

1:1 Ratio Adapter Kit

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EN

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

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

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

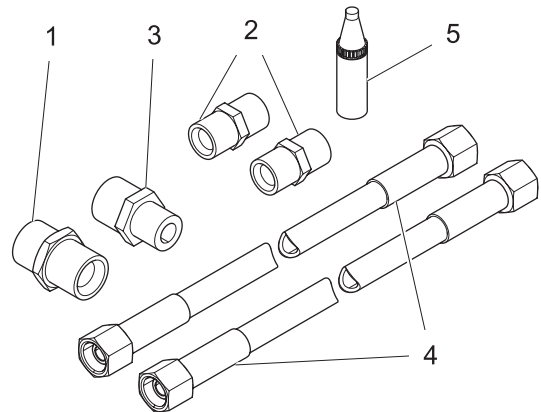
Kit No. 24X461

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



Important Safety Instructions

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



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See **Installation** instructions on page 2.

Parts

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

Installation

When running 1:1 mix ratio materials the:

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

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

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

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

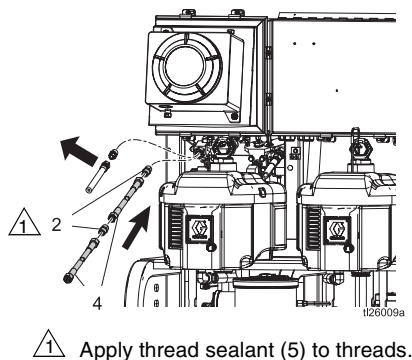
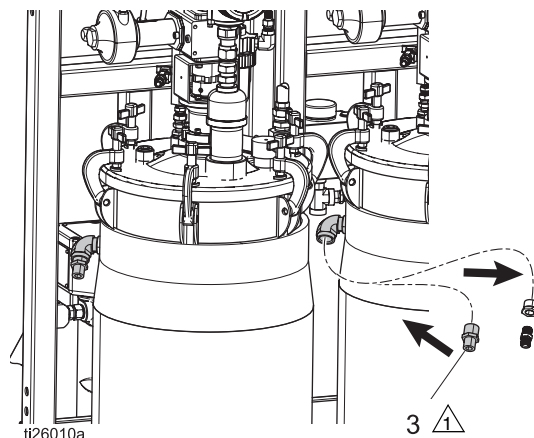


FIG. 1

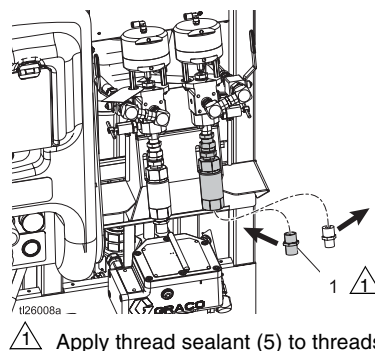
3. Connect the two hoses (4) with fitting (2).
4. Connect the second fitting (2) and hoses (4) to the back of the B side dosing valve.
5. Remove the 3/8 nipple and bushing from the B side feed module tank return and replace with the 3/4 x 1/2 in nipple (3).



⚠ Apply thread sealant (5) to threads.

FIG. 2

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



⚠ Apply thread sealant (5) to threads.

FIG. 3

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

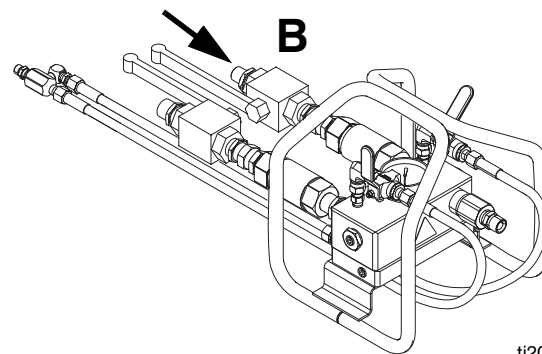


FIG. 4

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

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