valve into the pail.
4. When clean solvent comes from the gun/valve, release the trigger and carefully check all connections in the system for leaks.
5. Take the hoses out of the solvent and trigger the gun/valve until all solvent has been pumped out of the hoses.

Starting the Pump

NOTE: To open the mixer manifold (120), put in the handle in the down position. To close the mixer manifold, put in the handle in the up position. See Fig. 7.

1. Close the bleed-type master air valve. Turn the air regulator knob all the way out (counterclockwise).
2. Turn on the main air supply.
3. Open the mixer manifold handle, trigger the gun/valve, slowly open the bleed-type master air valve, and turn the air regulator knob clockwise until the pump starts.
4. Allow the pump to cycle slowly until all the air is pushed out of the lines. Release the trigger – the pump will stall against the pressure.
5. The manifold handle controls fluid flow. When the manifold is open, base and catalyst are supplied to the gun/valve. To stop the flow, close the handle.

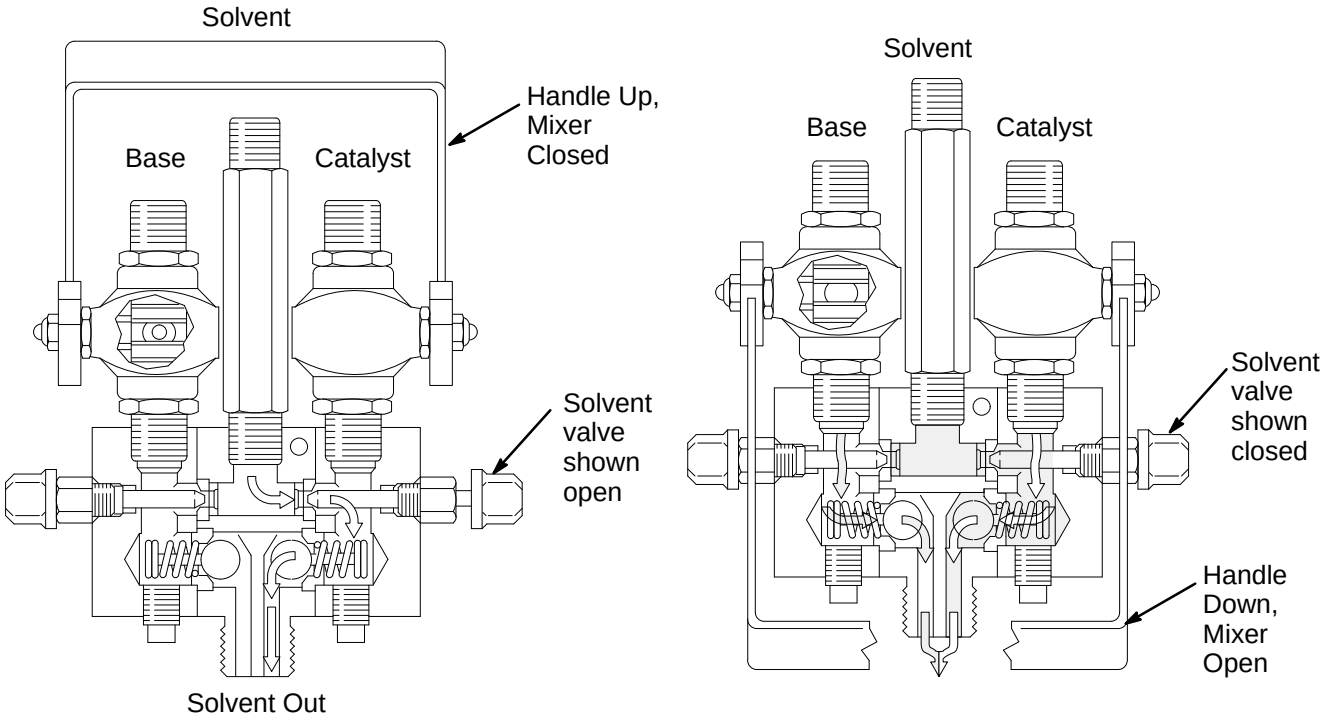


Fig. 7

Operation

NOTE: To open the mixer manifold (120), put the handle in the down position. To close the mixer manifold, put the handle in the up position. See Fig. 7 on page 16.

Standard Operating Flushing

1. Use the solvent valves to flush contaminants and mixed fluids from the mixer manifold, hose and gun/valve. Follow the procedure below.

   a. Start the solvent pump. Close the mixer manifold.

   b. Open one of the solvent valves (EE).

   c. Trigger the gun/valve into the metal pail until the solvent valve is thoroughly flushed. Release the trigger.

   d. Close the open solvent valve. Open the other solvent valve. Repeat step c.

   e. With both solvent valves open, flush until all contaminants and fluids are removed. Release the trigger.

2. To flush the sampling valves (119), place a grounded metal pail under them. Turn the valve handle to the open position. Flush until all contaminants and fluids are removed. Close the sampling valves and solvent valves. The solvent valves should be finger tight only, but must be tight enough to prevent solvent from mixing with the fluid during operation.

3. Trigger the gun/valve to relieve pressure.

Checking the Ratio

1. Open the mixer manifold (120).

2. Set the operating pressure. After determining the operating pressure, release the gun/valve trigger and lock the trigger safety.

3. Close the mixer manifold.

4. Open the sample valve (119) on the secondary pump side approximately three turns. Open the sampling valve on the primary pump side just one turn. This prevents the pressure from building up on the secondary pump, which would cause the relief valve (46) to open.

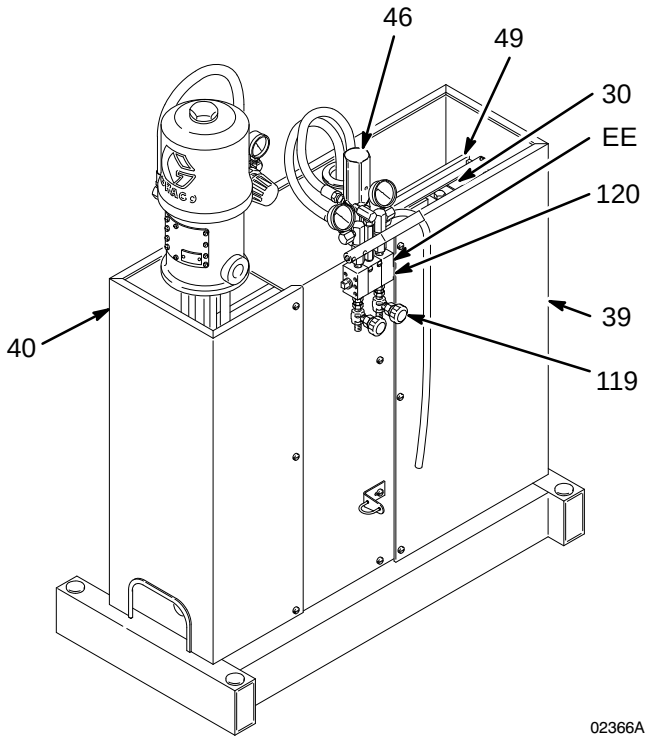


Fig. 8

5. Place a grounded metal pail under the sampling valves.

6. Open the mixer manifold. Use the sampling valves to adjust the pressures to your normal operating pressure.

NOTE: The pressure must be within 20% of your normal operating pressure to get a useable sample.

7. Close the mixer manifold. Put the sampling containers under the sampling valves.

8. Open the mixer manifold. Check the ratio. Make sure the pressure is within 20% of the normal operating pressure. Close the mixer manifold when enough fluid has been dispensed into the sampling containers.

NOTE: If the pressure is not within 20% of the normal operating pressure, follow the flushing procedure on page 16, and then take another sample. If the sample ratio is incorrect, there is a problem with the sample valves, secondary pump setting or the pump operation. Check the pump setting or service the sampling valves or pump.

Troubleshooting

Troubleshooting Techniques

Because the pumps are mechanically linked, the action of one pump can affect the readings of the second pump. Therefore, the key to successful troubleshooting is to be sure to isolate the problem.

For example, the secondary pump pressure, as read on the gauge, is low and sluggish during pump changeover. The most likely problem is a binding primary pump.

⚠ WARNING

To reduce the risk of serious injury whenever you are instructed to relieve pressure, always follow the **Pressure Relief Procedure** on page 15.

To isolate the pump:

1. Relieve the pressure.

2. Disconnect the index clamp (30) from the secondary pump and lean the pump out of the way of the lever arm (49). Now you can verify the operation of the primary pump alone.

3. Use the sampling valves (119) at the mixer manifold (120).

   a. Check the outlet ratio for the primary side.

   b. With the sampling valves closed, check for pump stalling on both the up and down strokes.

   c. Check for rapid gauge response during pump changeover.

4. When the operation of the primary side has been verified, reconnect the lever arm (49) to the secondary pump. Let the primary pump run freely in a pail of fluid and repeat the checks in Step 3 on the secondary side.

⚠ WARNING

Use very low air pressure to the air motor when making these checks. This system can produce very high fluid pressure, which can cause serious injury, including injection, splashing in the eyes or on the skin, and injury from moving parts. Follow the **Pressure Relief Procedure** on page 15.

⚠ WARNING

To reduce the risk of injuring or amputating a hand, fingers or other body parts, never place your hands or any part of your body or any tools inside the safety panel at any time, for any reason, while the unit is operating.

Refer to the manuals listed below to repair the VRHC components.

Component	Description	Manual No.
207–352	Air Motor	306–982
215–626	Manifold Valve	307–400
215–932	Displacement Pump	307–430
215–930	Displacement Pump	307–431
222–012, 222–015, 222–017, 222–019	Displacement Pump	307–944

Troubleshooting

Problem	Cause	Solution
System won't run or stops while running	Air pressure or volume too low	Increase, check air compressor.
	Closed or restricted air line or air valve	Open or clean as required.
	Fluid valves closed	Open fluid valves.
	Clogged fluid hose	Replace fluid hose.
	Air motor worn or damaged	Service air motor; see manual 306–982.
	Displacement pump stuck	Service displacement pump. See manuals listed in the chart on page 18.
Reducer not being delivered to system	Air pressure or volume is too low	Increase; check air compressor.
	Closed or restricted air line or valve	Open or clean as required.
	Manifold clogged	Clean and service as required. See manual 307–400.
	No reducer in reservoir	Refill reducer reservoir.
	Air motor worn or damaged	Service air motor; see manual 306–982.
Fluids not mixing properly	Clogged filter in fluid line	Clean; replace element if necessary.
	Manifold problems	Refer to manual 307–400.
	Check ratio	Check; replace pump.
	Clogged fluid hose	Replace fluid hose.
System speeds up or runs erratically	Fluid containers are empty	Check often – keep filled.
	Displacement pump parts worn or damaged	Service displacement pump. See manuals listed in the chart below.
Squeaking or knocking noise is heard	Bearing(s) dry or worn	Lubricate; replace bearing(s) if necessary.
	Pump bottoming out	See below.
System stops running on the end of a stroke	Secondary displacement pump bottomed out because ratio index clamp was set too far out	Adjust ratio index clamp.
	Secondary displacement pump bottomed out because top pivot bearings are set too high	Adjust bearings. See **Removing the Lever Arm from the VRHC Frame** on page 21.

Service

Required Service Tools

Tool	Use for
3/32”–90° or T-handle hex key	All setscrews
3/4” open end wrench	Clamp bolts and fluid hose on pump outlet
1” open end wrench	Locknuts on capscrews
9/16” open end wrench	Tie rod nuts
1/2” open end wrench	Loosening tie rods from motor base
1–1/8” open end wrench	Pivot bearing locknuts
Adjustable open end wrench	Tightening connecting rod to pumps
Needle nose pliers	Bending and pulling cotter pins
Medium slotted screwdriver	Removing shields
Small hammer and 6” punch	Tapping out pins

Bearing and Pump Lubrication

⚠ WARNING

To reduce the risk of serious injury whenever you are instructed to relieve pressure, always follow the **Pressure Relief Procedure** on page 15.

1. Relieve the pressure.
2. Insert one end of the nylon hose (52) into the wet-cup.
3. Pour Throat Seal Liquid (44) into the hose until the wet-cup is full.
4. Lubricate the VRHC periodically with Graco Gear Reducer Oil (43). If the pump is operating continuously at 60 cycles/min, lubricate at the points shown in Fig. 9 once every five days.

Service instructions are in the manuals for the separate components. See the chart on page 18.

Air Lubrication

If your air supply is very dry, install air line lubricators between the air regulators and pumps for automatic air motor lubrication. See page 29, **Accessories,** for a lubricator.

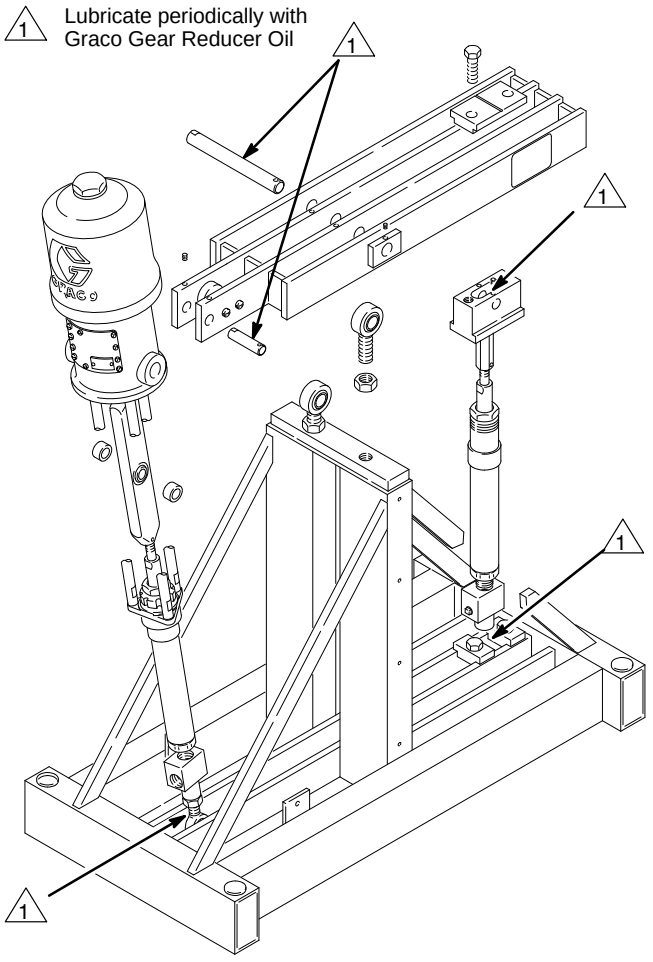


Fig. 9 02371A

Detecting Bearing and Pin Wear

Audio Detection

When a bearing fails, it makes a knocking noise each time the pump changes stroke. Shut off the system immediately to avoid serious damage. Replace the bearing(s).

Visual Detection

Check the movement of the lever arm (49) by watching it through the opening in the safety panel (39). If it bounces, shut off the system immediately to avoid serious damage. Replace the bearing pin.

Service

Removing the Lever Arm from the VRHC Frame

⚠ WARNING

To reduce the risk of serious injury whenever you are instructed to relieve pressure, always follow the **Pressure Relief Procedure** on page 15.

1. Flush the entire system with a solvent which is compatible with the fluid being pumped. Disconnect the air line and relieve the pressure.
2. Remove the safety panels (38,39,40). See Fig. 10.
3. Loosen the two setscrews (59) holding the primary displacement pump pin (35c) in the lever arm (49). See Fig. 11. The setscrews must be backed out far enough to clear the countersinks of the pin. Tap the pump pin out of the lever arm and bearing.
4. Slide the primary pump out of the lever arm (49) slot and save the two nylon spacers (27c).
5. Slowly lower the pump to the floor until it supports itself with the lower bearing (14d). See Fig. 17 on page 27.
6. Push down on the secondary displacement pump end of the lever arm (49) at point (JJ) until it is at the bottom of the stroke. See Fig. 11.
7. Remove the two top capscrews (16a) from the index clamp (30).
8. Raise the lever arm (49) slowly. Lower the secondary pump to the floor until it supports itself with the lower bearing.
9. Loosen the two setscrews (17) located above the ends of the frame pin (33). The setscrews must be turned out far enough to clear the countersinks of the pin.
10. Using a long punch and hammer, gently drive the frame pin (33) out from one end until it can be pulled out.

⚠ CAUTION

Do not drop the pin; dents will make reassembly difficult.

11. Remove the punch and lift the lever arm (49) off the VRHC frame.
12. Loosen the two pivot bearing locknuts (2) and turn the bearings (15) out of the housing (122). The bearings should be only hand tight. If they are tighter, use a wrench on the flats of the bearing (15) to unscrew the bearing from the frame.

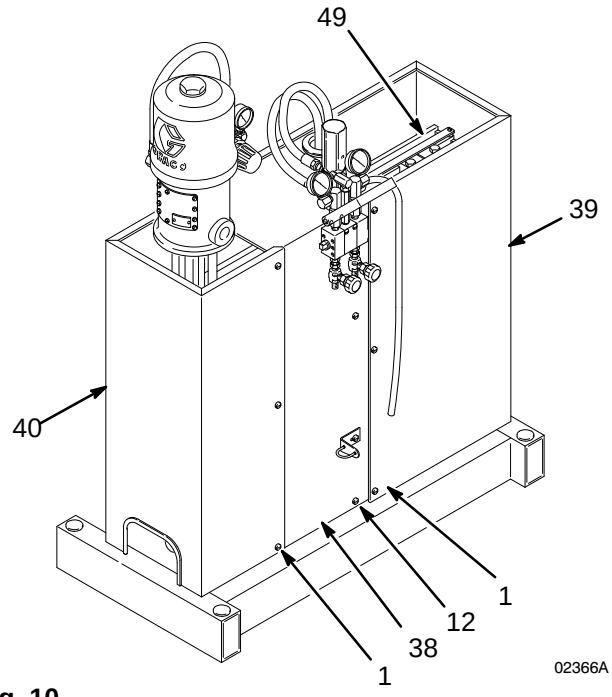


Fig. 10

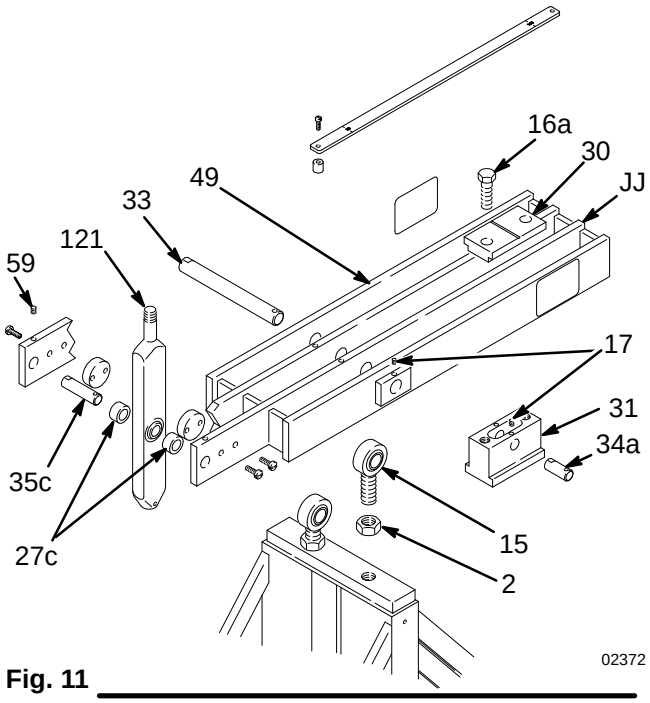


Fig. 11

Service

Determining Which Pin and/or Bearing is Worn

1. Disassemble the VRHC. After the pins and bearings are removed, wipe them off with a clean rag.

2. Visually inspect the pins for scoring, lines, grooves and scratches on the area in contact with the bearing. Then feel the surface of the pin for rough areas or a difference in size. If these signs of wear are detected, replace both the pin and bearing.

3. To check the bearings, hold the threaded part of the bearing in one hand and use the other hand to move the balls inside the bearing up and down. If there is any noticeable movement, replace the bearings. Also check the bearings for roundness. If a bearing appears to be out of round (egg-shaped), replace it.

Fitting the Pins into the Bearings

Tolerances between the surface of the pin and the bearings are very close. Never force the pin into the bearing. If the pin does not fit, sand it from the end to just past the countersinks with 500 grit sandpaper. See Fig. 12. If the pin still does not fit, return it to the factory for replacement. If the pin needs replacement, replace the bearing also.

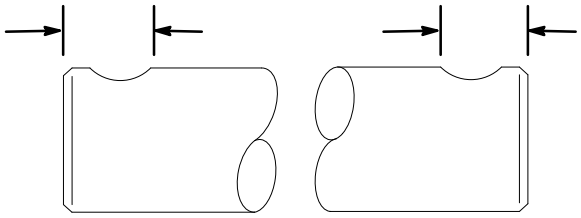


Fig. 12 02373

Storage of Spare Pins and Bearings

Completely coat spare pins and bearings with Graco Gear Reducer Oil (43) or the equivalent when storing these parts. Never use grease.

Removing the Secondary Pump and/or the Bearings and Pins

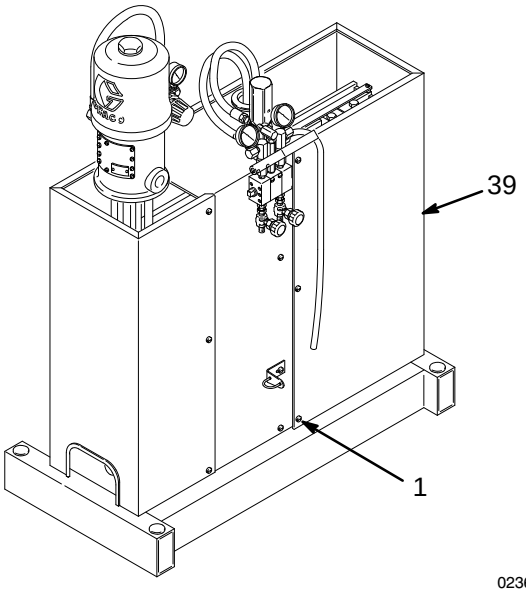
1. Flush the entire system with a compatible solvent.

⚠ WARNING

To reduce the risk of serious injury whenever you are instructed to relieve pressure, always follow the **Pressure Relief Procedure** on page 15.

2. Relieve the pressure.

3. Remove the safety panel (39). See Fig. 13. Disconnect the inlet and outlet fluid hoses of the secondary displacement pump (124).



02366A

Fig. 13

Continued on page 23.

Service

NOTE: Refer to Fig. 14 for steps 4 to 10.

4. Push down on the lever arm (49) until the wrench flats (KK) on the secondary pump (124) are just above the wet-cup (LL). Remove the ratio index clamp capscrews (16a) and the index clamp (30).

NOTE: Some fluid will drip from the pump when you are removing the ratio index clamp.

5. Raise the lever arm (49) off the pivot pin support (31a).

6. Remove the connecting rod cotter pin (102), if the pump has one. Unscrew the connecting rod assembly (117, 14a, 34a, 31a) in one piece from the pump.

7. If you are removing only the pump, remove it from the inlet manifold (32). If the secondary pump(s) need repair, follow the instructions in its manual.

8. If you are removing the bearings and pins, tilt the secondary pump (124) forward until it rests on the floor. Then follow Steps 9 and/or 10.

9. If you are removing the upper bearing (14a) and support pin:

   a. Loosen the two setscrews (17a). Back out the setscrews far enough to clear the countersinks of the support pin (34a).

   b. Place the support (31a) in a vise. Unscrew the connecting rod (117) from the bearing (14a). The connecting rod and bearing are sealed with thread sealant and may be difficult to unscrew.

   c. Remove the support (31a) from the vise. Gently tap the support pin (34a) out with a hammer and punch.

   d. Replace the support pin and bearing.

10. If removing the lower bearing (14b) and support pin (34b):

   a. Remove one of the lower clamps (28) and capscrews (16b).

   b. Loosen the locknut (3) and screw the pump manifold (32) off the bearing (14b) to remove the secondary displacement pump (124).

   c. Remove the remaining clamp (28) and capscrew (16b) from the lower support (31b).

   d. Raise the VRHC lower frame (50) and remove the support (31b).

   e. Gently tap the support pin (34b) out with a hammer and punch.

   f. Replace the pin and bearing.

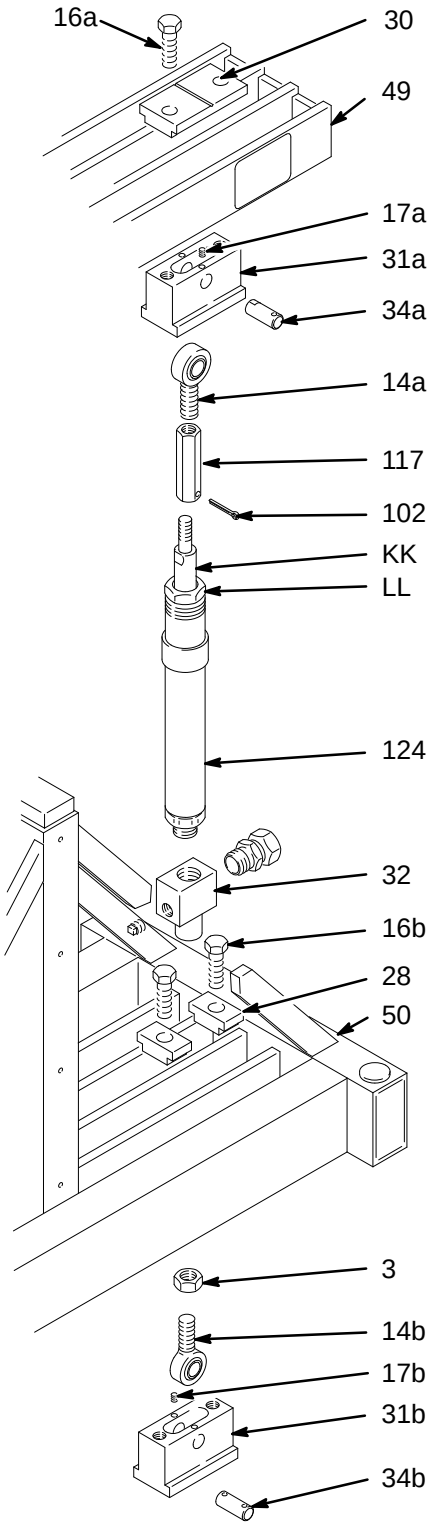


Fig. 14

Service

Replacing the Secondary Pump and/or the Bearings and Pins

NOTE: Refer to Fig. 14 for Steps 1 to 3.

1. If only the secondary pump is being replaced:

    a. Screw the secondary pump (124) into the inlet manifold (32). The manifold must face the end of the VRHC as shown in Fig. 14. If it does not, rotate the secondary displacement pump until it does, and tighten the locknut (3) against the inlet manifold. Torque the locknut to 60 ft-lb (81 N.m).

    b. Replace the connecting rod assembly (117, 14a, 34a, 31a) onto the displacement rod, and line up the cotter pin holes. Insert the cotter pin (102).

    c. Raise the lever arm (49) and place the support (31a) under the proper slot.

    d. Push down the lever arm until the support fits into the slot. If the support does not line up with the slot, rotate it clockwise until it does.

    e. Place the ratio index clamp (30) over the top of the support (31a). Insert the capscrews (16a).

    f. Set the index clamp (30) for the proper ratio and tighten the capscrews (16a).

2. If replacing the lower bearing (14b) and support pin (34b):

    a. Place a generous amount of Graco Gear Reducer Oil (43) on the inside of the lower bearing (14b) and the surface of the support pin (34b).

    b. Screw the locknut (3) onto the bearing (14b) threads until the locknut bottoms out.

    c. Slide the bearing into the slot in the support (31b). Insert the pin (34b) into place with the countersinks under the setscrew (17) holes. Tighten the setscrews to 35 in-lb (4 N.m). These are 10–32 self-locking setscrews. If no drag is felt while turning, replace the setscrew.

    d. Screw the secondary displacement pump (124) and manifold (32) onto the bearing (14b) until it bottoms out. Be sure it is not resting against the locknut (3).

    e. Align and loosely install the two clamps (28) and capscrews (16b).

3. If replacing the upper bearing (14a) and support pin (34a):

    a. Place a generous amount of Graco Gear Reducer Oil (43) on the inside of the upper bearing (14a) and the surface of the support pin (34a).

    b. Slide the support (31a) onto the bearing (14a). Insert the support pin (34a) with the countersinks in place under the setscrew (17a) holes.

> **⚠ CAUTION**
>
> Do not force the pin into place. Check for burrs on the pin or in the VRHC frame if the pin does not slide into place.

    c. Tighten the setscrews (17a) to 35 in-lb (4 N.m). These are 10–32 self-locking screws. If no drag is felt while turning, replace the setscrews.

    d. Place the support (31a) in a vise and screw the connecting rod (117) onto the bearing (14a). The connecting rod and the bearing can be disassembled and then reused one time before needing replacement. Be sure to seal the connecting rod and the bearing with thread sealant such as Loctite® No. 271–05 or the equivalent. Apply 3 drops of the sealant to the threads of the bearing.

    e. Screw the connecting rod (117) onto the pump (124) until the cotter pin holes line up (if the displacement pump has them). Install the cotter pin (102) and tighten the connecting rod against the piston shoulder of the displacement rod.

    f. Follow steps 1.c. to 1.f. at left.

    g. Tighten the capscrews (16b) at the bottom of the secondary displacement pump (124).

Removing the Primary Pump and/or the Lower Bearing and Pin

1. Flush the entire system with a compatible solvent.

⚠ WARNING

To reduce the risk of serious injury whenever you are instructed to relieve pressure, always follow the **Pressure Relief Procedure** on page 15.

2. Relieve the pressure.

3. Remove the safety panels (39,40). Disconnect the inlet and outlet hoses on the primary displacement pump (123).

NOTE: Refer to Fig. 15 for Steps 4 to 6.

4. Remove the three tie rod locknuts (103) and push up on the air motor (118) until the tie rods (116) clear the mounting holes of the displacement pump. See Fig. 15.

5. Using a wrench on the flats of the tie rods, unscrew them from the air motor base.

6. Remove the upper cotter pin (102c) and unscrew the air motor from the connecting rod (121).

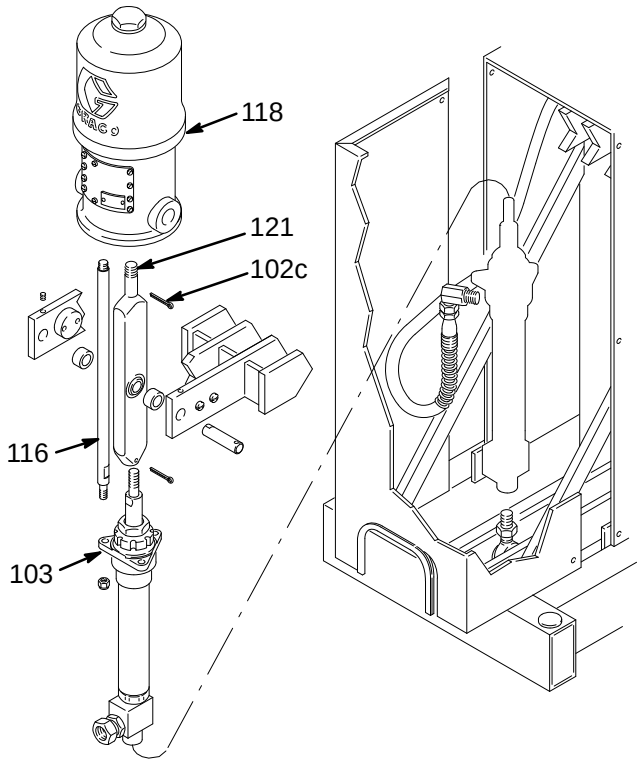


Fig. 15

Continued on page 26.

Service

NOTE: If only the air motor needs repair, follow the instructions in manual 306–982, supplied.

NOTE: Refer to Fig. 16 for Steps 7 to 15.

7. Remove the lower cotter pin (102d) from the connecting rod (121) (if the pump has one) and loosen the two setscrews (59). The setscrews must be backed out far enough to clear the countersink of the bearing support pin (35c).

8. Hold the connecting rod (121) and gently tap out the support pin (35c) with a hammer and punch.

9. Slowly pull the connecting rod (121) away from the lever arm (49) and tilt the pump (123) forward until it rests on the frame. Save the two nylon spacers (27c).

10. Unscrew the connecting rod (121) from the displacement pump (123). If necessary, replace the connecting rod.

11. If removing the pump only, remove it from the manifold (32). If the primary pump needs repair, follow the instructions in the separate pump manual.

12. If removing the lower bearing (14d) and pin (35d), tilt the primary pump (123) forward until it rests on the floor. Then follow steps 13 to 15.

13. Loosen the lower rod end locknut (3) and unscrew the pump manifold (32) to remove the primary pump (123).

14. Loosen the two setscrews (17b). The setscrews must be backed out far enough to clear the countersinks of the support pin (35d).

15. Remove the pin (35d) and save the two nylon spacers (27d) and the bearing (14d).

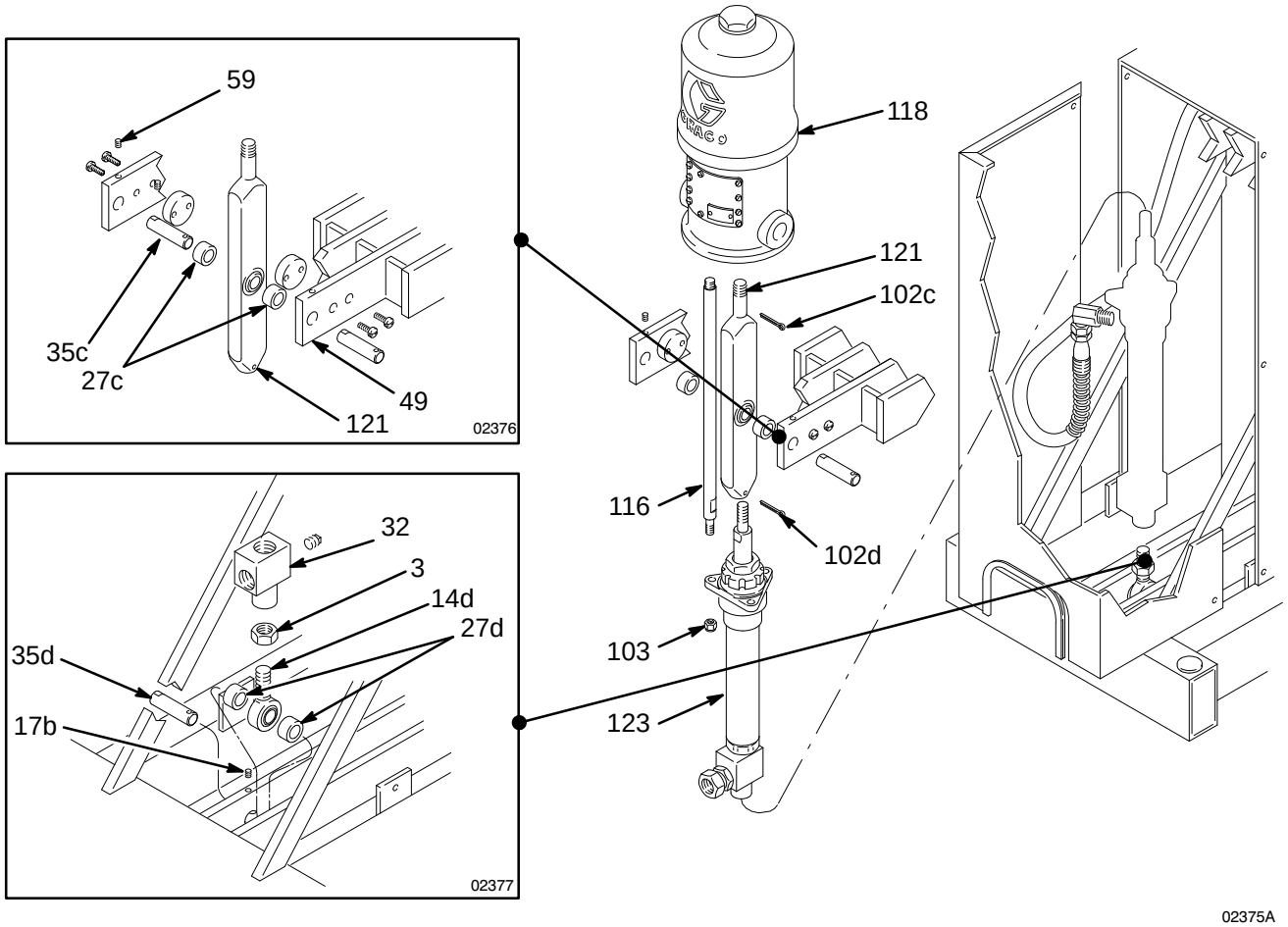


Fig. 16

Replacing the Primary Pump and/or Bearing and Pins

NOTE: Refer to Fig. 17 for Steps 1 to 9 except where noted.

1. Screw the displacement pump (123) into the inlet manifold (32) so the outlet is facing the back, left hand corner.

2. Screw the connecting rod (121) onto the primary displacement pump until the cotter pin holes line up. Install the cotter pin (102d) if the pump has one; if not, bottom out the connecting rod on the displacement pump.

3. Pull the connecting rod upward until the displacement pump stops.

4. Screw the air motor (118) onto the connecting rod until the cotter pin holes line up. Install the cotter pin (102c).

5. Rotate the air motor until the air inlet port is on the same side as the air inlet manifold (37). See the parts drawing on page 31.

6. Screw the three tie rods (116) into the air motor base and torque to 35–50 ft-lb (47–68 N.m).

NOTE: One of the tie rods will run through the lever arm slot.

7. Push down the air motor and place the tie rods into the displacement pump tie plate. Tighten the tie rod locknuts (103).

8. To install the support pin (35c) into the upper bearing:

   a. Remove the two capscrews (16a) from the support (31a) on the secondary pump (124).

   b. Move the lever arm (49) until you can place the nylon spacers (27c) and support pin (35c) in line with the bearing in the connecting rod (121).

   c. Lubricate the support pin with Gear Reducer Oil (43) and tap it into the upper bearing with the countersinks facing up.

⚠ CAUTION

Do not force the pin into place. Check for burrs on the pin or in the VRHC frame if the pin does not slide into place. Sand with 500 grit sandpaper between the countersinks.

   d. Torque the two setscrews (59) to 35 in-lb (4 N.m). See Fig. 18 on page 28.

   e. Move the lever arm (49) back into place and reinstall the two capscrews (16a) onto the support (31a) of the secondary pump.

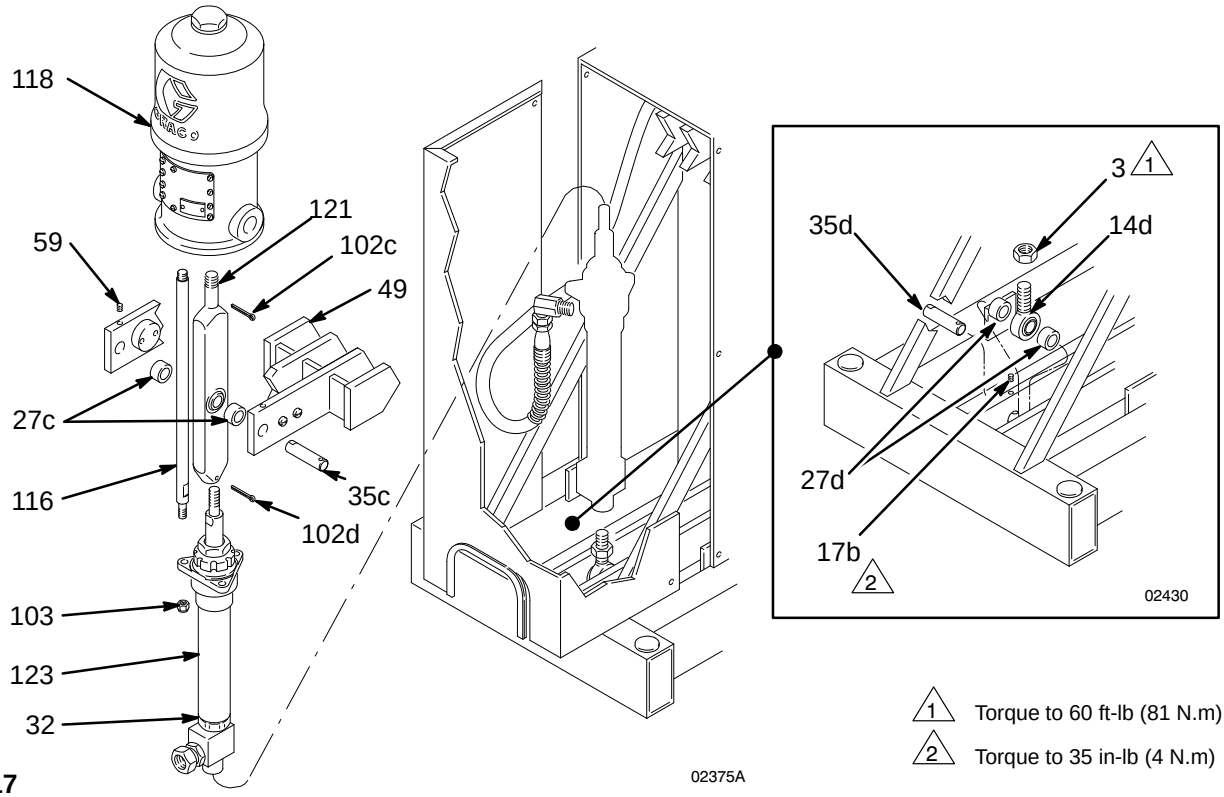


Fig. 17

9. If replacing the lower bearing (14d) and pin (35d):

   a. Thread the locknut (3) all the way onto the bearing.

   b. Screw the inlet manifold (32) onto the bearing twelve turns and tighten the locknut up to the inlet manifold. Torque to 60 ft-lb (81 N.m).

   c. Lubricate the support pin (35d) with Gear Reducer Oil (43). Install the pin with the countersinks facing up, into one side of the frame base (50). Place one nylon spacer (27d) on the end of the support pin.

   d. Install the bearing (14d) and manifold (32) and align them with the support pin (35d).

   e. Tap the pin in flush with the opposite side of the frame. Align the second nylon spacer with the support pin, and tap the pin all the way into the side of the frame base (50).

   f. Tighten the two setscrews (17b) onto the support pin (35d). Torque to 35 in-lb (4 N.m).

   g. Follow the procedure for replacing the primary pump on page 27.

Replacing the Lever Arm on the Frame

⚠ CAUTION

Tolerances between the surface of the frame and bearing are very close. Do not force the pin into place. Check for burrs on the pin or in the VRHC frame if the pin does not slide into place. Sand with 500 grit sandpaper between the countersinks.

NOTE: Refer to Fig. 18 for Steps 1 to 5.

1. Screw the locknuts (2) onto the pivot bearing (15).
2. Screw the pivot bearing into the frame base (50). Adjust the distance from the top of the support pin (33) to the bottom of the frame (50) to 26.125” (664 mm).
3. With the bearings at the correct height and parallel to each other, torque the locknuts (2) to 60 ft-lb (81 N.m).
4. Place a generous amount of lubricant (43) onto the support pin, and place the lever arm (49) over the bearings (15).
5. Slide the support pin, with the countersinks up, through the lever arm and bearings. Torque the two setscrews (17) to 35 in–lb (4 N.m).

NOTE: If no drag is felt while turning the setscrews, replace them.

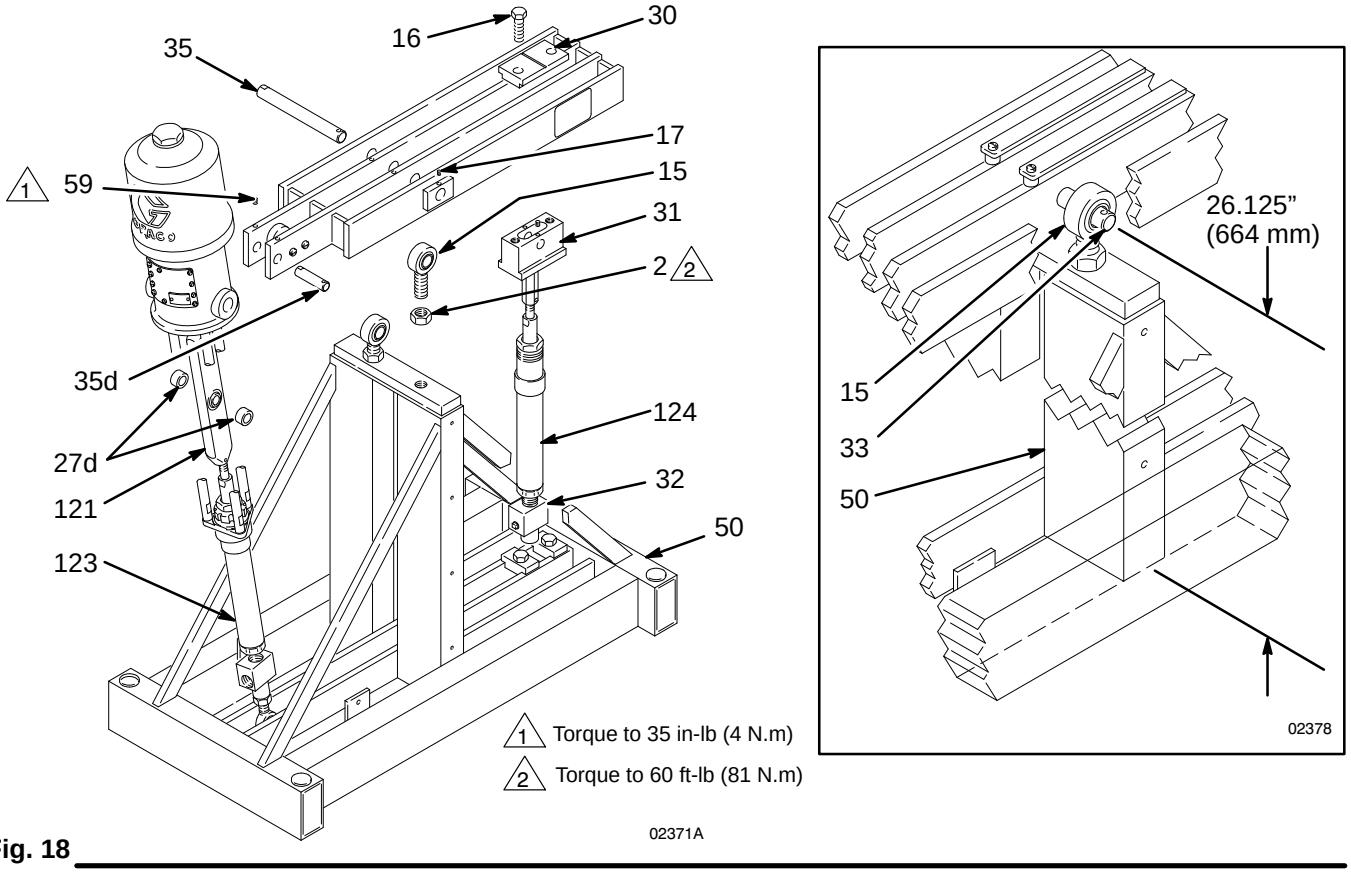


Fig. 18

Accessories

Additional Pump Installation Kit 215–934

Kit designed for the addition of another displacement pump to the Hydra-Cat. See manual 307–432.

Swivel Caster 102–399

Four required to make VRHC portable. Mount in sockets provided in the frame.

Airless Spray Gun 235–460

5000 psi (35 MPa, 350 bar) Maximum Working Pressure

1/4 npsm(m) fluid inlet. See manual 308–236.

Extrusion Flo Valve 204–355

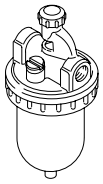
3000 psi (21 MPa, 210 bar) Maximum Working Pressure

3/8 npt(f) fluid inlet. See manual 306–586.

Air Line Lubricator 214–848

250 psi (1.7 MPa, 17.5 bar) Maximum Working Pressure

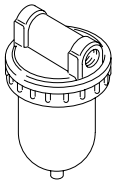
1/2 npt inlet and outlet with metal bowl.



Air Line Filter 106–149

250 psi (1.7 MPa, 17.5 bar) Maximum Working Pressure

1/2 npt(f) inlet and outlet.



Y–Line Strainer 101–078

500 psi (3.4 MPa, 34 bar) Maximum Working Pressure

3/4 npt(f) inlet and outlet. 20 mesh screen included.

Heater

Used to control paint viscosity in a heated spray system.

220–522 120 V, 60 Hz, 1/2 npt inlet, 3/8 npt outlet
237–947 240 V, 60 Hz, 1/2 npt inlet, 3/8 npt outlet

Static Mixers

3000 psi (21 MPa, 210 bar) Maximum Working Pressure

A static mixer consists of a tube with helical interior elements which thoroughly blend base and catalyst into the proper mix. Wetted parts are Stainless Steel.

500–639 14” (356 mm) long, 3/8” (9 mm) OD, 0.32” (8.1 mm) ID, 27 elements

500–586 25” (635 mm) long, 1/2” (12 mm) OD, 0.44” (11.2 mm) ID, 32 elements

Tube Fittings

502–170 For 3/8” (9 mm) OD tube x 3/8 npt(m)

502–172 For 1/2” (12 mm) OD tube x 1/2 npt(m)

Supply Pumps

953–179 5:1 Monark, 55 gallon, drum bung, 1.4 gpm (5 l/min), 3/4 npt(f) outlet

953–350 5:1 Monark, 5 gallon, single post ram 1.4 gpm (5 l/min), 3/4 npt(f) outlet

902–278 5:1 Monark, 5 gallon, pail cover 1.4 gpm (5 l/min), 1/4 npt(f) outlet

226–040 2:1 Standard, 55 gallon, drum bung, 1 gpm (4 l/min), 1/2 npt(f) outlet

902–823 5:1 Monark, 55 gallon, drum bung, 1.4 gpm (5 l/min), 3/4 npt(f) outlet

208–177 2:1 Standard, 55 gallon, drum bung, 2 gpm (8 l/min), 1/2 npt(f) outlet

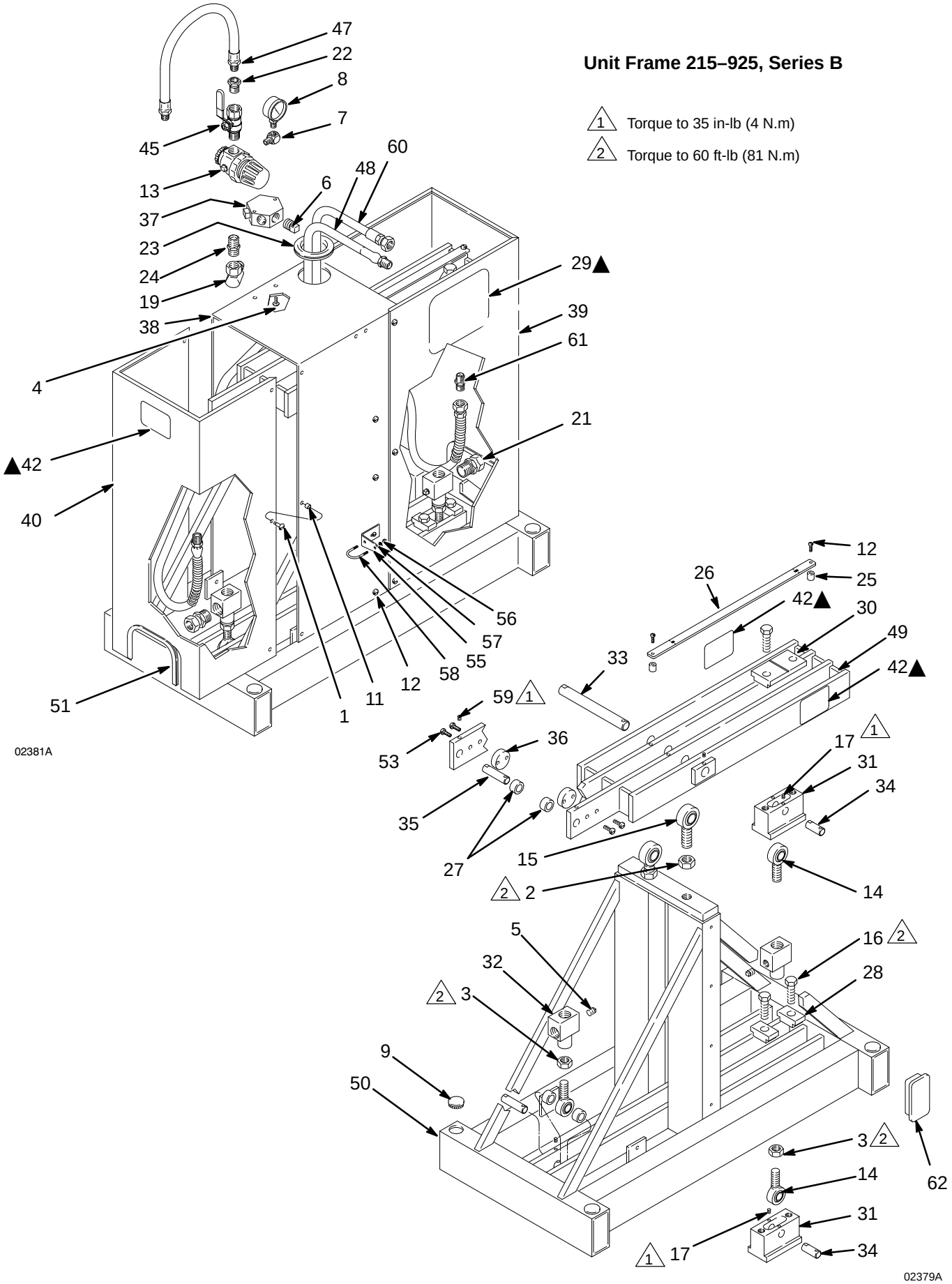
Parts

Unit Frame 215–925, Series B

Ref No.	Part No.	Description	Qty
1	108–036	STUD, fastener	12
2	100–071	LOCKNUT, hex, 3/4–16	2
3	100–155	NUT, 5/8–18	2
4	100–377	SCREW, slotted head, 1/4–20 x 5/8” (16 mm) long	2
5	100–509	PLUG, pipe, 1/4 npt	3
6	100–737	PLUG, pipe	4
7	100–840	ELBOW, street, 1/4 npt (m x f)	1
8	100–960	GAUGE, air pressure, 0–200 psi (0–1.4 MPa, 14 bar)	1
9	101–747	PLUG, bottom, 1/4 npt(m)	4
11	108–037	NUT, sheet spring, 10–24	12
12	103–836	SCREW, slotted hd, 10–32 x 3/4” (19 mm) long	12
13	104–267	REGULATOR, air, see 308–167 for parts	1
14	105–751	BEARING, rod end	3
15	105–752	BEARING, rod end	2
16	100–060	CAPSCREW, hex hd, 1/2–13 x 1–3/4” (44 mm) long	4
17	105–762	SETSCREW, hex, 10–32	8
19	155–470	SWIVEL, 90°; 3/8 npt(m) x 1/2 npsm(f)	1
21	157–785	UNION, swivel, straight, 3/4 npt(m) x 3/4 npsm(f) swivel	2
22	100–081	BUSHING; 3/8 npt(f) x 1/2 npt(m)	1
23	158–244	GROMMET	1
24	158–491	NIPPLE; 1/2 npt	3
25	159–463	SPACER	4
26	177–042	GAUGE, designation	2
27	177–086	SPACER, 1/4, nylon	4
28	177–089	CLAMP, lower	2
29▲	177–096	LABEL, warning	1
30	177–099	CLAMP, top, index	1
31	177–100	SUPPORT, pivot pin	2
32	177–101	MANIFOLD, inlet	2
33	177–105	PIN, pivot, frame	1
34	177–106	PIN, pivot, housing	2
35	177–107	PIN, pivot, pump	2
36	177–108	PLATE, wear	2
37	177–117	MANIFOLD, air	1
38	177–118	PANEL, safety	1
39	177–119	PANEL, safety	1
40	177–120	PANEL, safety	1
41	177–132	LABEL (not shown)	1
42▲	177–144	LABEL, warning	4
43	217–374	LUBRICANT, gear reducer (not shown)	16 oz
44	206–994	THROAT SEAL LIQUID (not shown)	8 oz
45	113–269	VALVE, air, bleed–type	1
47	214–652	HOSE, buna–S, 1/2” (13 mm) ID, coupled 3/8 npt (mbe), 1.5’ (0.45 m) long	1
48	215–247	HOSE, nylon, 1/4” (6 mm) ID, coupled 3/8 npt (mbe), 5’ (1.8 m) long	1
49	215–664	ARM, lever	1
50	215–665	FRAME BASE, VRHC	1
51	062–035	MOLDING, rubber	1.8 ft
53	102–790	SCREW, 10–24	4
55	180–673	BRACKET	1
56	100–179	NUT, 10–24	2
57	100–718	WASHER, no. 10	2
58	180–674	U–BOLT, 10–24	1
59	108–038	SETSCREW, 10–32	2
60	223–778	HOSE, Teflon®, 1/4” (6 mm) ID, coupled 1/4 npsm (fbe), 5’ (1.8 m) long	1
61	164–672	ADAPTER, 3/8 npt x 1/4 npsm (mbe)	1
62	189–559	CAP, end	4

▲ *Replacement Danger and Warning labels, tags and cards are available at no cost.*

Parts


Unit Frame 215–925, Series B
1 Torque to 35 in-lb (4 N.m)
2 Torque to 60 ft-lb (81 N.m)
47
22
8
7
45
60
48
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38
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31
1 17
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02379A

Parts

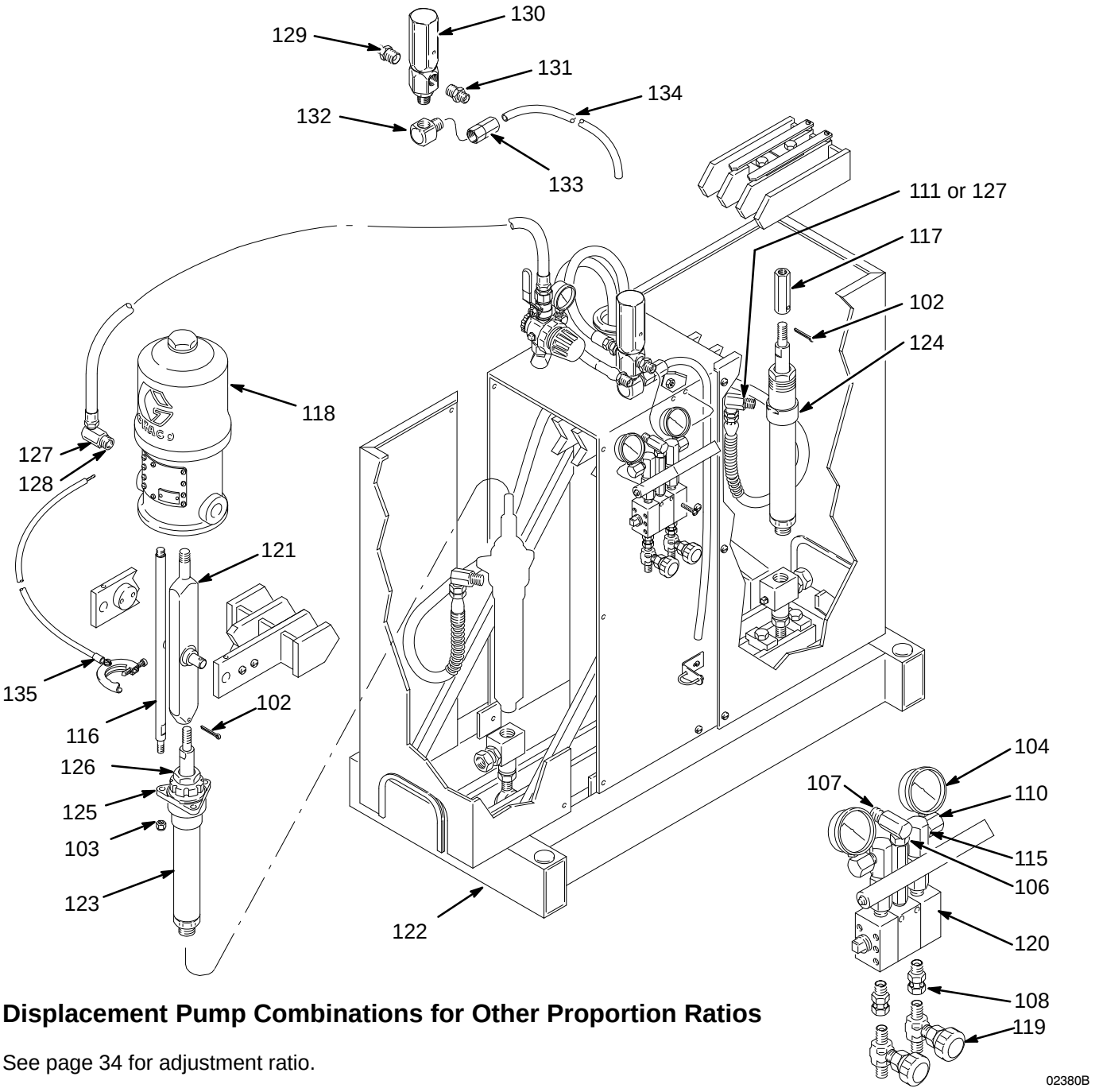
Models 226–933, 226–934, 226–935, 226–936, 226–937, 226–938, 226–939, 686–632

Ref No.	Part No.	Description	Qty	Used in Models
102	100–103	PIN, cotter	3	226–933 226–934
			1	All Others
103	101–566	LOCKNUT, sst, 3/8–16	3	All
104	102–814	GAUGE, pressure, 5000 psi (34 MPa, 350 bar), 1/4 npt(m)	2	All
106	100–139	PLUG, pipe, 1/8 npt	2	All
107	155–541	UNION, swivel, 90°, 1/4 npt(m) x 1/4 npsm(f)	1	All
108	156–823	UNION, 1/4 pt(m) x 1/4 npt(f)	2	All
110	158–962	ELBOW, street, 1/4 npt(f) x 1/8 npt(m)	2	All
111	161–037	UNION, swivel, 1/2 npt(f) x 3/8 npsm(f)	2	226–933 226–934
115	177–088	UNION, swivel, 3/8 npt(f) x 3/8 npsm(f)	2	All
116	177–111	TIE ROD, 16” (407 mm) shoulder to shoulder	3	226–935 226–936 226–937 226–938 226–939 686–632
	177–112	TIE ROD, 15.2” (385 mm) shoulder to shoulder	3	226–933
	177–471	TIE ROD, 16.9” (429 mm) shoulder to shoulder	3	226–934
117	177–113	CONNECTING ROD, 2.62”(66.5 mm) long	1	226–935 226–936 226–937 226–938 226–939 686–632
	177–114	CONNECTING ROD, 2.5” (64.4 mm) long	1	226–933
	177–115	CONNECTING ROD, 3.39” (88.1 mm) long	1	226–934
118	207–352	MOTOR, President[5]	1	All
119	108–233	SAMPLING VALVE, needle	2	All
120	215–626	MANIFOLD[4]	1	All
121	215–691	CONNECTING ROD, 13.5”(342 mm)	1	226–934
	215–692	CONNECTING ROD, 11.8” (300 mm)	1	226–935 226–936 226–937 226–938 226–939 686–632
	215–693	CONNECTING ROD, 12.7” (321 mm)	1	226–933
122	215–925	HOUSING, VRHC	1	All
123	215–932	PRIM. DISPL. PUMP[1]	1	226–933
	215–930	PRIM. DISPL. PUMP[2]	1	226–934
	222–012	PRIM. DISPL. PUMP[3]	1	226–935
	222–015	PRIM. DISPL. PUMP[3]	1	226–936
	222–017	PRIM. DISPL. PUMP[3]	1	226–937
	222–017	PRIM. DISPL. PUMP[3]	1	226–938
	222–015	PRIM. DISPL. PUMP[3]	1	226–939
124	215–932	SEC. DISPL. PUMP[1]	1	226–933
	215–930	SEC. DISPL. PUMP[2]	1	226–934
	222–012	SEC. DISPL. PUMP[3]	1	226–935
	222–015	SEC. DISPL. PUMP[3]	1	226–936
	222–017	SEC. DISPL. PUMP[3]	1	226–937
	222–019	SEC. DISPL. PUMP[3]	1	226–938
	222–019	SEC. DISPL. PUMP[3]	1	226–939
125	215–690	MOUNTING PLATE	1	226–935 226–936 226–937 226–938 226–939 686–632
126	164–417	LOCKNUT	1	226–935 226–936 226–937 226–938 226–939 686–632
127	155–494	UNION, 3/8 npt(mxf)	1	226–933 226–934
			3	All others
128	158–212	BUSHING, 1/2 npt(m) x 3/8 npt(f)	1	All
129	162–449	NIPPLE, 1/2 x 1/4 npt	1	All
130	237–063	VALVE, relief, 2900 to 3600 psi (20 to 24.8 MPa, 200 to 248 bar)	1	All
131	159–239	NIPPLE, 3/8 x 1/2 npt	1	All
132	158–683	ELBOW, 90°, steel	1	All
133	113–187	CONNECTOR, female, tube	1	All
134	190–738	TUBE, nylon	1	All
135	237–569	WIRE, ground	1	All

[1]See manual 307–430 for parts.
[2]See manual 307–431 for parts.
[3]See manual 307–944 for parts.
[4]See manual 307–400 for parts.
[5]See manual 306–982 for parts

Parts

Models 226–933, 226–934, 226–935, 226–936, 226–937, 226–938, 226–939, 686–632



Displacement Pump Combinations for Other Proportion Ratios

See page 34 for adjustment ratio.

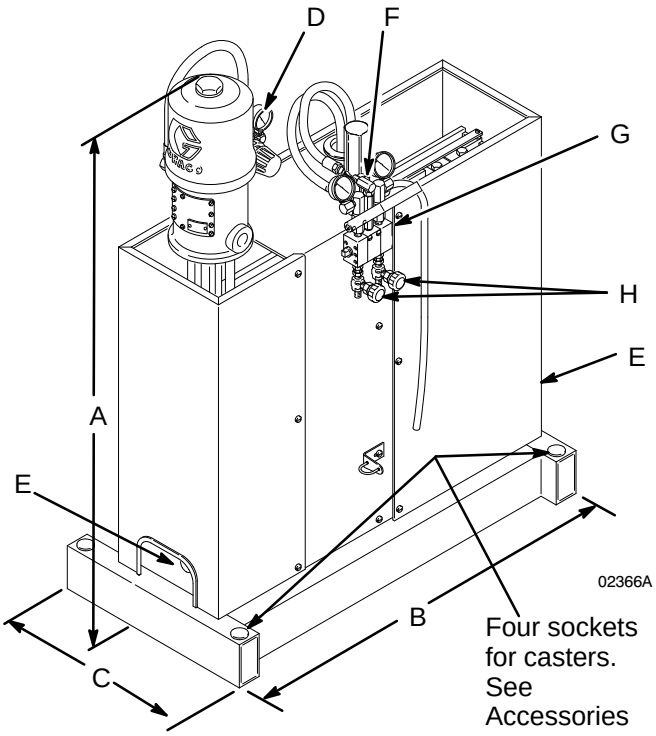
Pump Combinations		Proportion Ratio†	Volume Output† gpm (l/min)‡	At 100 psi (0.7 MPa, 7 bar) psi (MPa, bar)†
Primary	Secondary			
222–012	222–015	1.2:1 to 5.6:1	1.10 to 0.70 (4.2 to 2.6)	1300 to 2200 (9 to 15, 90 to 152)
222–012	222–017	1.4:1 to 6.7:1	1.10 to 0.70 (4.2 to 2.6)	1400 to 2200 (9.7 to 15, 97 to 152)
222–012	222–019	1.9:1 to 9.0:1	1.10 to 0.70 (4.2 to 2.6)	1600 to 2300 (11 to 16, 110 to 159)

†Maximum to minimum ranges.

NOTE: Output pressure decreases as volume output inreases.

‡Based on pump speed of 40 cycles per minute using No. 10 oil test media.

Dimensions



A Height . . . . . 48.5” (1232 mm)
B Length . . . . . 35” (889 mm)
C Width . . . . . 18” (457 mm)
D Air Inlet . . . . . 1/2 npt(f) has four 1/4 npt(f) plugged outlets
E Fluid Inlets . . . . . Two 3/4 npsm(f) swivel, has 1/4 npt(f) plugged cleanout port
F Solvent Inlets . . . . . 1/2 npt(m)
G Fluid Outlet . . . . . 1/2 npt(m)
H Valve Outlets . . . . . Two 1/4 npt(m)
Net Weight . . . . . 273 lb (124 kg)

Adjustment Ratios

Primary Displ. Pump – 222–012
Secondary Displ. Pump – 222–015

Proportion by Volume Primary to Secondary	Adjustment
1.2:1	94
1.6:1	71
2.0:1	56
2.4:1	47
2.8:1	40
3.2:1	35
3.6:1	31
4.0:1	28
4.4:1	26
4.8:1	24
5.2:1	22
5.6:1	20

Primary Displ. Pump – 222–012
Secondary Displ. Pump – 222–017

Proportion by Volume Primary to Secondary	Adjustment
1.4:1	97
1.5:1	91
2.0:1	68
2.5:1	54
3.0:1	45
3.5:1	39
4.0:1	34
4.5:1	30
5.0:1	27
5.5:1	25
5.6:1	24

Primary Displ. Pump – 222–012
Secondary Displ. Pump – 222–019

Proportion by Volume Primary to Secondary	Adjustment
1.9:1	95
2.0:1	91
2.5:1	72
3.0:1	61
3.5:1	52
4.0:1	45
4.5:1	40
5.0:1	36
5.5:1	33
6.0:1	30
6.5:1	28
7.0:1	26
7.5:1	24
8.0:1	23
8.5:1	21
9.0:1	20

Technical Data

Air motor effective diameter . . . . . 4.25 in. (108 mm)
Air motor stroke . . . . . 4 in. (102 mm)
Operating air pressure range . . . . . 40 to 120 psi (0.3 to 0.8 MPa,3 to 8 bar)
Recommended pump speed . . . . . 40 cycles per minute
Max. fluid inlet pressure* . . . . . 250 psi (1.7 MPa, 17 bar)
Max. pump operating temperature . . . . . 180°F (82° C)

Noise level at 100 psi (0.7 MPa, 7bar) inlet air at 40 cpm normal load
Pressure level . . . . . 88.6 dB(A)
Pressure level . . . . . 103.5 dB(A)

Noise level at 120 psi (0.8 MPa, 8.2bar) inlet air at 60 cpm maximum load
Pressure level . . . . . 91.2 dB(A)
Pressure level . . . . . 106.1 dB(A)

*25% pump outlet pressure maximum

Air Consumption

At 40 psi (0.28 MPa, 2.8 bar) cfm (m^3/min)	At 70 psi (0.49 MPa, 4.9 bar) cfm (m^3/min)	At 100 psi (0.7 MPa, 7 bar) cfm (m^3/min)	At Cycles per Minute
3 (0.08)	5 (0.14)	7 (0.19)	10
6 (0.16)	10 (0.28)	13 (0.37)	20
9 (0.25)	14 (0.40)	19 (0.53)	30
12 (0.34)	19 (0.53)	25 (0.71)	40
15 (0.42)	23 (0.65)	31 (0.88)	50
18 (0.51)	28 (0.80)	37 (1.05)	60
21 (0.59)	32 (0.91)	43 (1.22)	70

Wetted Parts

All Models	
Fluid Manifolds	Zinc-Plated Steel
Fluid Hoses	Nylon, Zinc-Plated Steel Couplings
Pressure Relief Valve	304 Stainless Steel, Graphite-Filled Teflon®, Tungsten Carbide (Nickel Binder)
Mixer Manifold	Chrome Alloy, Nickel Chrome Plated and Zinc Plated Steels, Stainless Steel, Delrin®, Nylon and Teflon® Plastics
Primary and Secondary Displacement Pumps	
226–933	Chrome-Plated and Electro-Polished Stainless Steel, Stainless Steel, Polyethylene, and Teflon® Plastics
226–934	Nitralloy Steel, Stainless Steel, Tungsten Carbide, Zinc-Plated Steel, Teflon® Plastics
226–935, 226–936, 226–937, 226–938, 226–939	Stainless Steel, Tungsten Carbide, Chrome Plating, Carbon Steel, Teflon®

Graco Standard Warranty

Graco warrants all equipment referenced in this document which is manufactured by Graco and bearing its name to be free from defects in material and workmanship on the date of sale by an authorized Graco distributor to the original purchaser for use. With the exception of any special, extended, or limited warranty published by Graco, Graco will, for a period of twelve months from the date of sale, repair or replace any part of the equipment determined by Graco to be defective. This warranty applies only when the equipment is installed, operated and maintained in accordance with Graco's written recommendations.

This warranty does not cover, and Graco shall not be liable for general wear and tear, or any malfunction, damage or wear caused by faulty installation, misapplication, abrasion, corrosion, inadequate or improper maintenance, negligence, accident, tampering, or substitution of non–Graco component parts. Nor shall Graco be liable for malfunction, damage or wear caused by the incompatibility of Graco equipment with structures, accessories, equipment or materials not supplied by Graco, or the improper design, manufacture, installation, operation or maintenance of structures, accessories, equipment or materials not supplied by Graco.

This warranty is conditioned upon the prepaid return of the equipment claimed to be defective to an authorized Graco distributor for verification of the claimed defect. If the claimed defect is verified, Graco will repair or replace free of charge any defective parts. The equipment will be returned to the original purchaser transportation prepaid. If inspection of the equipment does not disclose any defect in material or workmanship, repairs will be made at a reasonable charge, which charges may include the costs of parts, labor, and transportation.

THIS WARRANTY IS EXCLUSIVE, AND IS IN LIEU OF ANY OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO WARRANTY OF MERCHANTABILITY OR WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE.

Graco's sole obligation and buyer's sole remedy for any breach of warranty shall be as set forth above. The buyer agrees that no other remedy (including, but not limited to, incidental or consequential damages for lost profits, lost sales, injury to person or property, or any other incidental or consequential loss) shall be available. Any action for breach of warranty must be brought within two (2) years of the date of sale.

GRACO MAKES NO WARRANTY, AND DISCLAIMS ALL IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, IN CONNECTION WITH ACCESSORIES, EQUIPMENT, MATERIALS OR COMPONENTS SOLD BUT NOT MANUFACTURED BY GRACO. These items sold, but not manufactured by Graco (such as electric motors, switches, hose, etc.), are subject to the warranty, if any, of their manufacturer. Graco will provide purchaser with reasonable assistance in making any claim for breach of these warranties.

In no event will Graco be liable for indirect, incidental, special or consequential damages resulting from Graco supplying equipment hereunder, or the furnishing, performance, or use of any products or other goods sold hereto, whether due to a breach of contract, breach of warranty, the negligence of Graco, or otherwise.

FOR GRACO CANADA CUSTOMERS

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Graco Phone Number

FOR TECHNICAL ASSISTANCE, service repair information or assistance regarding the application of Graco equipment: **1–800–543–0339 Toll Free**

Manual Change Summary

The manual has been revised to add Model 686–632.

All written and visual data contained in this document reflects the latest product information available at the time of publication.
Graco reserves the right to make changes at any time without notice.

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