

# XP70 Plural-Component Sprayer

Easy-to-Use High-Pressure Sprayer for Industrial Coatings



PROVEN QUALITY. LEADING TECHNOLOGY.

# Graco® XP70 Plural-Component Sprayer



## Easy and affordable two-component spraying

The trend for the coatings industry is toward high solids coatings. Formulated with less solvent, these coatings reduce VOC emissions and speed production with faster cure times.

The Graco XP70 Plural-Component Sprayer is designed to pump, mix and atomize high-viscosity, materials with superior results.

### The spray system handles:

- Environmentally-friendly high solids coatings, with little or no solvent
- Hybrid polyurethanes
- Epoxies
- Very high solids coatings – up to 100% solids content
- Materials requiring heat (requires optional heaters)
- Fast-curing materials

If you spray several different materials each week, the XP70 is the right choice. That's because you can change the ratio by simply changing out one or two pump lowers. Six fixed mix ratios are available: 1:1, 1.5:1, 2:1, 2.5:1, 3:1 and 4:1.

## On-ratio spraying means peace of mind

With an optional **XP Pressure Monitor Kit**, you have the assurance that your Graco XP70 is spraying on-ratio. It monitors the spray pressures on the "A" and "B" sides, and shuts down the sprayer if conditions occur such as running out of material, pump cavitation, packing failures, leaks in valves or fittings, or plugged filters.

### Benefits:

- Better overall productivity – projects done on time
- Reduced labor and rework costs
- Confidence in end results and quality

### Applications

- |              |                         |                    |
|--------------|-------------------------|--------------------|
| • Tanks      | • Secondary containment | • Wind towers      |
| • Railcars   | • Marine/shipbuilding   | • Water towers     |
| • Refineries | • Wastewater treatment  | • Structural steel |
| • Pipes      | • Bridges               | • Roof coatings    |



# A Smart Alternative to Hand-mixing

## Engineered specifically for two-component coatings

The Graco XP70 Plural-Component Sprayer provides the high-pressure performance you need to spray high-viscosity, high-solids coatings. In addition, the unit is designed to maximize gravity feed, which may eliminate the need for feed pumps, saving you money.

### NXT® Air Motor

- Standard anti-icing feature means production won't stop due to motor icing
- Modular design for easier maintenance
- Rugged body armor won't rust or dent

### Outlet manifold and valves

- Fluid pressure gauges to monitor pump output
- Provides automatic overpressure relief
- Includes circulation back to the supply for pump priming, purging, or relieving outlet pressure
- Allows fluid warm-up circulation when optional heaters are used

### Mix manifold

- Provides simple fluid control for mixing or flushing
- Accurately dispenses A and B fluids to the static mix tube
- Handles high-solids coatings with large ports and low pressure drop
- Choose to use mix manifold remotely to reduce solvent and material waste

### High-pressure to handle high-viscosity coatings

- Rated for 7250 psi (500 bar, 50 MPa) to handle viscous materials and long hose lengths

### Compact cart-mounted

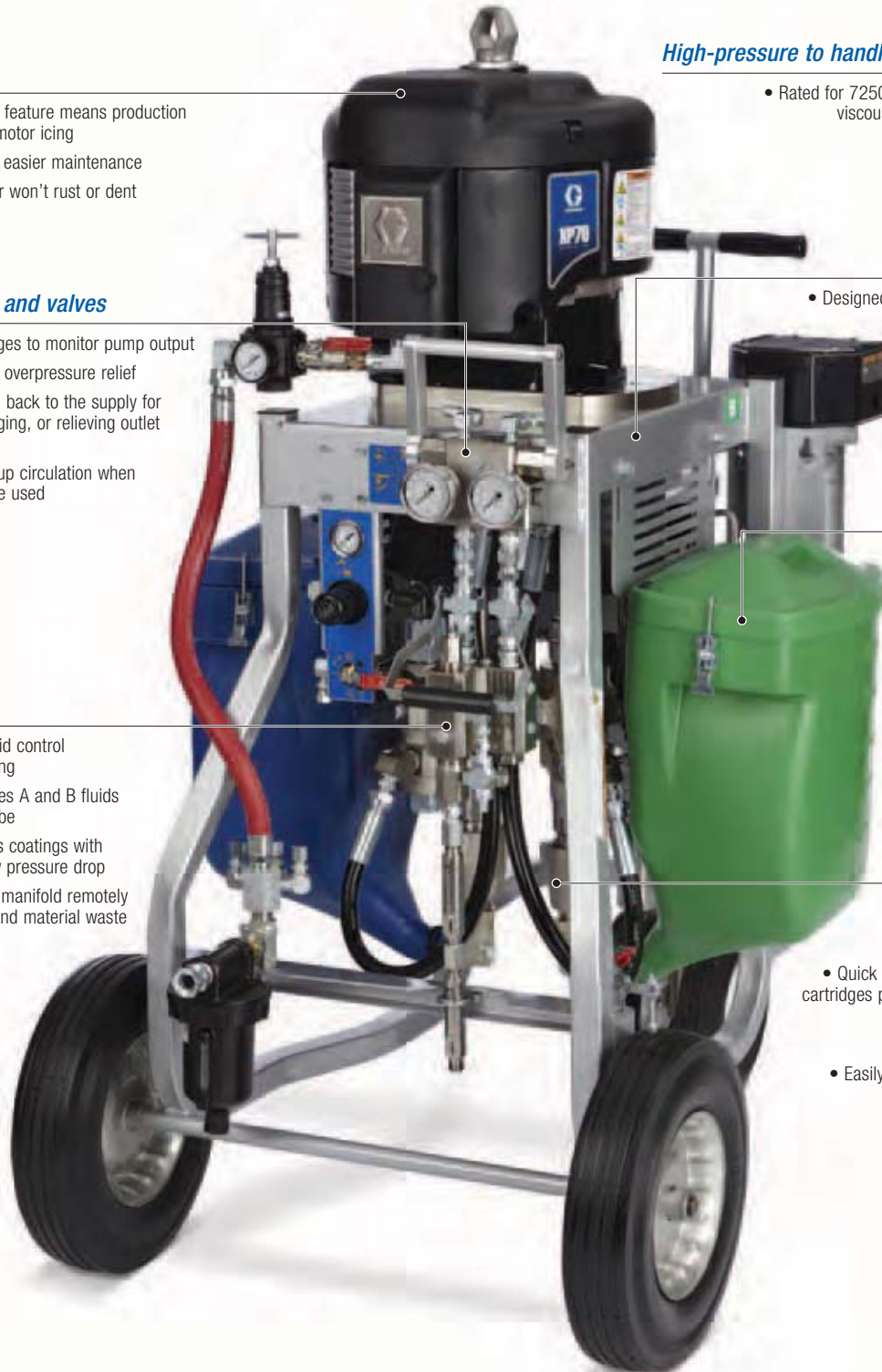
- Designed for easy handling by one person
- Can be floor mounted after removing wheels
- Easy mounting of optional flush pump and heaters

### Material hoppers

- Side-mounted 7-gal (26 liter) hoppers hold A and B components until it's time to spray
- Made of rugged polyethylene – unaffected by harsh solvents
- Optimized for direct pump feed

### Xtreme® Pump lowers

- Standard Severe Duty coating on rods and cylinder maximizes wear life
- Quick knockdown design and throat seal cartridges provide fast and easy maintenance
- Six sizes available to provide various fixed mix ratios
- Easily change one or both lowers to get desired mix ratio (see pg. 5)



# Discover How the XP70 Pays for Itself

## Quick return on your investment

You'll discover that the Graco XP70 Plural-Component Sprayer pays for itself when you switch from hand-mixing. Here's how:

### Reduces material costs

With the Graco XP70, you eliminate waste and save money because you only mix as much material as you need. No more throwing away unused material at the end of the day. No more residue left over in smaller pails or cans. You can buy material in bulk as well.

### Saves money by using less clean-up solvent

Only the parts that come in contact with mixed material must be cleaned. Instead of flushing out an entire pump system that contains mixed material, you only need to flush the static mix tube and hose to the gun. Reduced cleaning time means you save labor costs and increase uptime.

### Provides consistent material quality

No more guesswork or human error in measuring means you can improve throughput, cut back on material waste, and reduce rework. Materials are proportioned by precision positive displacement pumps and mixed accurately and on-ratio at the mix manifold.

### Easy to operate

With proper training, operators are up and running quickly. The Graco XP70 runs right out of the box with low set-up time. Accessory kits can be added for heat and solvent flush.

### Reduces maintenance costs

Engineered to proportion with two pumps instead of three, the Graco XP70 reduces cost of ownership because you only need to rebuild two pumps.



# Selection and Savings ROI

## Typical pay back in less than 12 months

Compare XP70 to hand-mixing and see how much you'll save. XP70 provides a substantial return on investment compared to hand mixing because you throw away less mixed material, and you use less solvent. Visit [www.graco.com/xp70](http://www.graco.com/xp70) to calculate an ROI for your application.

MATERIAL SAVINGS (by eliminating unused mixed material in pail)	*EXAMPLE	ACTUAL	FORMULA
Average cost of coating per gallon	\$40.00		A
Amount of wasted material per day	.75 gal		B
Average cost of wasted coating per day	\$30.00		C = AxB
<b>TOTAL SAVINGS</b> (assumes 200 work days per year)	<b>\$6,000.00</b>		<b>D = Cx200</b>
MATERIAL SAVINGS (by shortening mixed material hose length)	*EXAMPLE	ACTUAL	FORMULA
Material volume in shortened hose (assumes 3/8-in hose x 50 ft = 1100 cc)	1100 cc		E
Average cost of wasted coating per day (F = E/3785 cc/gal x A)	\$11.62		F
<b>TOTAL SAVINGS</b> (assumes 200 work days per year)	<b>\$2,325.00</b>		<b>G = Fx200</b>
SOLVENT SAVINGS (by eliminating potlife extender)	*EXAMPLE	ACTUAL	FORMULA
Average cost of potlife extender per gallon	\$15.00		H
Amount of potlife extender used per day (assumes 0.5 gal solvent per 5 gal material)	4 gal		I
Average cost of potlife extender used per day	\$60.00		J = HxI
<b>TOTAL SAVINGS</b> (assumes 200 work days per year)	<b>\$12,000.00</b>		<b>K = Jx200</b>
SOLVENT SAVINGS (by eliminating pump flushing)	*EXAMPLE	ACTUAL	FORMULA
Average cost of solvent per gallon	\$15.00		L
Material volume of pump, siphon hose, siphon tube (220 cc pump + 1320 cc from siphon hose and tube)	1540 cc		M
Amount of solvent used per day (N = M/3785 cc/gal x 3 flush factor x L)	\$18.31		N
<b>TOTAL SAVINGS</b> (assumes 200 work days per year)	<b>\$3,662.00</b>		<b>O = Nx200</b>
<b>TOTAL SAVINGS FROM XP70 WHEN COMPARED TO HAND-MIXING</b>	<b>\$23,987.00</b>		<b>P = D+G+K+O</b>

\*Example is based on spraying 40 gallons in an 8-hour shift. R.O.I. is an example only and should be reviewed for each application. Dollar savings are not guaranteed. Actual results may vary.

## XP Ratio Selection Guide

Mix Ratio by Volume	Pressure Ratio	Resin Pump	Hardener Pump	Combined Output cc's/cycle	Max Air Setpoint psi (bar)	Max Fluid Pressure psi (bar)	Flow rate at 40 cycles/min gpm (lpm)
1:1	76:1	Xtreme 85 (L085C0)	Xtreme 85 (L085C0)	173	95 (6.5)	7250 (500)	1.83 (6.92)
1.5:1	91:1	Xtreme 85 (L085C0)	Xtreme 58 (L058C0)	144	80 (5.5)	7250 (500)	1.52 (5.76)
2:1	76:1	Xtreme 115 (L115C0)	Xtreme 58 (L058C0)	174	95 (6.5)	7250 (500)	1.84 (6.96)
2.5:1	65:1	Xtreme 145 (L14AC0)	Xtreme 58 (L058C0)	203	100 (6.9)	6500 (448)	2.14 (8.12)
3:1	68:1	Xtreme 145 (L14AC0)	Xtreme 48 (L048C0)	193	100 (6.9)	6800 (469)	2.04 (7.72)
4:1	73:1	Xtreme 145 (L14AC0)	Xtreme 36 (L036C0)	181	100 (6.9)	7250 (500)	1.91 (7.24)

# Technical Specifications

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### Fluid filtration

XP pump outlets .....	30 mesh
XTR™-7 Spray Gun .....	60 mesh

**Air inlet filtration** ..... 40 micron

### Ambient temperature range

Operating .....	40° to 130°F (4° to 54°C)
Storage .....	30° to 160°F (-1° to 71°C)

**Max fluid temperature** ..... 160°F (71°C)

**Environmental rating** ..... Indoor/Outdoor

Hazardous areas ..... Ex II 2 G

**Fluid viscosity range** (gravity feed hoppers) ..... 200-20,000 cps (pourable)

**Higher viscosities with pump feed** ..... Pump feed recommended for mix-at-the-gun applications to pre-compress fluids

**Max air pressure supply to the machine** ..... 175 psi (12 bar, 1.2 MPa)

**Sprayer air consumption** (see performance charts in 3A0420) ..... 75 cfm at 100 psi inlet/gpm (0.56 cu meter/min at 7 bar/liter/min)

### Dimensions

Bare machine .....	52 L x 60 H x 32 W in (132 x 152 x 81.6 cm)
With 7 gal (26 l) hoppers .....	52 L x 60 H x 35 W in (132 x 152 x 89 cm)

### Weight

Bare system ..... 425 lb (192 kg)  
*(No heaters, hoppers or junction box)*

Full system ..... 575 lb (260 kg)  
*(Includes 2 heaters, solvent pump and empty hoppers)*

**Air inlet connection** ..... 3/4 npsm (f) union in 3/4 npt (f) port

**Fluid pump inlets (for non-hopper models)** ..... 1-1/4 npt (m)

**Fluid gauge manifold "A" and "B" outlets** ..... 1/2 in npt (f)

**Fluid gauge manifold** ..... 1/4 in npt (m)  
*(combination pressure relief / circulation / prime) outlets back to supply*

**Fluid mix manifold inlets** ..... 3/8 in npt (m) ball valves

**Mix manifold material outlet** ..... 1/2 in npt (f)

**Static mix tube outlet** ..... 3/8 in npt (m)

### Wetted parts

Hard parts ..... Nickel or zinc plated carbon steels, stainless steels, carbide

Soft parts ..... PTFE, UHMWPE, nylon, acetal, solvent resistant o-rings

**Max recommended feed pressure** ..... Less than 15% of outlet pressure

**Sound pressure** ..... 86 dBA at 100 psi (7 bar, 0.7 MPa)

**Sound power** ..... 98 dBA at 100 psi (7 bar, 0.7 MPa)

**Operation and repair manual (English)** ..... 3A0420

## XP70 Options for Added Productivity



### Merkur® Solvent Flush Pump

- Quickly flushes mixed materials from hose and gun
- Provides enough pressure to push good paint out the mix hose with a spray pattern, resulting in less wasted material
- Mounts easily to slotted holes provided on XP cart
- Prime valve can be used to supply flush solvent for tip cleaning, or to flush a second hose and gun that have been removed from the tee in the mix line



### Viscon® Fluid Heaters

- Reduces coating viscosity so it can be sprayed at lower pressure
- Provides consistent spray temperature, resulting in consistent spray pattern and better thickness control
- Mounts easily to slotted holes on XP cart (requires heater mounting kit 262450)
- Available in standard or hazardous atmosphere design



### Xtreme Pump Lower

- Change one or both lowers for desired mix ratio (see page 5)
- XP uses specific Xtreme pump lowers with spring-loaded inlet valves, Tuff stack packings, 30 mesh filters, and no prime valves
- Overpressure rupture protection included on 36 cc, 48 cc and 58 cc sizes
- Six sizes available to provide fixed mix ratios: 1:1, 1.5:1, 2:1, 2.5:1, 3:1, and 4:1



### Remote Mount Mix Manifold

- Mix manifold on cart is removable and can be located closer to the spray gun to reduce mixed coatings and the volume of flush solvent required - results in less wasted materials
- A and B hoses from the XP cart to the mix manifold don't need to be flushed and can be sized for less pressure loss over long runs
- Great for materials with very short pot life
- Use carriage 262522 to protect mix manifold and valves

# Ordering Information

For more high-pressure airless accessories, see High-Pressure Accessories brochure (339361)

## Sprayers – All cart-mounted pump packages include material hoses and XTR-7 gun, and use an NXT 6500 Air Motor (N65DNO)

571100	1:1 Bare proportioner, no cart, guns, hoses or manifolds	571250	2.5:1 Bare proportioner, no cart, guns, hoses or manifolds
571101	1:1 Cart-mounted sprayer without hoppers	571251	2.5:1 Cart-mounted sprayer without hoppers
571102	1:1 Cart-mounted sprayer with hoppers	571252	2.5:1 Cart-mounted sprayer with hoppers
571150	1.5:1 Bare proportioner, no cart, guns, hoses or manifolds	571300	3:1 Bare proportioner, no cart, guns, hoses or manifolds
571151	1.5:1 Cart-mounted sprayer without hoppers	571301	3:1 Cart-mounted sprayer without hoppers
571152	1.5:1 Cart-mounted sprayer with hoppers	571302	3:1 Cart-mounted sprayer with hoppers
571200	2:1 Bare proportioner, no cart, guns, hoses or manifolds	571400	4:1 Bare proportioner, no cart, guns, hoses or manifolds
571201	2:1 Cart-mounted sprayer without hoppers	571401	4:1 Cart-mounted sprayer without hoppers
571202	2:1 Cart-mounted sprayer with hoppers	571402	4:1 Cart-mounted sprayer with hoppers

## Pump Lowerers – All Xtreme XP pump lowerers include built-in filter and Tuff-Stack™ (carbon filled PTFE packings)

L036C0	Xtreme XP 36 lower (repair kit - 262504)	L085C0	Xtreme XP 85 lower (repair kit - 262507)
L048C0	Xtreme XP 48 lower (repair kit - 262505)	L115C0	Xtreme XP 115 lower (repair kit - 262508)
L058C0	Xtreme XP 58 lower (repair kit - 262506)	L14AC0	Xtreme XP 145 lower (repair kit - 262510)

## Water Jacketed Heated Hoses – (Approved for explosive atmospheres) 50 ft (15.2 m) sections

245866	Heated hose kit (Includes diaphragm pump, fittings, tubes, mounting bracket and reservoir tank. Actual hose assembly and heater must be ordered separately.) Ref. manual 309525.	248118	Dual hose bundles, 1/2 in & 1/2 in (12.7 mm) 7250 psi (345 bar, 34.5 MPa)
245841	1/4 in (6.3 mm), 7250 psi (500 bar, 50 MPa)	248119	Dual hose bundles, 3/8 in & 3/8 in (9.5 mm) 7250 psi (345 bar, 34.5 MPa)
245843	3/8 in (9.5 mm), 7250 psi (500 bar, 50 MPa)	248120	Dual hose bundles, 1/2 in & 3/8 in (12.7 mm x 9.5 mm) 7250 psi (345 bar, 34.5 MPa)
245845	1/2 in (12.7 mm), 7250 psi (500 bar, 50 MPa)	248121	Dual hose bundles, 3/8 in & 1/4 in (9.5 mm x 6.3 mm) 7250 psi (345 bar, 34.5 MPa)
		246078	Scuff Guard, 50 ft (15.2 m) braided polyester mesh. Blue 2.5 in nominal diameter
		246456	Scuff Guard, 50 ft (15.2 m) polyethylene (6 mil) clear tubing 5 in diameter

## Xtreme-Duty™ 7250 psi High-Pressure Hoses

H72503	3 ft (0.9 m), 1/4 in (6.3 mm), 7250 psi (500 bar, 50 MPa), 1/4 in female NPSM	H73810	10 ft (3.0 m), 3/8 in (9.5 mm), 7250 psi (500 bar, 50 MPa), 3/8 in female NPSM
H72506	6 ft (1.8 m), 1/4 in (6.3 mm), 7250 psi (500 bar, 50 MPa), 1/4 in female NPSM	H73825	25 ft (7.6 m), 3/8 in (9.5 mm), 7250 psi (500 bar, 50 MPa), 3/8 in female NPSM
H72510	10 ft (3.0 m), 1/4 in (6.3 mm), 7250 psi (500 bar, 50 MPa), 1/4 in female NPSM	H73850	50 ft (15.2 m), 3/8 in (9.5 mm), 7250 psi (500 bar, 50 MPa), 3/8 in female NPSM
H72525	25 ft (7.6 m), 1/4 in (6.3 mm), 7250 psi (500 bar, 50 MPa), 1/4 in female NPSM	H7381X	100 ft (30.5 m), 3/8 in (9.5 mm), 7250 psi (500 bar, 50 MPa), 3/8 in female NPSM
H72550	50 ft (15.2 m), 1/4 in (6.3 mm), 7250 psi (500 bar, 50 MPa), 1/4 in female NPSM	H75010	10 ft (3.0 m), 1/2 in (12.7 mm), 7250 psi (500 bar, 50 MPa), 1/2 in female NPSM
H7251X	100 ft (30.5 m), 1/4 in (6.3 mm), 7250 psi (500 bar, 50 MPa), 1/4 in female NPSM	H75025	25 ft (7.6 m), 1/2 in (12.7 mm), 7250 psi (500 bar, 50 MPa), 1/2 in female NPSM
H73803	3 ft (0.9 m), 3/8 in (9.5 mm), 7250 psi (500 bar, 50 MPa), 3/8 in female NPSM	H75050	50 ft (15.2 m), 1/2 in (12.7 mm), 7250 psi (500 bar, 50 MPa), 1/2 in female NPSM
H73806	6 ft (1.8 m), 3/8 in (9.5 mm), 7250 psi (500 bar, 50 MPa), 3/8 in female NPSM	H7501X	100 ft (30.5 m), 1/2 in (12.7 mm), 7250 psi (500 bar, 50 MPa), 1/2 in female NPSM

## Supply Processing Equipment

### Supply Pump Kits (see manual 312769 for more selections)

256275	T2 2:1 drum pump with 3/4 x 10 ft (3.0 m) fluid hose, air regulator kit, air hose, fluid strainer, ball valve and pump union
256276	Monark® 5:1, drum pump with 3/4 x 10 ft (3.0 m) fluid hose, air regulator kit, air hose, fluid strainer, ball valve and pump union

### Agitator Kit

248824 Twistork® with air connection to work with feed pump kits (reference manual 310863)

### Solvent Flush Kit

262393 Merkur 45:1. Mounts to XP cart. Includes air controls, pail siphon, prime valve and 3 ft (0.9 m) hose to mix manifold (reference manual 310863)

## Temperature Controlling Equipment

262450 Heater mounting kit. Includes hose and fittings to mount one heater on the XP cart. Two heaters can be mounted on an XP cart.

### Viscon Fluid Heaters

Approved for explosive atmospheres

245848	Hazardous location, 120 VAC single phase, 2300 watts, 19.2 amps
245862	Hazardous location, 200 VAC single phase, 4000 watts, 20 amps
245863	Hazardous location, 240 VAC single phase, 4000 watts, 16.7 amps
246254	Hazardous location, 380 VAC single phase, 4000 watts, 10.5 amps
245864	Hazardous location, 480 VAC single phase, 4000 watts, 8.3 amps

Not approved for explosive atmospheres

245867	Non-hazardous location, 120 VAC single phase, 2300 watts, 19.2 amps
245868	Non-hazardous location, 200 VAC single phase, 4000 watts, 20 amps
245869	Non-hazardous location, 240 VAC single phase, 4000 watts, 16.7 amps
246276	Non-hazardous location, 380 VAC single phase, 4000 watts, 10.5 amps
245870	Non-hazardous location, 480 VAC single phase, 4000 watts, 8.3 amps

### Band Heaters - Not approved for explosive atmospheres

15F028 Heater, drum, 1000 watts, 230V

## Accessories

### Remote Mix Manifold

258989	Mix manifold, no carriage
262522	Carriage only - no mix manifold

### Static Mixing, 7250 psi (500 bar, 50 MPa)

248927	25 pack, disposable, 1/2 in (12 mm), 12 element
262478	Static mix housing, 1/2 in x 5 in (12 mm x 127 mm)
511352	Static mixer, SST, 3/8 in x 9.5 in (9.5 mm x 241 mm)

### Spray Guns, 7250 psi (500 bar, 50 MPa)

XTR700	XTR-7, round handle, four-finger trigger, no tip
XTR701	XTR-7, round handle, four-finger trigger, flat tip
XTR702	XTR-7, oval insulated handle, four-finger trigger, HD RAC tip
XTR703	XTR-7, oval insulated handle, two-finger trigger, HD RAC tip
XTR704	XTR-7, round handle, four-finger trigger, HD RAC tip
XTR705	XTR-7, round handle, two-finger trigger, HD RAC tip

### Hoppers

24F376	Blue for resin side (7-gallon hopper kits with bracket and hardware to mount on an XP cart)
24F377	Green for hardener side (7-gallon hopper kits with bracket and hardware to mount on an XP cart)
262454	Desiccant dryer kit. Bulkhead fitting and 2-pack of cartridges for one hopper
119974	Replacement 2-pack of desiccant cartridges

### XP Pressure Monitor Kit (see manual 3A1331)

262940	Pressure monitor kit, wall powered with light tower
262942	Pressure monitor kit, air powered with light tower

### Miscellaneous

234026	Gun splitter manifold. Allows two spray guns to be individually selected and/or flushed
NXT606	DataTrak™ conversion kit. Can be added to the NXT 6500 Air Motor for totalizer and flow rate data, and to provide runaway protection. Approved for hazardous atmospheres
24F375	Ratio sampling value kit; includes 1 valve (see manual 3A0421 for details)



## ABOUT GRACO

### PROVEN QUALITY. LEADING TECHNOLOGY.

Founded in 1926, Graco is a world leader in fluid handling systems and components. Graco products move, measure, control, dispense and apply a wide range of fluids and viscous materials used in vehicle lubrication, commercial and industrial settings.

The company's success is based on its unwavering commitment to technical excellence, world-class manufacturing and unparalleled customer service. Working closely with qualified distributors, Graco offers systems, products and technology that set the quality standard in a wide range of fluid handling solutions. Graco provides equipment for spray finishing, protective coating, paint circulation, lubrication, and dispensing sealants and adhesives, along with power application equipment for the contractor industry. Graco's ongoing investment in fluid management and control will continue to provide innovative solutions to a diverse global market.

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