



# Air-Operated Mastic Regulators

- **Control pressures at multiple applicators from a single pump**
- **Moderate flow surges due to line valve opening and pump changeovers**
- **Easy-to-set precise adjustment**
- **Consistent, stable pressure setting**
- **Low cost fluid metering**

**Accurate  
pressure control  
for sealant and  
adhesive  
materials**

Graco has developed a variety of Mastic Regulator metering packages that provide accurate material pressure for a large variety of applications. Mastic regulators are used where one pump supplies multiple guns to dispense mastics and other semi-solid materials. Installed ahead of each dispense gun, they control pressure so that the guns furthest from the pump have sufficient pressure for effective operation, and those close to the pump are not over-pressured. They also moderate flow surges when line valves are opened or when pump changeover occurs.

Material can be dispensed with manual guns or automatic applicators using robotic automation equipment. Graco mastic regulator packages provide high speed, fixed flow rate dispensing with the lowest cost metering available to the industry. Metering packages are combined with supply pumps to extrude, brush, stream, shower or spray sealant and adhesive materials.

## Typical Fluids Handled

- PVC sealants
- Epoxy adhesives
- Body shop sealants
- Ambient materials
- Heated materials
- Temperature conditioned materials

## Typical Applications

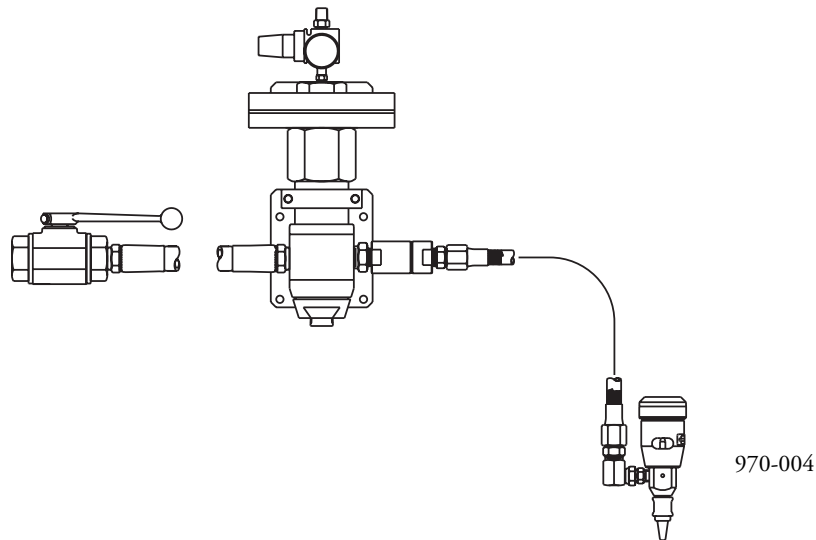
- Automotive sealant dispensing
- Automotive structural bonding
- Industrial product assembly



961-635

SEALANT ADHESIVE EQUIPMENT

## Ordering Information for Automatic Mastic Regulator Packages



### *For Automatic Extrude Applications*

#### **970-003 Temperature Conditioned**

Includes temperature conditioner with supply/dispense fluid hoses, mastic regulator and temperature conditioned automatic snuff back dispense valve with nozzle.

#### **970-004 Ambient**

Includes supply/dispense fluid hoses, mastic regulator and automatic snuff back dispense valve with nozzle.

#### **970-005 Heated**

Includes 4 zone control panel, heated supply/dispense fluid hoses, heated mastic regulator and heated automatic snuff back dispense valve with nozzle.

### *For Automatic Extrude/Stream Applications*

#### **970-036 Temperature Conditioned**

Includes temperature conditioner with supply/dispense fluid hoses, mastic regulator and temperature conditioned automatic snuff back dispense valve with extrusion nozzle and streaming tips.

#### **970-037 Ambient**

Includes supply/dispense fluid hoses, mastic regulator and automatic snuff back dispense valve with extrusion nozzle and streaming tips.

#### **970-038 Heated**

Includes 4 zone control panel, heated supply/dispense fluid hoses, heated mastic regulator and heated automatic snuff back dispense valve with extrusion nozzle and streaming tips.

### *For Automatic Stream/Shower Applications*

#### **970-107 Temperature Conditioned**

Includes dual filter bank, temperature conditioner with fluid hoses, mastic regulator, AA300-S stream dispense valve and streaming tip.

#### **970-108 Ambient**

Includes dual filter bank, fluid hoses, mastic regulator, AA3000-S stream dispense valve and streaming tip.

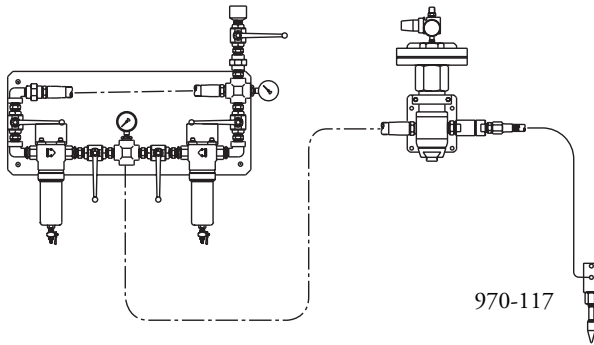
#### **970-109 Heated**

Includes dual filter bank, 4 zone control panel, heated fluid hoses, heated mastic regulator, AA3000-S dispense valve and streaming tip.

#### **970-119 Shower Dispense Kit**

Includes 6 hole shower nozzle, I/P valve with bracket, cable and air hose for shaping air.

## Ordering Information for Automatic Mastic Regulator Packages



### For Automatic Filtered Extrude Applications

#### 970-116 Temperature Conditioned

Includes dual filter bank, temperature conditioner with fluid hoses, mastic regulator, automatic dispense valve and 4 in. (10 cm) compliant nozzle.

#### 970-117 Ambient

Includes dual filter bank, fluid hoses, mastic regulator, automatic dispense valve and 4 in. (10 cm) compliant nozzle.

#### 970-118 Heated

Includes dual filter bank, 4 zone control panel, heated fluid hoses, heated mastic regulator, automatic dispense valve and 4 in. (10 cm) compliant nozzle.

### For Automatic Spray Applications

#### 970-133 Temperature Controlled

Includes dual filter bank, temperature conditioner with fluid hoses, mastic regulator, automatic airless dispense valve and fan spray tip.

#### 970-134 Ambient

Includes dual filter bank, fluid hoses, mastic regulator, automatic airless dispense valve and fan spray tip.

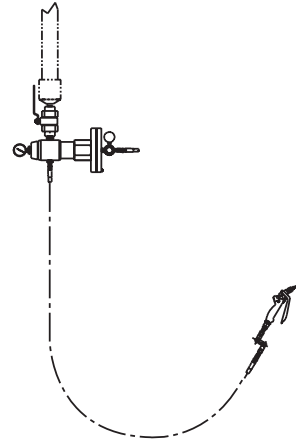
#### 970-135 Heated

Includes dual filter bank, 4 zone control panel, heated fluid hoses, heated mastic regulator, automatic airless dispense valve and fan spray tip.

#### 970-139 Ambient (Stainless Steel)

Includes dual filter bank, fluid hoses, 3/4 in. (19 mm) SST mastic regulator, automatic airless dispense valve and fan spray tip. For waterborne materials.

## Ordering Information for Manual Mastic Regulator Packages



### For Manual Extrude Applications

#### 969-201 In-line Ball Needle Manual Extrude Kit

Includes ball valve, 3/8 in. mastic regulator, 15 ft. (4.6 m) dispense hose, Z-swivel and Ultra-Lite in-line flow gun.

#### 969-202 In-line Tapered Needle Manual Extrude Kit

Includes ball valve, 3/8 in. mastic regulator, 15 ft. (4.6 m) dispense hose, Z-swivel and Ultra-Lite in-line flow gun.

#### 970-167 Pistol Grip Manual Extrude Kit

Includes ball valve, 3/8 in. mastic regulator, 15 ft. (4.6 m) dispense hose, Z-swivel and Ultra-Lite 4000 SD pistol grip flow gun.

### For Manual Spray Applications

#### 970-124 Pistol Grip Manual Airless Spray Kit

Includes ball valve, 3/8 in. mastic regulator, 15 ft. (4.6 m) dispense hose, straight swivel and Silver Plus pistol grip airless spray gun with fan spray tip.

#### 970-145 Pistol Grip Manual Air-Assisted Airless Spray Kit

Includes ball valve, 3/8 in. mastic regulator, 15 ft. (4.6 m) dispense hose, straight swivel and AA Plus pistol grip spray gun with fan spray tip (242-525).

#### 970-193 Pistol Grip Manual Air-Assisted Airless Spray Kit

Includes ball valve, 3/8 in. mastic regulator, 15 ft. (4.6 m) dispense hose, straight swivel and AA Plus pistol grip spray gun with fan spray tip (242-317).

# Technical Specifications for 3/4 Mastic Regulator

## Regulated pressure range

**Air-Operated** . . . 500-4000 psi (3.4-27.2 MPa, 34-272 bar)

**Maximum inlet pressure** . . . . . 5000 psi (34 MPa, 340 bar)

**Inlet size** . . . . . 3/4 npt

**Outlet size** . . . . . 3/4 npt

## Weight

**Air-Operated** . . . . . 17.75 lb (8 kg)

## Instruction manuals

**3/4 npt** . . . . . 307-517

**3/8 npt** . . . . . 308-647

*This chart shows the approximate air pressure needed to regulate the air operated regulator to a given fluid outlet pressure.*

Air Pressure			Regulated Fluid Outlet Pressure		
psi	bar	kPa	psi	bar	MPa
10	0.7	70	500	35	3.5
15	1.0	100	800	55	5.5
20	1.4	140	1100	76	7.6
25	1.7	170	1300	90	9.0
30	2.1	210	1600	110	11.0
40	2.8	280	2100	145	14.5
50	3.5	350	2700	186	18.6
60	4.2	420	3200	221	22.1
70	4.9	490	3800	262	26.2
80	5.6	560	4300	296	29.6

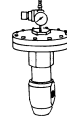
# Accessories

## 113-654 Fluid Pressure Gauge

Maximum pressure: 5000 psi (34 MPa, 340 bar). 1/4 npt(m). Requires bushing (100-615), must be ordered separately.

## 961-635 Ambient Mastic Regulator

3/4 npt(f) fluid ports. Includes air pilot regulator and pilot regulator gauge.



## C58-945 Temperature Conditioned Mastic Regulator

3/4 npt(f) fluid ports, (8) 1/8 npt(f) water ports for (4) water paths, and mounting bracket.

## 918-447 Heated Mastic Regulator

3/4 npt(f) fluid ports, 120 VAC heater, RTD sensor and connector box.

## C58-318 SST Mastic Regulator

3/4 npt(f) fluid ports.

## C59-613 Mounting Bracket for 3/4 npt Mastic Regulator

## 238-894 3/8 SST Mastic Regulator

3/8 npt(f) fluid ports with 5000 fluid pressure gauge. See form 305-793 for technical specs and accessories.