

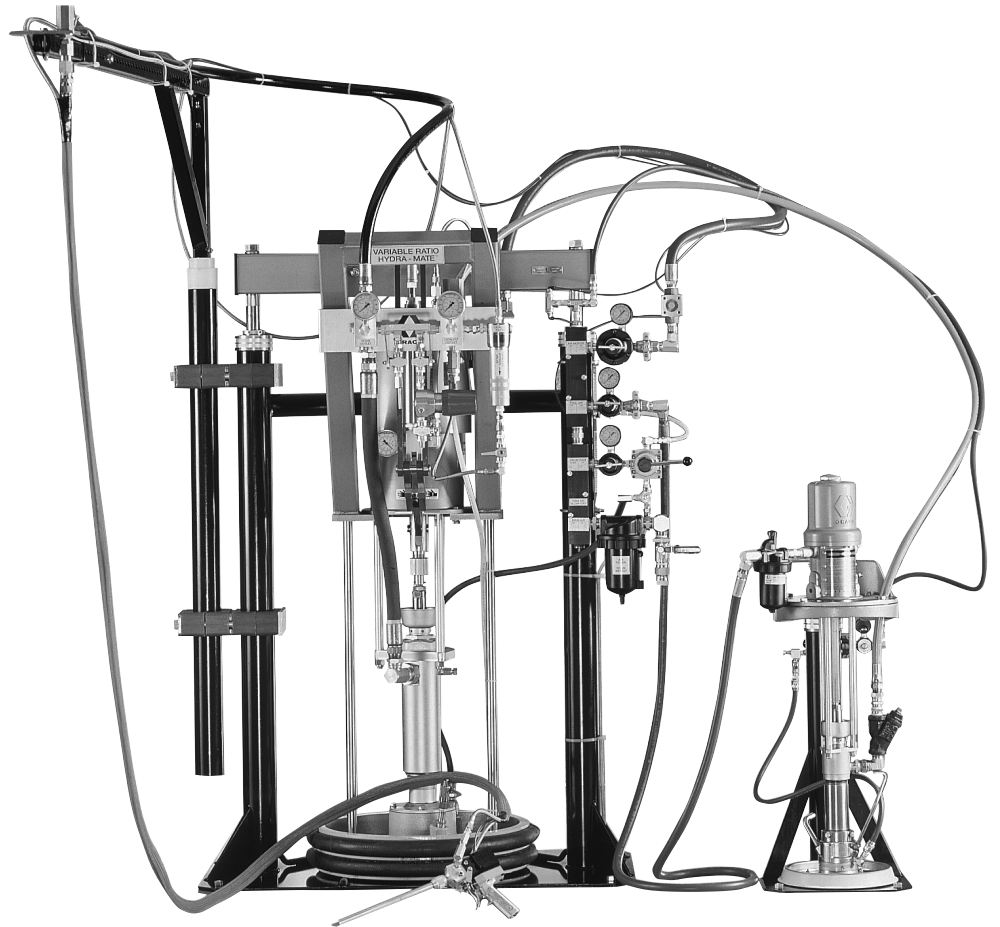


First choice when
quality counts.™

Hydra-Mate™ Package for 2-Part Acrylic Adhesives

- Accurate proportioning
- Reliability
- Continuous uniform application
- Durable / Severe-Duty construction
- Reduced material waste
- Complete package

**Dispense and
apply small to
large beads
of acrylic
adhesives**



SEALANT ADHESIVE EQUIPMENT

Graco has designed a plural component package based on the popular Hydra-Mate proportioning unit to handle some revolutionary new acrylic adhesive materials. Major advances in the formulation and bonding capability of adhesives based on modified acrylic technology have been achieved. These changes have been brought about by the need to bond structural thermoplastics for such applications as car bumpers in automotive assembly, fiber-reinforced plastics in truck assembly, structural bonding of 2-piece composite radar beam assemblies for marine pleasure craft, and a host of product assembly applications.

The Hydra-Mate System includes our popular Bulldog-powered proportioning pump mounted on a dual post pneumatic ram. The resin pump is fitted with a 55 gallon (210 liter) ram plate which allows the viscous base fluid to be pumped directly from the barrel. A metering feed pump is used to process materials with a ratio range of 8:1 to 16:1 by volume. The curative supply pump is made of stainless steel with a 5 gallon (20 liter) inductor plate and single post ram. The dispense valve requires no flushing and uses a disposable mixer. The hand held, air-operated valve has Severe Duty needles and seats with snuff-back action.

Typical Fluids Handled

- Acrylics

Typical Applications

- Auto assembly
- Product assembly
- Truck and bus assembly
- Marine pleasure craft

Technical Specifications

Shipping weight 1120 lbs. (509 kg)

Dimensions (with table) . 44 in. W x 55 in. D x 73 in. H
(1118 mm W x 1397 mm D x 1854 mm H)

Mix ratio 8:1 to 16:1 by volume

Fluid to air ratio 25:1

Air consumption 25 cu ft./gal

Flow rate 3-12 lbs/min typical

Wetted parts

Base pump hard chrome over SST

Packings Teflon®/UHMWPE

Ram plate cast iron

Curative pump SST

Packings Teflon

Ram plate SST

Metering pump hard chrome over SST

Dispense valve aluminum and SST

Manifolds zinc-plated steel

Teflon® is a registered trademark of Du Pont

Ordering Information

988-228 Hydra-Mate for 2-Part Acrylic Adhesives

Includes Hydra-Mate with Bulldog powered proportioning pump, Monark slave pump and 2K Ultra-Lite gun. Valid for ratios from 8:1 to 16:1 by volume.

System Components

- Hydra-Mate Bulldog-powered proportioning pump: 55 gallon (210 liter)
- Dual post pneumatic ram for resin pump
- Curative supply pump – Monark 5:1 5 gallon (20 liter)
- SST inductor plate for curative feed pump
- 2K Ultra-Lite dispense valve
- Pilot valve to actuate proportioner motor from dispense valve
- Swingable boom, 6 ft. (1.8 m), with 12 ft. (3.6 m) drop hoses
- 50 disposable mixers

How the System Works

The resin pump is the positive displacement meter while the air motor supplies the force and motion required to drive the system. A connecting rod is used to couple the resin pump and motor directly. The air motor force and motion is transmitted through an orange slave linkage for synchronous motion of the resin and curative pumps.

The resin and the cure displace different volumes for the same stroke. By adjustment of the cure inlet manifold at different points on the slave linkage, the stroke length of the cure pump can be changed.

Fluid is pumped from outlet blocks, through hoses, to a disposable mixer type valve which requires no flushing.