

# Instructions – Parts List



5 AND 30 GALLON, 65:1 KING

## Module Supply Units™

309230 Rev.C

*4875 psi (336 bar) Maximum Working Pressure*

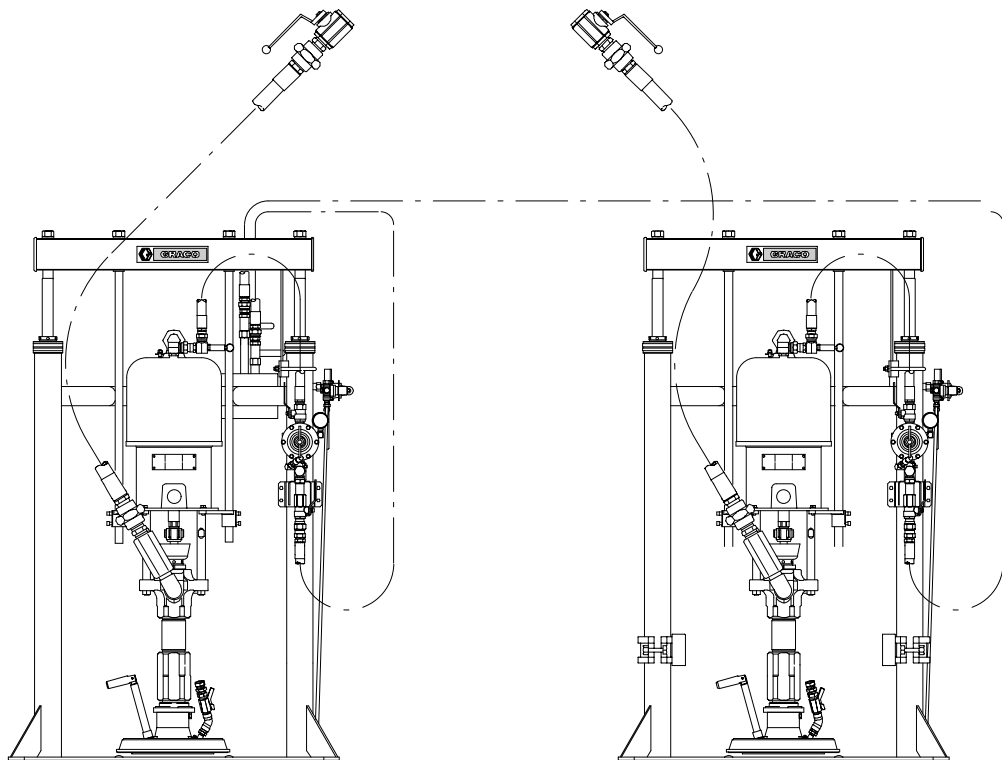
- \* **Model 970025, Tandem with Pneumatic Crossover**
- Model 970026, Tandem with Electric Crossover**
- \* **Model 970027, Pneumatic Low Level Shutoff**
- Model 234117, Pneumatic Low Level Shutoff**

Refer to page 2 for List of Models and Related Manuals.

\* These models are CE certified.



**Read warnings and instructions.**  
See page 2 for **Table of Contents**.



**Model 970025 Tandem Shown**

T10462

# Table of Contents

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## List of Models

Part No.	Pump Model	Displacement Pump Model	Ratio	Maximum Fluid Working Pressure	Maximum Pump Air Input Pressure	Parts Page
* 970025	King™	Check-Mate™ 800	65:1	336 bar, 33.6 MPa (4875 psi)	5.2 bar, 0.52 MPa (75 psi)	16
970026	King™	Check-Mate™ 800	65:1	336 bar, 33.6 MPa (4875 psi)	5.2 bar, 0.52 MPa (75 psi)	17
* 970027	King™	Check-Mate™ 800	65:1	336 bar, 33.6 MPa (4875 psi)	5.2 bar, 0.52 MPa (75 psi)	18
234117	King™	Check-Mate™ 800	65:1	336 bar, 33.6 MPa (4875 psi)	5.2 bar, 0.52 MPa (75 psi)	19



\* These models are CE certified.

## Related Manuals

Manual	No.
Ram-Mounted Pumps (Model C59522)	308027
Pneumatic Crossover (Model 918468)	310293
Low-Level Shutoff (Model 918478)	310294
Electrical Crossover (Model C59519)	310295

# Warnings

## Warning Symbol



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

## Caution Symbol



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, malfunction, or start unexpectedly and result in serious injury.

- This equipment is for professional use only.
- Read all instruction manuals, warnings, 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 the equipment daily. Repair or replace worn or damaged parts immediately.
- Do not exceed 75 psi (5.1 bar) maximum inbound air pressure to the air-powered ram.
- Never exceed the recommended working pressure or the maximum air inlet pressure stated on your pump or in the **Technical Data** on page 22.
- Be sure that all spray/dispensing equipment and accessories are rated to withstand the maximum working pressure of the pump. Do not exceed the maximum working pressure of any component or accessory used in the system.
- Route the hoses away from the 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).
- Do not use the hoses to pull the equipment.
- Use fluids and solvents that are chemically compatible with the equipment wetted parts. Refer to the **Technical Data** sections of all the equipment manuals. Always read the material manufacturer's literature before using fluid or solvent in this pump.
- Always wear protective eyewear, gloves, clothing, and respirator as recommended by the fluid and solvent manufacturers.
- Wear hearing protection when operating this equipment.
- Comply with all applicable local, state and national fire, electrical and other safety regulations.

# ⚠ WARNING



## INJECTION HAZARD

Spray from the spray gun, hose leaks, or ruptured components can inject fluid into your body and cause extremely serious injury, including the need for amputation. Splashing fluid 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/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 fluid leaks with your hand, body, glove, or rag.
- Always have the trigger guard on the gun when dispensing.
- Check the gun diffuser operation weekly. Refer to the gun manual.
- Be sure the gun/valve trigger safety operates before dispensing.
- Lock the gun/valve trigger safety when you stop dispensing.
- Follow the **Pressure Relief Procedure** on page 12 if the nozzle clogs, and before cleaning, checking or servicing the equipment.
- Tighten all fluid connections before operating the equipment.
- Check the hoses, tubes, and couplings daily. Replace worn, damaged, or loose parts immediately. Do not repair high pressure couplings; you must replace the entire hose.
- Fluid hoses must have spring guards on both ends, to help protect them from rupture caused by kinks or bends near the couplings.



## FIRE, EXPLOSION AND ELECTRIC SHOCK HAZARD

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

- Ground the equipment, the object being dispensed, and all other electrically conductive objects in the dispense area. Proper grounding dissipates static electricity generated in the equipment. Refer to **System Grounding** on page 8.
- Provide fresh air ventilation to avoid the buildup of flammable fumes from solvent or material.
- Extinguish all open flames or pilot lights in the dispense area.
- Do not turn on or off any light switch in the dispense area.
- Do not use this equipment with flammable liquids.
- Do not stop or deflect fluid leaks with your hand, body, glove, or rag.
- Keep the dispense area free of debris, including solvent, rags, and gasoline.
- Do not smoke in the dispense area.
- If there is any static sparking or you feel an electric shock while using the equipment, **stop dispensing immediately**. Do not use the equipment until you have identified and corrected the problem.

# WARNING



## MOVING PARTS HAZARD

Moving parts, such as the ram follower plate/pump inlet can pinch fingers.

- Do not operate the equipment with the guard removed.
- Keep clear of all moving parts when starting or operating the equipment.
- Keep hands and fingers away from the priming piston during operation and whenever the pump is charged with air.
- Keep clear of the follower plate, pump fluid inlet, and lip of the fluid container when raising or lowering the ram.
- Before checking or servicing the ram or pump, follow the **Pressure Relief Procedure** on page 12.



## TOXIC FLUID HAZARD

Hazardous fluid or toxic fumes can cause serious injury or death if splashed in the eyes or on the skin, inhaled, or swallowed.

- 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.
- Avoid exposure to heated material fumes.
- Provide adequate ventilation.

# System Information

## System Description

System 970025 includes a dual 5 gallon supply unit with pneumatic crossover for continuous material supply. System 970026 includes a dual 5 gallon supply unit with electric crossover for continuous material supply. System 234117 is a single 30 gallon supply unit with a low-level shutoff. System 970027 is a single 5 gallon supply unit with a low-level shutoff. See Fig. 1.

Each system air-powered ram pushes a follower plate (C) into a drum of material, while the pump (A) removes material from the drum and pushes it through a supply hose to a customer-supplied header. Material flows through the header to individual dispense drops.

### WARNING

A main air bleed valve (E) and pump air bleed valve (H), are required. These accessories help reduce the risk of serious injury, including fluid injection and splashing of fluid in the eyes or on the skin, and injury from moving parts if you are adjusting or repairing the pump.

The main air bleed valve (E) shuts off and relieves the air to the pump and ram. The ram will hold pressure if the ram director valve (U) is in the horizontal (neutral) position. To relieve air pressure in the ram, close the main air bleed valve (E) and move the director valve (U) to DOWN. The ram will slowly drop.

The pump air bleed valve (H) relieves air trapped between it and the pump after the air is shut off. Trapped air can cause the pump to cycle unexpectedly. Locate the valve close to the pump.

The fluid drain valve assists in relieving fluid pressure in the displacement pump, hose, and gun. Triggering the gun to relieve pressure may not be sufficient.

## System Accessories and Modules

Before you install the system, you should be familiar with the parts discussed in the following paragraphs.

**NOTE:** Reference numbers and letters in parentheses in the text refer to the callouts in the figures and the parts drawing.

- **Main air bleed valve (E)** is required in your system to shut off the air supply to the pump and ram (Refer to the preceding **WARNING** ). When closed, the valve bleeds off all air in the ram and pump, and the ram slowly lowers. Be sure the valve is easily accessible from the pump, and is located **upstream** from the air manifold (F).
- **Pump air bleed valve (H)** is required in your system to relieve air trapped between it and the air motor when the valve is closed (Refer to the preceding **WARNING** ). Be sure the valve is easily accessible from the pump, and is located **downstream** from the air regulator (G).
- **Air regulator (G)** controls pump speed and outlet pressure by adjusting the air pressure to the pump. Locate the regulator close to the pump, but **upstream** from the pump air bleed valve.
- **Air manifold (F)** has a swivel air inlet. It mounts to the ram, and provides ports for connecting lines to air-powered accessories.
- **Air line filter (J)** removes harmful dirt and moisture from the compressed air supply.
- **Second bleed-type air valve (K)** isolates the air line accessories for servicing. Locate upstream from all other air line accessories.
- **Pneumatic crossover (Model 970025) or electrical crossover (Model 970026) (L)** provides switching between dual rams to provide a constant supply of material to the system. The crossover controls the air supply to each of the ram air motors.  
**Low-level shutoff (Model 970027 and 234117) (L)** provides automatic shutdown of a single ram system when only a small amount of material remains. The shutoff controls the air supply to the ram air motor.
- **Ram air regulator (T)** controls the air pressure to the ram.
- **Ram director valve (U)** controls the raising and lowering of the ram.
- **Air release valve (V)** opens and closes the flow of air to assist raising the ram plate (C) out of an empty drum.
- **Bleed handle (CC)** bleeds air from under the ram plate (C) to assist in priming the pump and lowering the ram plate into the drum.

# Component Identification and Function

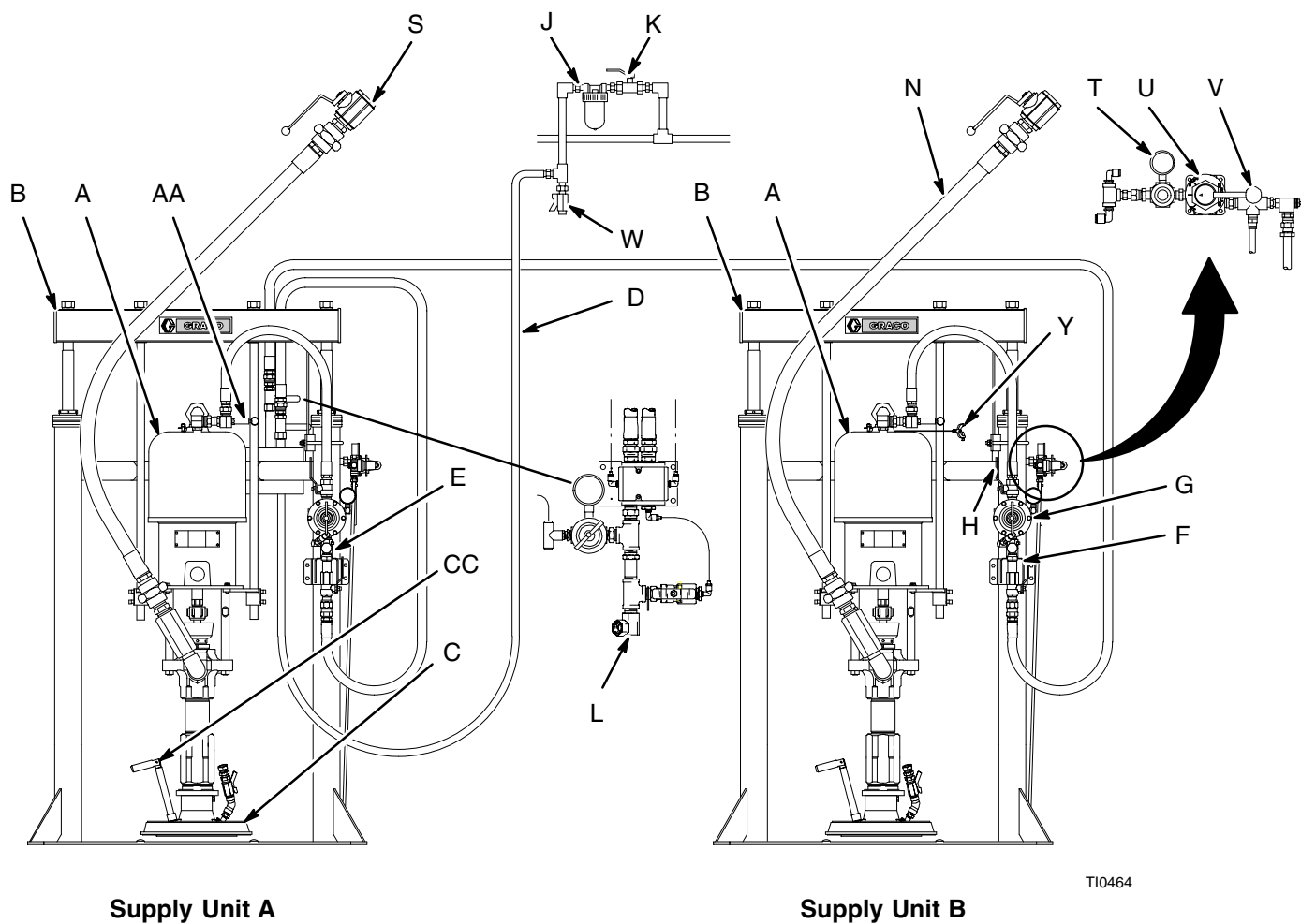
## KEY

**A** Pump  
**B** Ram (two used on 970025 and 970026, one used on 970027 and 234117)  
**C** Ram Plate  
**D** Electrically Conductive Air Supply Hose  
**E** Main Air Bleed Valve (required, for pump and ram)  
**F** Air Manifold  
**G** Pump Air Regulator

**H** Pump Air Bleed Valve (required, for pump)  
**J** Air Line Filter  
**K** Bleed-Type Air Valve (for accessories)  
**L** Pneumatic Crossover (for 970025), Electrical Crossover (for 970026), Low-level Shutoff (for 970027 and 234117)  
**N** Electrically Conductive Fluid Hose

**S** Ball Valve  
**T** Ram Air Regulator  
**U** Ram Director Valve  
**V** Air Release Valve  
**W** Air Line Drain Valve  
**Y** Ground Wire (required; Refer to page 8 for setup)  
**AA** Safety Valve  
**CC** Bleed Handle

## Model 970025 Tandem Shown



T10464

Fig. 1

# System Setup

## System Setup

The following typical system installation is only a guide for selecting and installing system components and accessories. Contact your Graco distributor for help in designing a system to suit your particular needs.

Air-powered ram extruder systems force high viscosity fluids into the intake valve of the fluid pump. Make certain all accessories are adequately sized and pressure-rated to meet your system's requirements.

## Air and Fluid Hoses

Be sure all air hoses (D) and fluid hoses (N) are properly sized and pressure-rated for your system. Use only electrically conductive hoses. See Fig. 1.




## Selecting System Ram Locations

System rams are to be positioned so that air regulator controls for pumps and rams are easily accessible. Make sure there is overhead clearance for rams when fully raised. Refer to Dimensional Drawing on page 21 and separate ram manual 306934 (supplied) for additional setup data.

Use holes in ram base as a guide, drill holes for 13 mm (1/2 in.) anchors.

Check that ram base is level in all directions. If necessary, level base using metal shims. Secure base to floor using 13 mm (1/2 in.) anchors to prevent ram from tipping.

## System Grounding

 <b>WARNING</b>	
	<b>FIRE AND EXPLOSION HAZARD</b>
	<b>ELECTRIC SHOCK HAZARD</b>
Before operating the pump, ground the system as explained below. Also read the section <b>FIRE, EXPLOSION AND ELECTRIC SHOCK HAZARD</b> on page 4.	

1. **Ram Pumps:** check ground wire and clamp. See Fig. 2. To install, loosen grounding lug locknut (W) and washer (X). Insert one end of 1.5 mm<sup>2</sup> (12 ga) minimum ground wire (Y) into slot in lug (Z) and tighten locknut securely. Connect other end of wire to true earth ground.

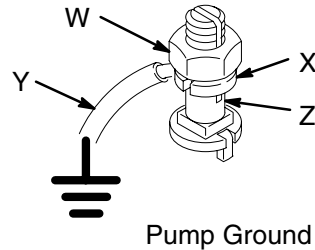


Fig. 2

0864

2. **Air and fluid hoses:** use only electrically conductive hoses.
3. **Air compressor:** follow manufacturer's recommendations.
4. **Dispense gun:** ground through connection to properly grounded fluid hose and pump.
5. **Material supply container:** follow your local code.
6. **Object material is applied to:** follow your local code.
7. **Solvent pails used when flushing:** follow your local code. Use only metal pails, which are conductive, placed on grounded surface. Do not place pail on nonconductive surface, such as paper or cardboard, which interrupts grounding continuity.
8. **To maintain grounding continuity when flushing or relieving pressure,** hold metal part of dispense gun firmly to side of grounded **metal** pail, then trigger gun.



# System Setup

## Pneumatic Crossover Setup (Model 970025)

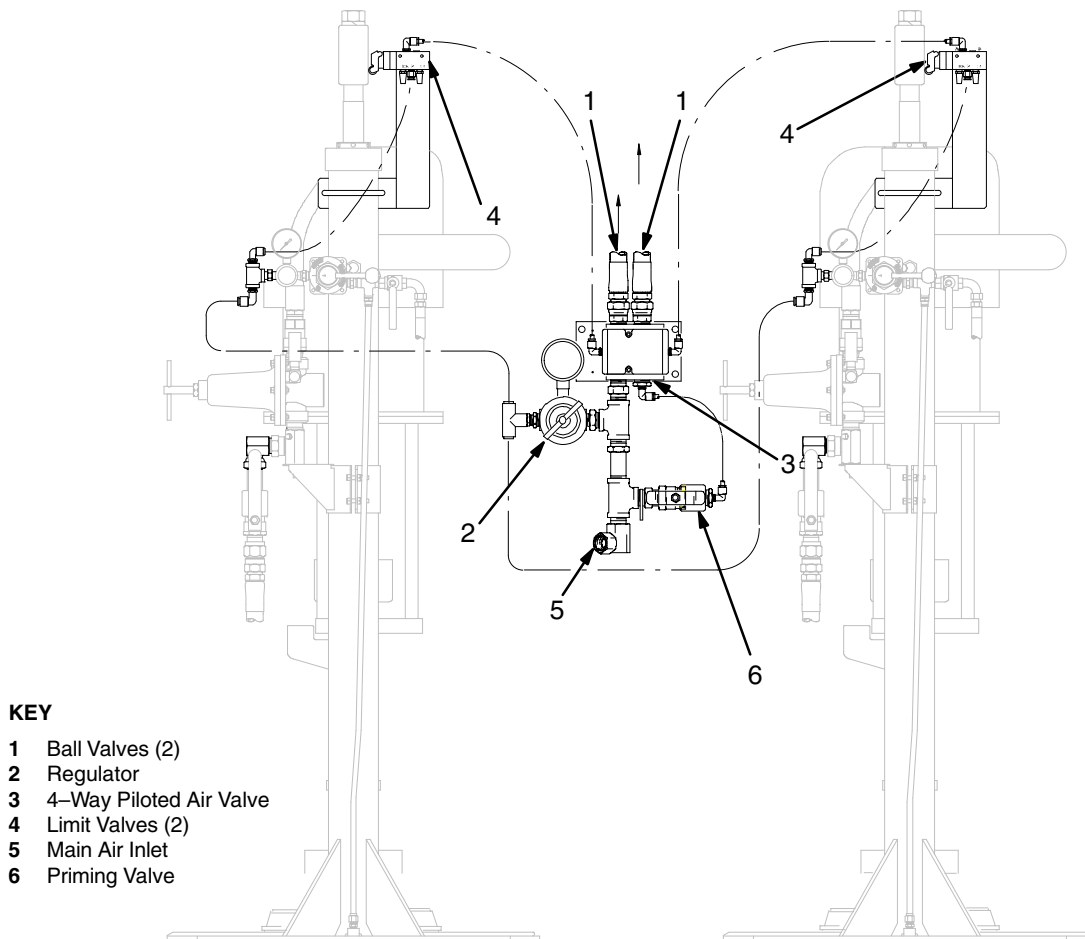
Install the pneumatic crossover as shown in Fig. 3.  
Also See Schematic, Fig. 7, page 23.

**NOTE:** During system operation, as the ram approaches the drum bottom, the top of the ram contacts the limit valve switch. The switch shuts off air to the ram air motor via a 4-way piloted air valve (3). As the valve stops air to one ram, it starts air to the other ram. This allows constant material flow and changing out of material drums.

**NOTE:** The position of the limit valve (4) on the ram determines when the ram air motor is turned on and off. During operation, this position can be adjusted as desired.

**NOTE:** The manually operated priming valve (6) allows the operator to prime the second pump in preparation for change over. Once priming is accomplished the valve should be immediately returned to the closed position.

## Pneumatic Crossover Setup (Model 970025)



TI0466

Fig. 3

# System Setup

## Electrical Crossover Setup (Model 970026)

The electrical crossover is setup as shown in Fig. 4 and the Unloader Crossover (1) must be connected to a 120 Volt, 60 Hz supply.

During system operation, as the ram approaches the drum bottom, the top of the ram contacts the limit valve switch. The switch shuts off the air to one ram, and starts the other ram. This allows constant material flow and changing out of material drums.

The position of the empty level indicator kit (2) on the ram determines when the ram air motor is turned on and off. During operation, this position can be adjusted as desired. See Fig. 4.

The crossover panel has a Prime Empty Pump button. When making a change of material barrels, this button must be pushed after the ram is in the new drum of material and the majority of air has been removed via the follower bleed stick. After pushing the button, open the pump bleed valve **slowly** until all air escapes and only material flows (minimum of 4 pump cycles). The standby pump air shuts off automatically after 5 minutes.

## Electrical Crossover Setup (Model 970026)

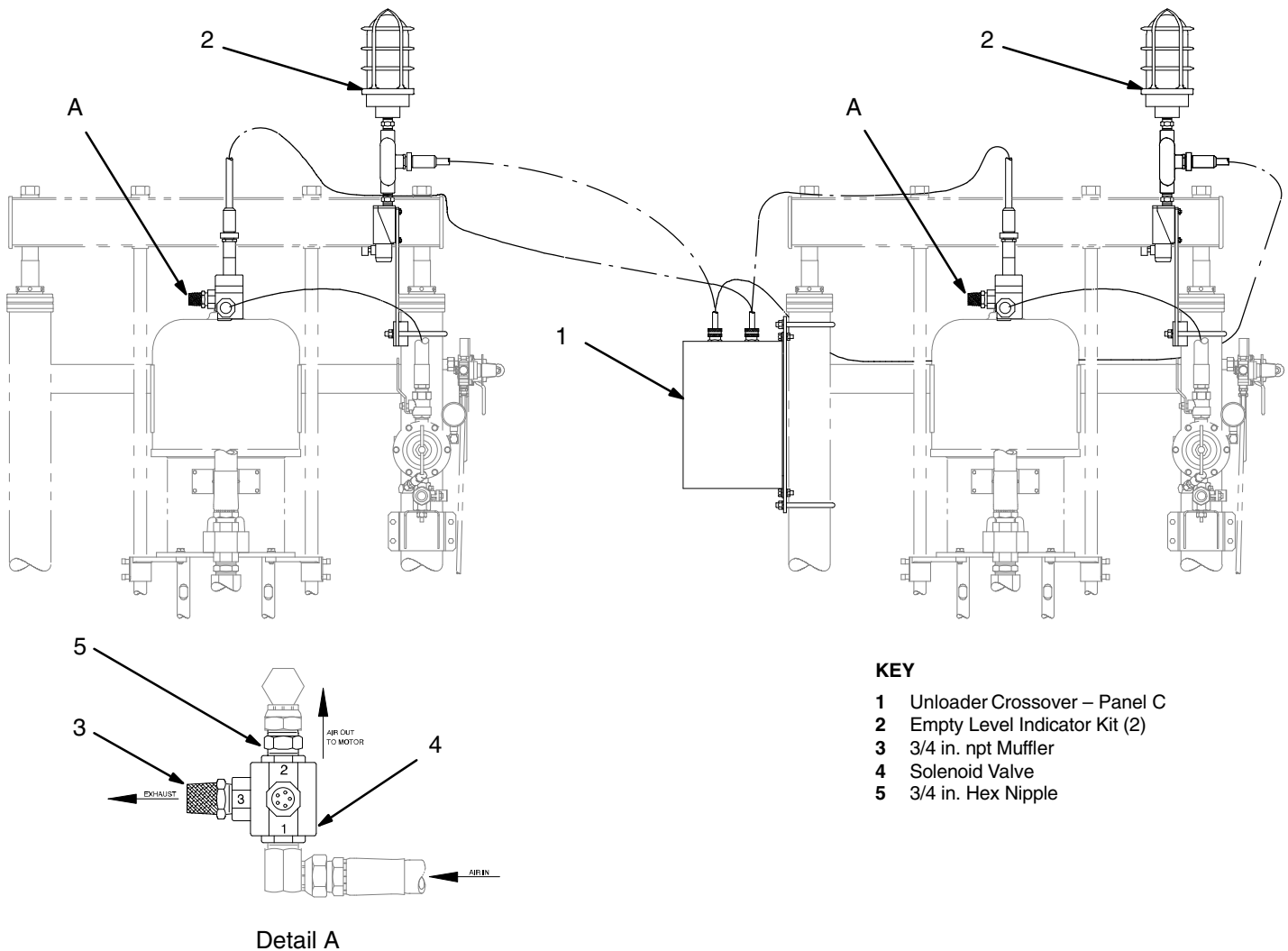


Fig. 4

8584A

# System Setup

## Low-Level Shutoff Setup (Model 970027 and 234177)

Setup the low-level shutoff as shown in Fig. 5.

During system operation, as the ram approaches the drum bottom, the top of the ram contacts the limit switch. The switch shuts off the air to the ram.

**NOTE:** The position of the air limit valve (2) on the ram determines when the ram air motor is turned on and off. During operation, this position can be adjusted as desired. See Fig. 5.

## Low-Level Shutoff Setup (Model 970027 and 234117)

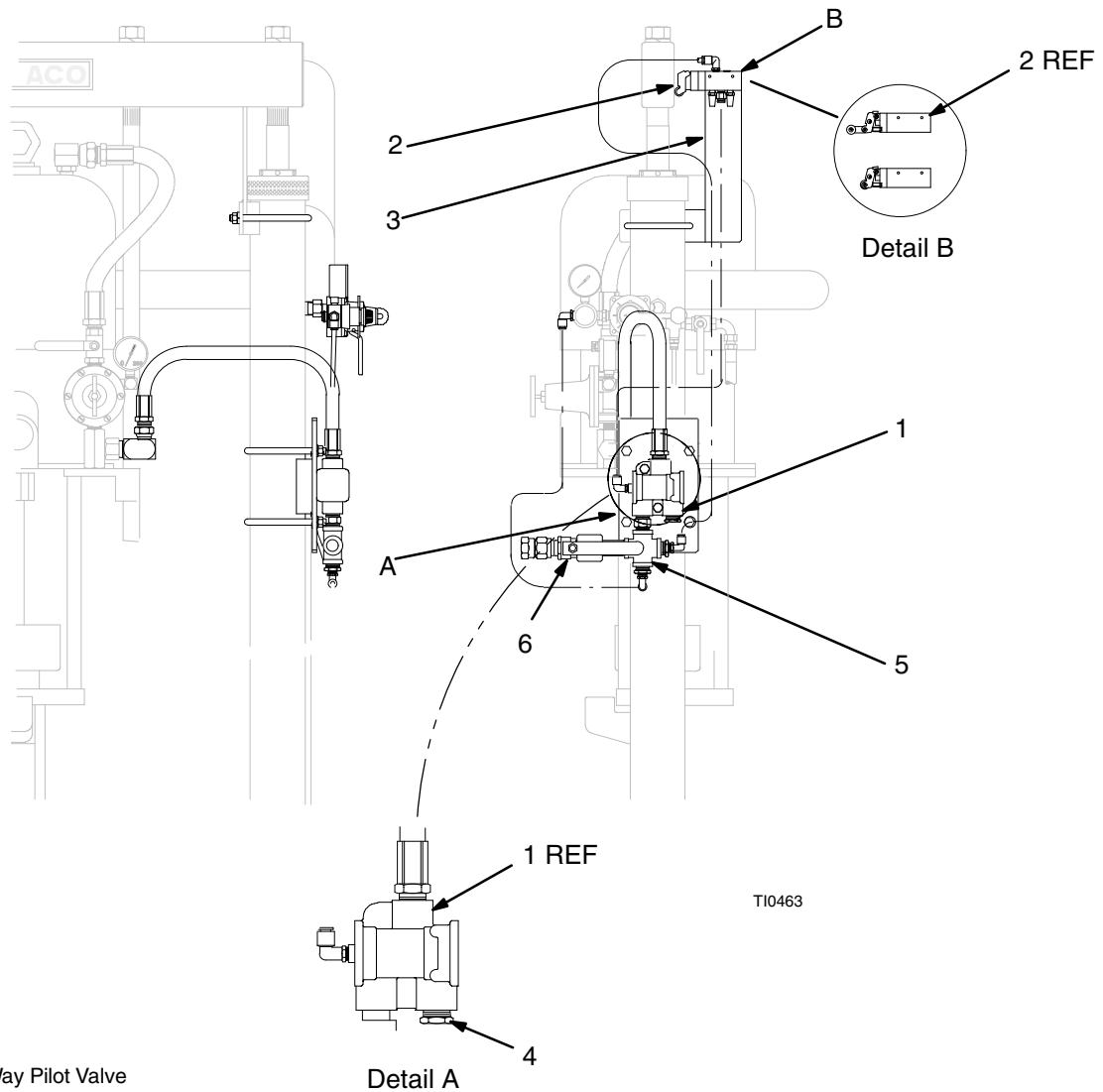


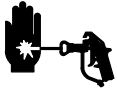
Fig. 5

8586A

# Operation

## Pressure Relief Procedure

### **WARNING**



#### **INJECTION HAZARD**

The system pressure must be manually relieved to prevent the system from starting or spraying 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 dispensing,
- check or service any of the system equipment,
- or install or clean the dispense ball valve.

1. Relieve system pressure to which Graco module supply units are attached.
2. Close dispenser ball valves (S). Unhook ball valves from system. See Fig. 1.
3. Close pump air bleed valve (H, required in your system). See Fig. 1 or Fig. 6.
4. Shut off main air bleed valve (E, required in your system). Set ram director valve (U) to DOWN. Ram will slowly drop.
5. Hold metal part of dispenser ball valve firmly to side of grounded metal pail, and open ball valve to relieve pressure.
6. Close dispenser ball valve.
7. Repeat procedure for each ram (for models 970025 and 970026 only).

## Flushing the System

Flush the system before initial use to prevent material contamination.

### **CAUTION**

**Flush the system before performing the initial material loading procedure.** The system was factory-tested using a light soluble oil, a soybean oil, or other oil as tagged. Flush the system to avoid contaminating the material that has been designated for initial material loading.

To flush the system, perform the following procedure:

1. Select material to be used.

### **WARNING**

Use fluids and solvents that are chemically compatible with the equipment wetted parts. Refer to the **Technical Data** sections of all the equipment manuals. Always read the material manufacturer's literature before using fluid or solvent in this pump.

2. Verify that factory-test oil and material are compatible:
  - a. If substances are compatible, omit following step b and proceed to step 4.
  - b. If substances are incompatible, perform remaining steps to flush system.
3. Select drum of solvent that dissolves, cleans, and eliminates factory-test oil from system. If necessary, check with Graco Distributor or material supplier for recommended solvent.
4. Before flushing, be sure entire system and flushing drums are properly grounded. Refer to **System Grounding**, on page 8.
5. Using compatible solvent, perform **Starting and Adjusting System Rams** procedure and **Starting and Adjusting the Pump** procedure on page 14.
6. Flush solvent through system for 1 to 2 minutes.
7. Remove drum containing solvent.

# Operation

Model 970025 Tandem Ram Shown

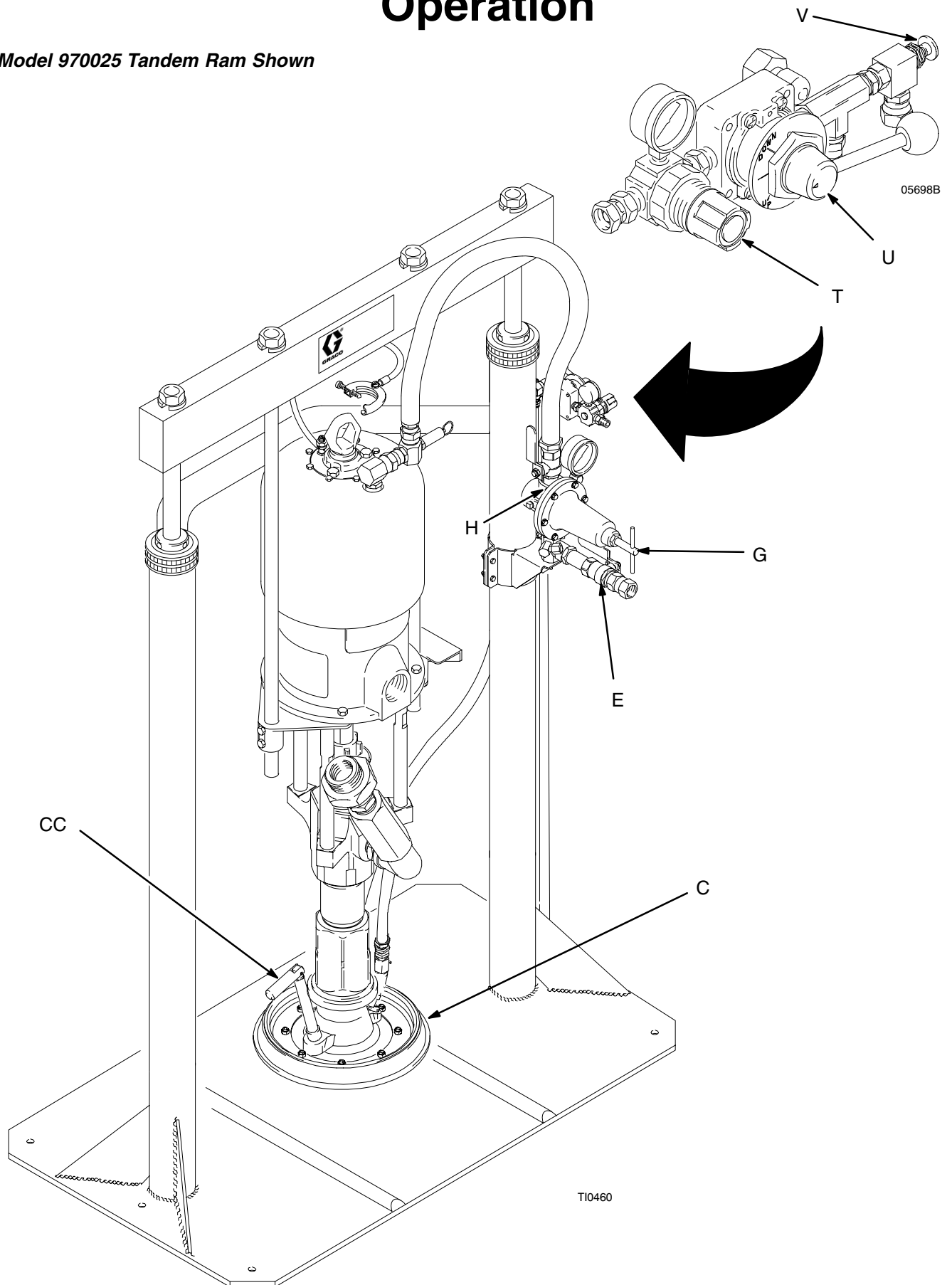


Fig. 6

# Operation

## Starting and Adjusting System Rams

### WARNING



#### **PRESSURIZED EQUIPMENT HAZARD**

To reduce risk of injury or equipment damage:

- Make sure all material hose connections are secure.
- Check that all routing of air lines will not interfere with any moving components within the fixture.
- Do not pressurize the system until you have verified the system is ready and it is safe to do so.

1. Use following instructions to start and adjust system rams.
2. Close all air regulators and air valves. See Fig. 6.
3. Open main air bleed valve (E) and set ram air regulator (T) to 2.8 bar, 0.28 MPa (40 psi). Move director valve (U) handle so arrow points to UP, and let ram rise to full height.
4. Set full drum of fluid on ram base, slide drum back against tube stop, and center under ram plate (C). Center, hold, and properly align drum with ram.
5. Ensure drum cover is free from debris and remove drum cover. Smooth material surface with straightedge.

### WARNING



#### **MOVING PARTS HAZARD**

Moving parts can pinch or amputate your fingers. When the pump is operating and when raising or lowering the ram, keep your fingers and hands away from the pump intake, ram plate, and lip of the drum.

### CAUTION

To help avoid damage to equipment, *do not* use drums that have side bungs or large dents with this ram. Rough bung openings or large dents will damage the wipers or stop the ram plate, resulting in a runaway pump.

6. Lubricate wipers with material compatible lubricant. Contact material supplier for lubricant recommendations.
7. Move director valve handle to DOWN position to lower ram. Lower ram until ram plate is just above drum, then set valve to neutral position. Reposition drum as necessary so wipers do not hit drum lip. Open vent valve (CC) on ram plate.
8. Set director valve to DOWN position and lower ram until fluid appears at vent valve (CC). Set director valve to neutral and close vent valve.

## Starting and Adjusting the Pump

1. Be sure pump air regulator (G) is closed. Set ram air regulator (T) to 3.5 bar, 0.35 MPa (50 psi). Set director valve (U) to DOWN. See Fig. 6.
2. Start pump as explained in separate pump instruction manual.
3. Keep director valve (U) set to DOWN while pump is operating.

**NOTE:** Increase air pressure to the ram if the pump does not prime properly with heavier fluids. If fluid is forced out around the top wiper, ram pressure is too high and the air pressure should be decreased. In general, ram pressure should be set at the lowest pressure that allows for proper operation of the system.

# Operation

## Changing Drums

### **WARNING**



#### **MOVING PARTS HAZARD**

Moving parts can pinch or amputate your fingers. When the pump is operating and when raising or lowering the ram, keep your fingers and hands away from the pump intake, ram plate, and lip of the drum.

1. Stop pump. Close pump air bleed valve (H). See Fig. 6.
2. Before raising wiper plate, locate push button on air release valve (V).
3. Set director valve (U) to UP to raise wiper plate. At the same time, carefully equalize pressure in drum by operating air release valve.
4. Raise wiper plate until it is completely out of drum.
5. Remove empty drum.

6. Inspect wiper plate and, if necessary, remove any remaining material or material build-up.
7. Place full drum on ram base.
8. Lubricate wipers.
9. Lower ram and adjust position of drum relative to ram plate, as explained under **Starting and Adjusting Ram** on page 14.

## Shutdown and Care of the Pump

1. Set director valve (U) to neutral. 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 12.

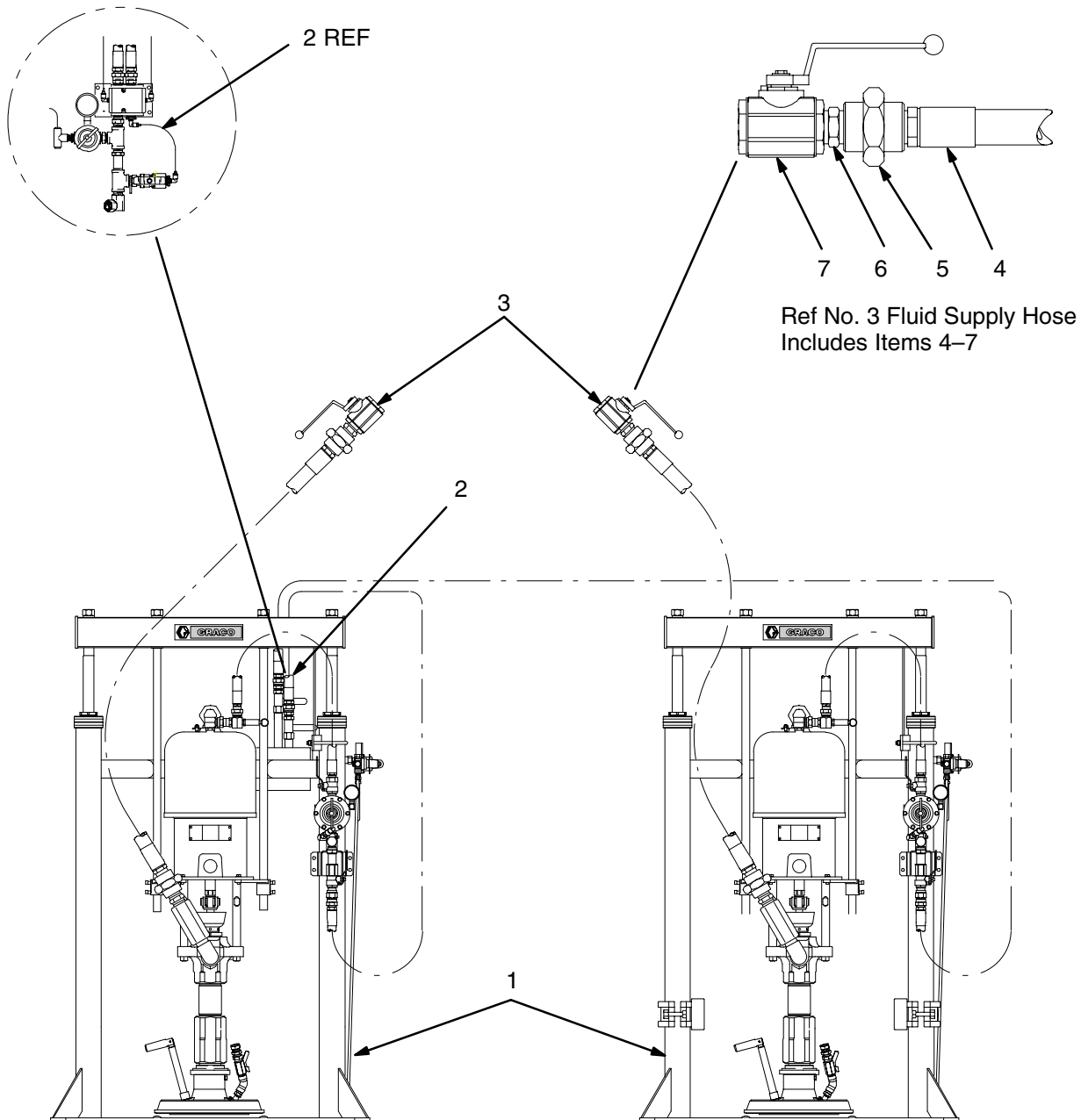
2. **Relieve pressure.**
3. Follow pump shutdown instructions in your separate pump manual.

# Parts

**Model 970025**

**Tandem with Pneumatic Crossover, 65:1 Ratio King Pump**

Includes items 1–7

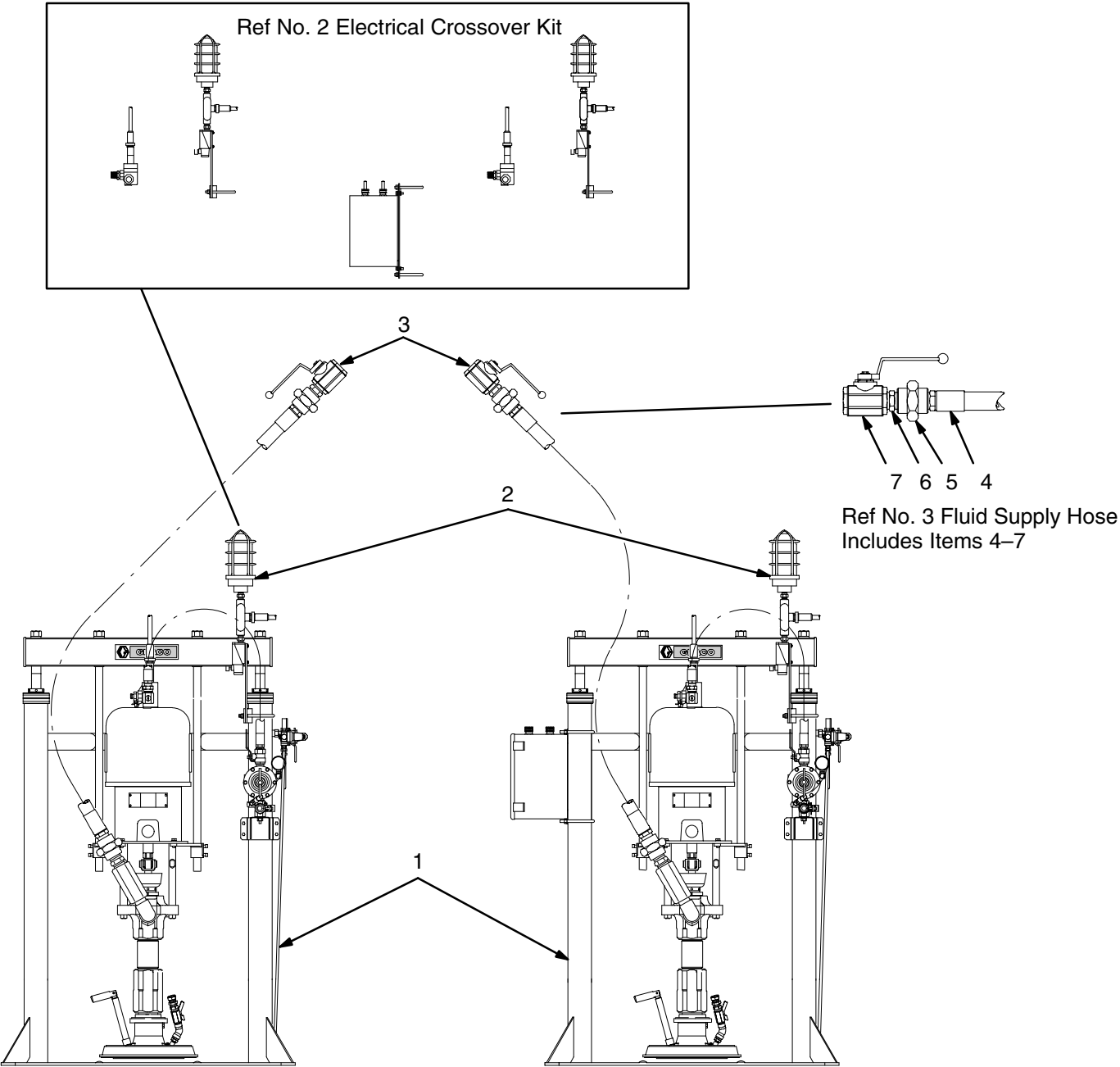


Ref No.	Part No.	Description	Qty	Ref No.	Part No.	Description	Qty
1	C59522	PUMP, ram-mounted 19 liter (5 gal.) See 308027 for parts	2	4	521973	. HOSE	1
2	918468	KIT, pneumatic crossover See 310293 for parts	1	5	521975	. UNION, pipe	1
3	C56995	HOSE ASSEMBLY, fluid supply; Includes items 4–7	2	6	C20490	. NIPPLE, hex	1
16	309230			7	118854	. VALVE, ball	1



# Parts

**Model 970026**  
**Tandem with Electrical Crossover, 65:1 Ratio King Pump**  
Includes items 1–7



Ref No.	Part No.	Description	Qty	Ref No.	Part No.	Description	Qty
1	C59522	PUMP, ram-mounted 19 liter (5 gal.) See 308027 for parts	2	4	521973	. HOSE ASSEMBLY	1
2	C59519	KIT, electrical crossover See 310295 for parts	1	5	521975	. UNION, pipe	1
3	C56995	HOSE, fluid supply; Includes items 4–7	2	6	C20490	. NIPPLE, hex	1
				7	118854	. VALVE, ball	1

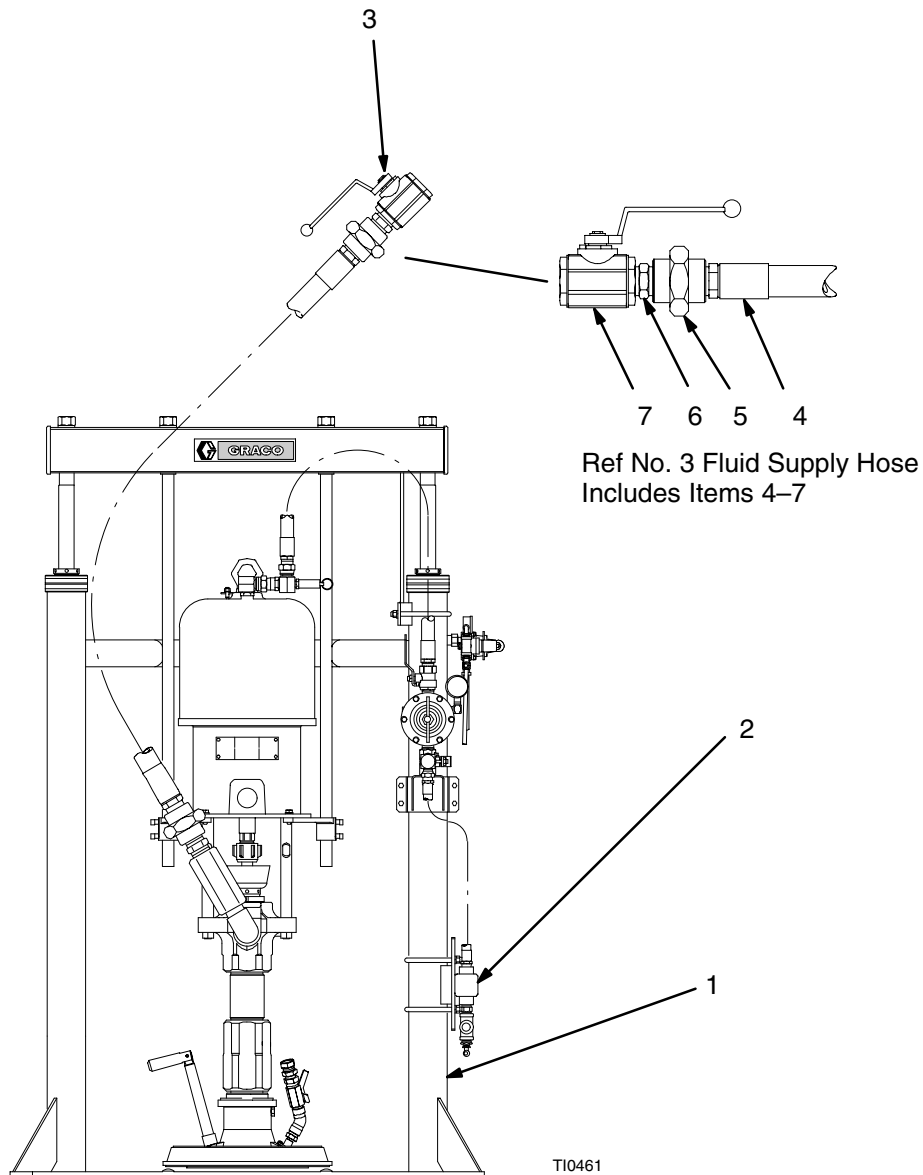
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# Parts

## Model 970027

### Supply Unit with Pneumatic Low Level Shut-Off, 65:1 Ratio King Pump

Includes items 1–7



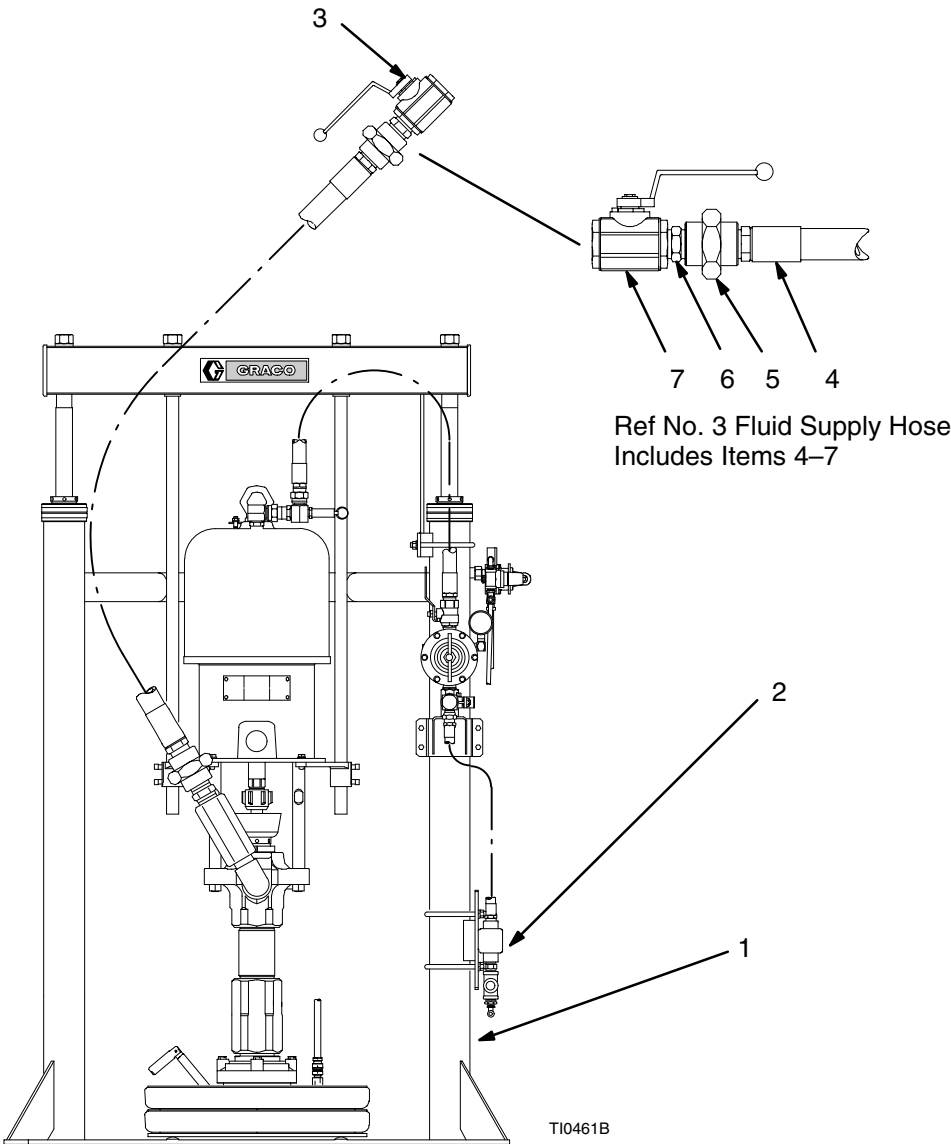
Ref No.	Part No.	Description	Qty	Ref No.	Part No.	Description	Qty
1	C59522	PUMP, ram-mounted 19 liter (5 gal.) See 308027 for parts	1	4	521973	. HOSE ASSEMBLY	1
2	918478	KIT, shut-off, low level, pneumatic See 310294 for parts	1	5	521975	. UNION, pipe	1
3	C56995	HOSE, fluid supply; Includes items 4–7	1	6	C20490	. NIPPLE, hex	1
				7	118854	. VALVE, ball	1

# Parts

## Model 234117

### Supply Unit with Pneumatic Low Level Shut-Off, 65:1 Ratio King Pump

Includes items 1–7

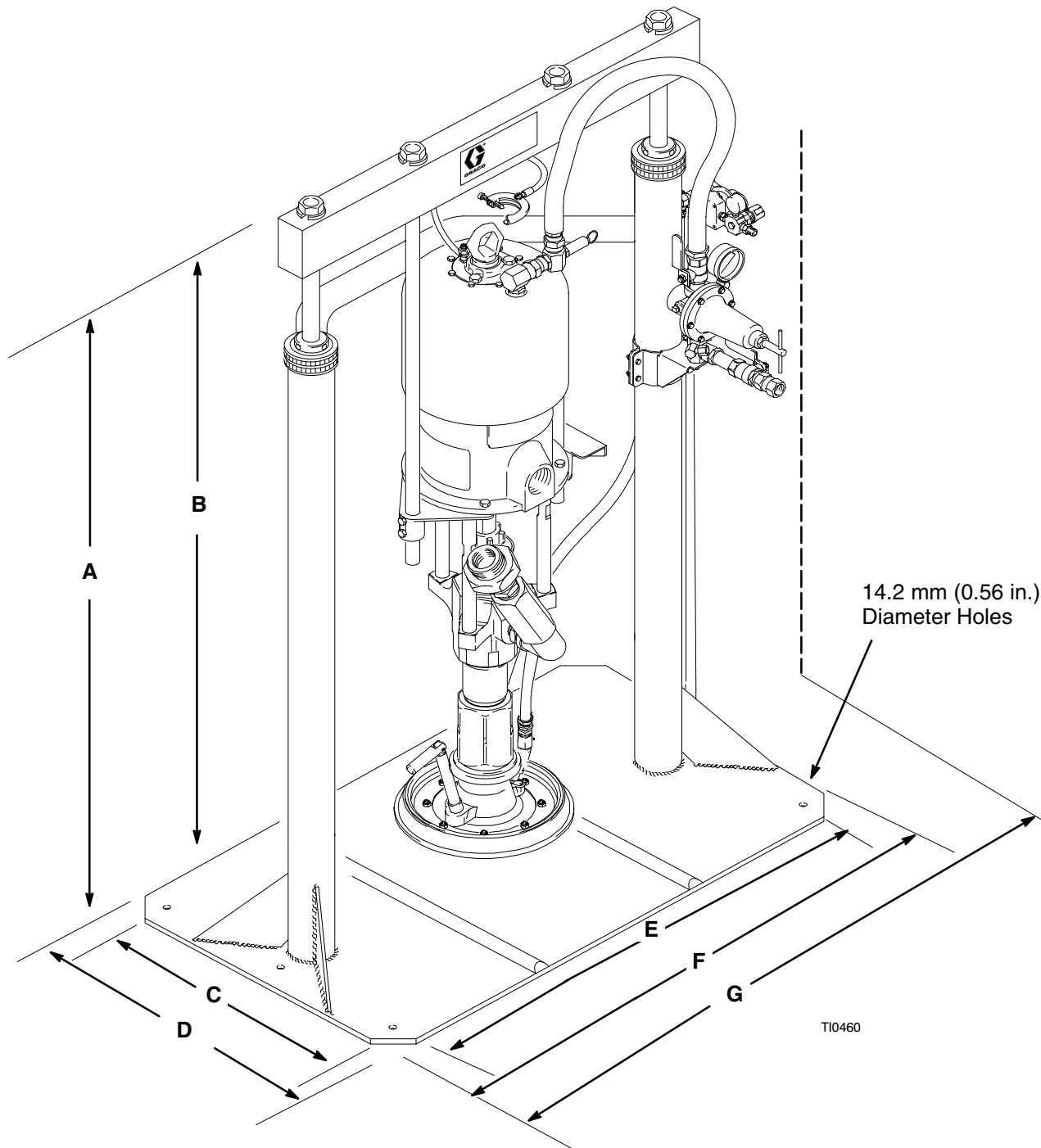


Ref No.	Part No.	Description	Qty	Ref No.	Part No.	Description	Qty
1	234051	PUMP, ram-mounted 120 liter (30 gal.) See 308027 for parts	1	3	C56995	HOSE, fluid supply; Includes items 4–7	1
2	918478	KIT, shut-off, low level, pneumatic See 310294 for parts	1	4	521973	. HOSE ASSEMBLY	1
				5	521975	. UNION, pipe	1
				6	C20490	. NIPPLE, hex	1
				7	118854	. VALVE, ball	1

## Notes

# Ram Mounted Pump Clearance Dimensions

Model 970025 Ram Shown



Model	A (Raised)	B (Lowered)	C	D	E	F	G
All	2578 mm (101.5 in.)	1575 mm (62 in.)	533 mm (21 in.)	635 mm (25 in.)	965 mm (38 in.)	1067 mm (42 in.)	1111 mm (43.74 in.)

# Technical Data

Model	Pump Model	Displacement Pump Model	Ratio	Maximum Fluid Working Pressure	Maximum Pump Air Input Pressure
970025	King™	Check-Mate™ 800	65:1	336 bar, 33.6 MPa (4875 psi)	5.2 bar, 0.52 MPa (75 psi)
970026	King™	Check-Mate™ 800	65:1	336 bar, 33.6 MPa (4875 psi)	5.2 bar, 0.52 MPa (75 psi)
970027	King™	Check-Mate™ 800	65:1	336 bar, 33.6 MPa (4875 psi)	5.2 bar, 0.52 MPa (75 psi)
234117	King™	Check-Mate™ 800	65:1	336 bar, 33.6 MPa (4875 psi)	5.2 bar, 0.52 MPa (75 psi)

## Sound Data

Part No.	Pump Model	Air Pressure of Sound Tests (25 cycles/min)	* Sound Pressure Level	** Sound Power Level
970025	King™	6.3 bar, 0.63 MPa (90 psi)	98 dBa	113 dBa
970026	King™	6.3 bar, 0.63 MPa (90 psi)	98 dBa	113 dBa
970027	King™	6.3 bar, 0.63 MPa (90 psi)	98 dBa	113 dBa
234117	King™	6.3 bar, 0.63 MPa (90 psi)	98 dBa	113 dBa

\* Sound pressure was measured in accordance with Cagi Pneurop, 1969.

\*\* Sound power was measured in accordance with ISO 3744, 1981.

Main air inlets [for 970025 (1) and 970026 (2)] ..... 3/4 in. npsm(f)

Main air inlet (for 970027 and 234117) ..... 1/2 in. npt(f)

Material outlets ..... 1–1/4 in. npt(f)

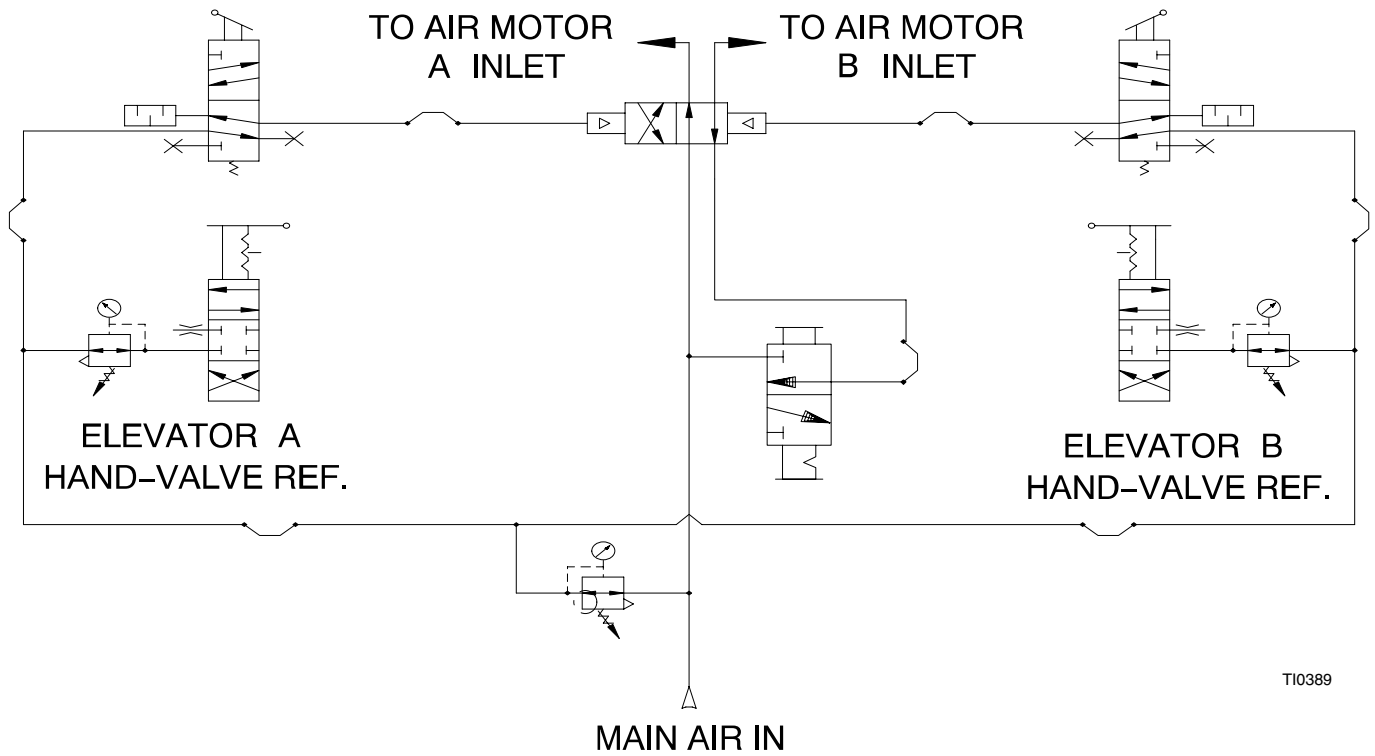
Maximum fluid flow (at 60 cpm) ..... 2.8 gpm (10.61 lpm)

Air consumption (at 75 psi) ..... 100 scfm (2.8 m³/min)

Wetted parts ..... *Fluid outlet fittings: zinc or cadmium-plated carbon steel*

*Viton® is registered trademarks of the DuPont Co.*

# Schematic



**Pneumatic Crossover Schematic Diagram (Model 970025 only)**

**Fig. 7**

# Graco Standard Warranty

Graco warrants all equipment manufactured by Graco and bearing its name to be free from defects in material and workmanship on the date of sale 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.

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**1-800-367-4023 Toll Free**

**612-623-6921**

**612-378-3505 Fax**

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