

GX-16

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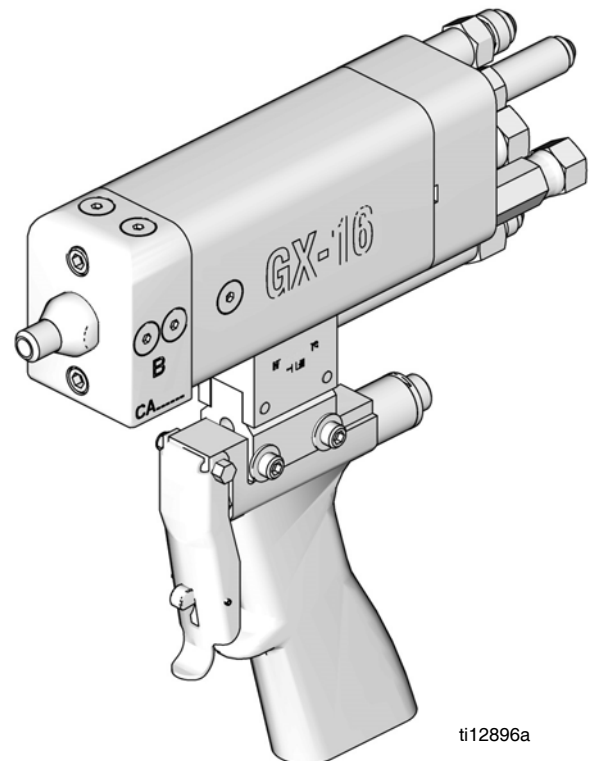
***For dispensing polyol and isocyanate materials only. For professional use only.
For indoor use only. Not approved for use in European explosive atmosphere
requirements.***

*3000 psi (21 MPa, 207 bar) Maximum Fluid Working Pressure
2500 psi (17 MPa, 172 bar) Maximum Hydraulic Working Pressure
180°F (82°C) Maximum Fluid Temperature*



Important Safety Instructions

Read all warnings and instructions in this manual. Save these instructions.



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Model 257496 shown

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Models

Part No.	Description
257492†	GX-16 Pour Gun, 24:1, Pour Handle, Right Side Chemical Tubes, Star-Shaped Trigger Switch Connector
257493†	GX-16 Pour Gun, 24:1, Pour Handle, Left Side Chemical Tubes, Star-Shaped Trigger Switch Connector
257494†	GX-16 Pour Gun, 24:1, Pour Handle, Right Side Chemical Tubes, Circular Trigger Switch Connector
257495†	GX-16 Pour Gun, 24:1, Pour Handle, Left Side Chemical Tubes, Circular Trigger Switch Connector
257496†	GX-16 Pour Gun, 24:1, Isolated Pistol Handle
257497†	GX-16 Pour Gun, 24:1, No Handle
257498†	GX-16 Pour Gun, No Handle, No Orifice
257499†	GX-16 Pour Gun, Reverse Block, No Handle, No Orifice
257502†	GX-16 Pour Gun, 1:1, No Handle
257503†	GX-16 Pour Gun, 1:1, No Handle, No Fittings
257504†	GX-16 Pour Gun, 1:1, No Handle, 3 ft Hoses
257505†	GX-16 Pour Gun, 1:1, Pistol Handle, No Orifice, Proximity Switch
257506†	GX-16 Pour Gun, 1:1, Isolated Pistol Handle, Proximity Switch
257507†	GX-16 Pour Gun, 1:1, Isolated Pistol Handle, No Orifice, Proximity Switch
24E876◆†	GX-16 Pour Gun, HFR™, NVH, Straight, Basic
24E877◆†	GX-16 Pour Gun, HFR, NVH, Right, 24:1
24E878◆†	GX-16 Pour Gun, HFR, NVH, Right, Basic
24J187◆†	GX-16 Pour Gun, HFR, NVH, Straight, 24:1
24K233◆†	GX-16 Pour Gun, HFR, NVH, Left, 24:1
24K234◆†	GX-16 Pour Gun, HFR, NVH, Left, Basic
25E973❖	GX-16 Pour Gun, No Handle, 1:1, PEEK Nozzle
25E974❖	GX-16 Pour Gun, No Handle, 24:1, PEEK Nozzle
25E975❖	GX-16 Pour Gun, LED Handle, 1:1, Magnetic Nozzle
26C466❖	GX-16 Pour Gun, LED Handle, 24:1, Magnetic Nozzle
25R248❖	GX-16 Pour Gun, LED Handle, 24:1, Plain Nozzle
25P155❖	GX-16 Pour Gun, No Handle, 2:1, Plain Nozzle
25P154❖	GX-16 Pour Gun, LED Handle, 2:1, Plain Nozzle
25R249❖	GX-16 Pour Gun, LED Handle, 1:1, Plain Nozzle








◆ Models used specifically for HFR machines.






❖ Models used specifically for HFR-NVH machines.

† Models are CE approved.

Warnings

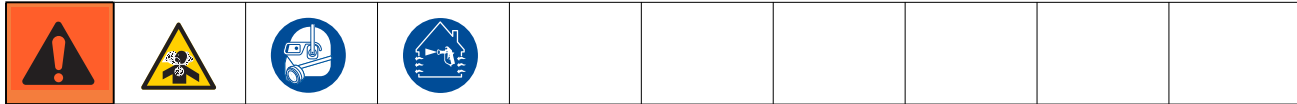
The following warnings are for the setup, use, grounding, maintenance, and repair of this equipment. The exclamation point symbol alerts you to a general warning and the hazard symbol refers to procedure-specific risk. Refer back to these warnings. Additional, product-specific warnings may be found throughout the body of this manual where applicable.

 WARNING	
 	<p>TOXIC FLUID OR FUMES HAZARD</p> <p>Toxic fluids or fumes can cause serious injury or death if splashed in the eyes or on skin, inhaled or swallowed.</p> <ul style="list-style-type: none"> • Read Safety Data Sheet (SDS) for handling instructions and to know the specific hazards of the fluids you are using, including the effects of long-term exposure. • When spraying, servicing equipment, or when in the work area, always keep work area well ventilated and always wear appropriate personal protective equipment. See Personal Protective Equipment warnings in this manual. • Store hazardous fluid in approved containers, and dispose of it according to applicable guidelines.
	<p>PERSONAL PROTECTIVE EQUIPMENT</p> <p>Always wear appropriate personal protective equipment and cover all skin when spraying, servicing equipment, or when in the work area. Protective equipment helps prevent serious injury, including long-term exposure; inhalation of toxic fumes, mists or vapors; allergic reaction; burns; eye injury and hearing loss. This protective equipment includes but is not limited to:</p> <ul style="list-style-type: none"> • A properly fitting respirator, which may include a supplied-air respirator, chemically impermeable gloves, protective clothing and foot coverings as recommended by the fluid manufacturer and local regulatory authority. • Protective eyewear and hearing protection.
  	<p>SKIN INJECTION HAZARD</p> <p>High-pressure fluid from dispensing device, hose leaks, or ruptured components will pierce skin. This may look like just a cut, but it is a serious injury that can result in amputation. Get immediate surgical treatment.</p> <ul style="list-style-type: none"> • Engage trigger lock when not dispensing. • Do not point dispensing device at anyone or at any part of the body. • Do not put your hand over the fluid outlet. • Do not stop or deflect leaks with your hand, body, glove, or rag. • Follow the Pressure Relief Procedure when you stop dispensing and before cleaning, checking, or servicing equipment. • Tighten all fluid connections before operating the equipment. • Check hoses and couplings daily. Replace worn or damaged parts immediately

 WARNING	
	<p>EQUIPMENT MISUSE HAZARD Misuse can cause death or serious injury.</p> <ul style="list-style-type: none"> • Do not operate the unit when fatigued or under the influence of drugs or alcohol. • Do not exceed the maximum working pressure or temperature rating of the lowest rated system component. See Technical Data in all equipment manuals. • Use fluids and solvents that are compatible with equipment wetted parts. See Technical Data in all equipment manuals. Read fluid and solvent manufacturer's warnings. For complete information about your material, request MSDS from distributor or retailer. • Do not leave the work area while equipment is energized or under pressure. Turn off all equipment and follow the Pressure Relief Procedure when equipment is not in use. • Check equipment daily. Repair or replace worn or damaged parts immediately with genuine manufacturer's replacement parts only. • Do not alter or modify equipment. • Use equipment only for its intended purpose. Call your distributor for information. • Route hoses and cables away from traffic areas, sharp edges, moving parts, and hot surfaces. • Do not kink or over bend hoses or use hoses to pull equipment. • Keep children and animals away from work area. • Comply with all applicable safety regulations.
	<p>FIRE AND EXPLOSION HAZARD Flammable fumes, such as solvent and paint fumes, in work area can ignite or explode. To help prevent fire and explosion:</p> <ul style="list-style-type: none"> • Use equipment only in well ventilated area. • Eliminate all ignition sources; such as pilot lights, cigarettes, portable electric lamps, and plastic drop cloths (potential static arc). • Keep work area free of debris, including solvent, rags and gasoline. • Do not plug or unplug power cords, or turn power or light switches on or off when flammable fumes are present. • Ground all equipment in the work area. See Grounding instructions. • Use only grounded hoses. • Hold gun firmly to side of grounded pail when triggering into pail. • If there is static sparking or you feel a shock, stop operation immediately. Do not use equipment until you identify and correct the problem. • Keep a working fire extinguisher in the work area.
	<p>BURN HAZARD Equipment surfaces and fluid that's heated can become very hot during operation. To avoid severe burns:</p> <ul style="list-style-type: none"> • Do not touch hot fluid or equipment.
	<p>PRESSURIZED ALUMINUM PARTS HAZARD Use of fluids that are incompatible with aluminum in pressurized equipment can cause serious chemical reaction and equipment rupture. Failure to follow this warning can result in death, serious injury, or property damage.</p> <ul style="list-style-type: none"> • Do not use 1,1,1-trichloroethane, methylene chloride, other halogenated hydrocarbon solvents or fluids containing such solvents. • Many other fluids may contain chemicals that can react with aluminum. Contact your material supplier for compatibility.

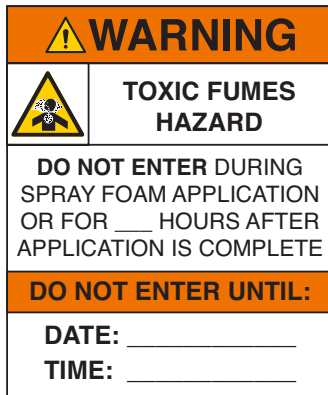
Important Two-Component Material Information

Isocyanate Conditions



Spraying or dispensing fluids that contain isocyanates creates potentially harmful mists, vapors, and atomized particulates.

- Read and understand the fluid manufacturer’s warnings and Safety Data Sheet (SDS) to know specific hazards and precautions related to isocyanates.
- Use of isocyanates involves potentially hazardous procedures. Do not spray with this equipment unless you are trained, qualified, and have read and understood the information in this manual and in the fluid manufacturer’s application instructions and SDS.
- Use of incorrectly maintained or mis-adjusted equipment may result in improperly cured material, which could cause off gassing and offensive odors. Equipment must be carefully maintained and adjusted according to instructions in the manual.
- To prevent inhalation of isocyanate mists, vapors and atomized particulates, everyone in the work area must wear appropriate respiratory protection. Always wear a properly fitting respirator, which may include a supplied-air respirator. Ventilate the work area according to instructions in the fluid manufacturer’s SDS.
- Avoid all skin contact with isocyanates. Everyone in the work area must wear chemically impermeable gloves, protective clothing and foot coverings as recommended by the fluid manufacturer and local regulatory authority. Follow all fluid manufacturer recommendations, including those regarding handling of contaminated clothing. After spraying, wash hands and face before eating or drinking.
- Hazard from exposure to isocyanates continues after spraying. Anyone without appropriate personal protective equipment must stay out of the work area during application and after application for the time period specified by the fluid manufacturer. Generally this time period is at least 24 hours.
- Warn others who may enter work area of hazard from exposure to isocyanates. Follow the recommendations of the fluid manufacturer and local regulatory authority. Posting a placard such as the following outside the work area is recommended:



For all applications except spray foam



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- Avoid all skin contact with isocyanates. Everyone in the work area must wear chemically impermeable gloves, protective clothing and foot coverings as recommended by the fluid manufacturer and local regulatory authority. Follow all fluid manufacturer recommendations, including those regarding handling of contaminated clothing. After spraying, wash hands and face before eating or drinking.

Material Self-ignition



Some materials may become self-igniting if applied too thick. Read material manufacturer’s warnings and Safety Data Sheet (SDS).

Keep Components A and B Separate



Cross-contamination can result in cured material in fluid lines which could cause serious injury or damage equipment. To prevent cross-contamination:

- **Never** interchange component A and component B wetted parts.
- Never use solvent on one side if it has been contaminated from the other side.

Moisture Sensitivity of Isocyanates

Exposure to moisture (such as humidity) will cause ISO to partially cure, forming small, hard, abrasive crystal that become suspended in the fluid. Eventually a film will form on the surface and the ISO will begin to gel, increasing in viscosity.

NOTICE

Partially cured ISO will reduce performance and the life of all wetted parts.

- Always use a sealed container with a desiccant dryer in the vent, or a nitrogen atmosphere. **Never** store ISO in an open container.
- Keep the ISO pump wet cup or reservoir (if installed) filled with appropriate lubricant. The lubricant creates a barrier between the ISO and the atmosphere.
- Use only moisture-proof hoses compatible with ISO.
- Never use reclaimed solvents, which may contain moisture. Always keep solvent containers closed when not in use.
- Always lubricate threaded parts with an appropriate lubricant when reassembling.

NOTE: The amount of film formation and rate of crystallization varies depending on the blend of ISO, the humidity, and the temperature.

Foam Resins with 245 fa Blowing Agents

Some foam blowing agents will froth at temperatures above 90°F (33°C) when not under pressure, especially if agitated. To reduce frothing, minimize preheating in a circulation system.

Changing Materials

NOTICE

Changing the material types used in your equipment requires special attention to avoid equipment damage and downtime.

- When changing materials, flush the equipment multiple times to ensure it is thoroughly clean.
- Always clean the fluid inlet strainers after flushing.
- Check with your material manufacturer for chemical compatibility.
- When changing between epoxies and urethanes or polyureas, disassemble and clean all fluid components and change hoses. Epoxies often have amines on the B (hardener) side. Polyureas often have amines on the B (resin) side.

Grounding



The equipment must be grounded. Grounding reduces the risk of static and electric shock by providing an escape wire for the electrical current due to static build up or in the event of a short circuit.

Pump: use ground wire and clamp (supplied). Connect ground clamp to a true earth ground.

Gun: ground through connection to a properly grounded fluid hose and pump.

Fluid supply container: follow local code.

Solvent pails used when flushing: follow local code. Use only conductive metal pails, placed on a grounded surface. Do not place the pail on a non-conductive surface, such as paper or cardboard, which interrupts grounding continuity.

Maintain grounding continuity: When flushing or relieving pressure, hold metal part of the gun firmly to the side of a grounded metal pail, then trigger the gun.

Trigger Lock

Verify that the trigger lock is engaged whenever you stop pouring to avoid accidental triggering. Check daily for chemical build-up on trigger, trigger lock, and trigger lock spring that can prevent proper trigger lock function.



Engage

To engage the trigger lock, release the trigger. The trigger lock is spring loaded and automatically engages when the gun trigger is released.

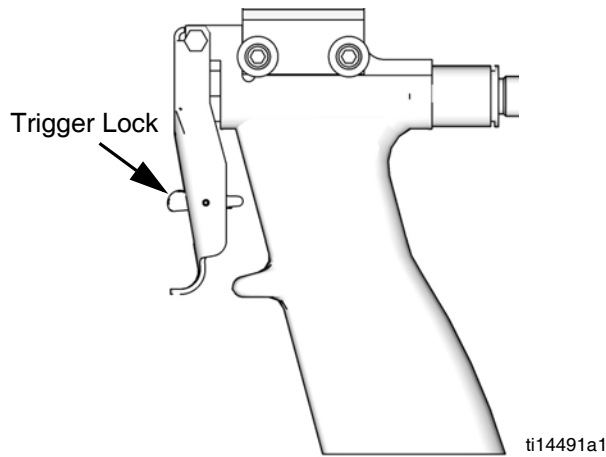


FIG. 1: Models 257509, 257510

To engage the trigger lock, press the trigger lock down.

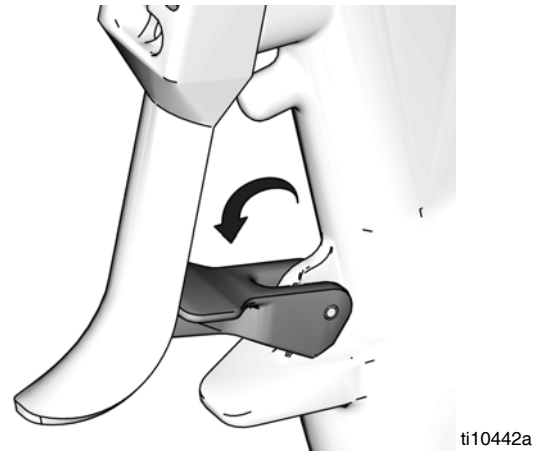


FIG. 2: Kit 24K223

Disengage

To disengage the trigger lock, press trigger lock down. See the following figure.

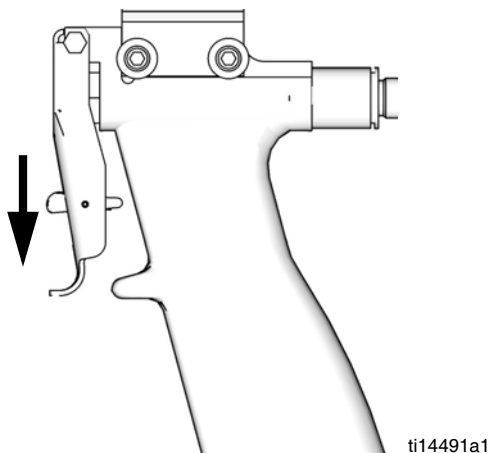


FIG. 3: Models 257509, 257510

To disengage the trigger lock, press the trigger lock up.

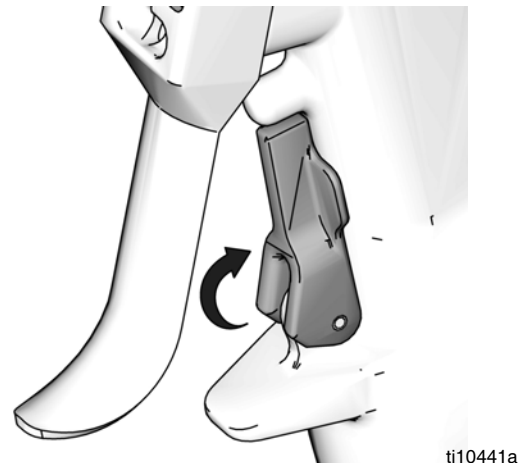


FIG. 4: Kit 24K223

Setup

Gun Connections

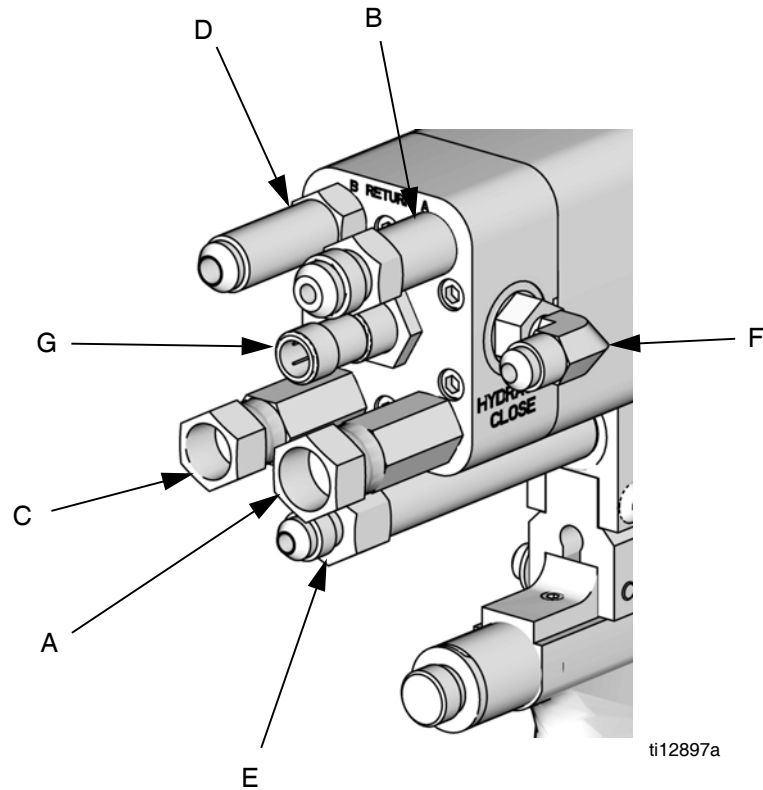


FIG. 5

Ref	Description	Tape Color †	Fitting Size	HFR Systems Only
A	A Pressure Line	Red	7/16 ORG x #6 JIC Female	7/16 ORG x #5 JIC Female
B	A Return Line	Red and White	7/16 ORG x #6 JIC Male	7/16 ORG x #5 JIC Male
C	B Pressure Line	Blue	7/16 ORG x #5 JIC Female	7/16 ORG x #6 JIC Female
D	B Return Line	Blue and White	7/16 ORG x #5 JIC Male	7/16 ORG x #6 JIC Male
E	Hydraulic Open Line	Green and White	7/16 ORG x #4 JIC Male Extension	7/16 ORG x #4 JIC Male Extension
F	Hydraulic Close Line	Green	7/16 ORG x #4 JIC Male Elbow	7/16 ORG x #4 JIC Male Elbow
G	Proximity Switch or Plug (depending on model)	NA	NA	NA

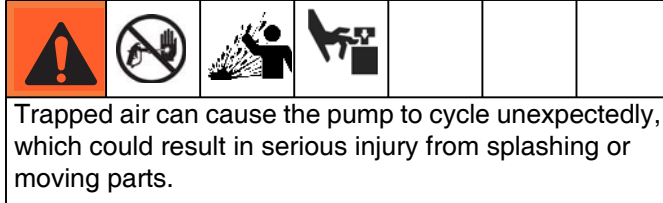
† Only hoses are taped, fittings are not taped.

Fluid Line

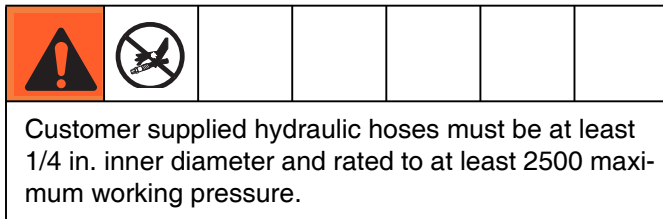
Fluid Filter: Use a 25 micron stainless steel element to filter particles from the fluid as it leaves the pump.

Fluid Drain Valve: Required in your system, to relieve fluid pressure in the hose and gun.

Gun Setup



1. Verify hydraulic power pack is off.
2. Install hydraulic hoses to power pack.



3. Use a 7/16 in. JIC male-male adapter at the gun end to connect hoses together. This creates a hydraulic fluid circulation loop.

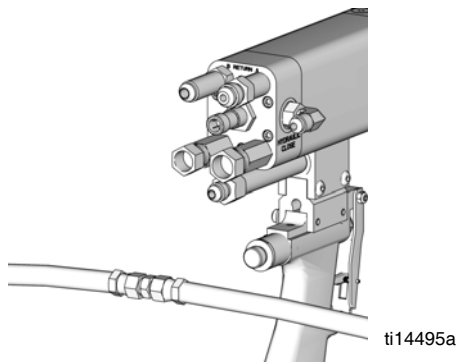


FIG. 6

4. Turn on the power pack. Circulate oil for 10 minutes to purge air from hydraulic hoses.

NOTE: Pressure should not increase while air is purged from hoses.

5. Turn off power pack. Verify no pressure exists in hoses.
6. Remove the 7/16 in. JIC male-male adapter connecting the hydraulic hoses.
7. Attach hydraulic hoses to the gun.

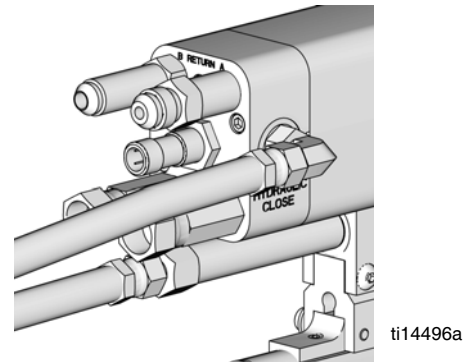


FIG. 7

8. Set power pack to manual mode.
9. Attach trigger switch cable and proximity switch cable (if applicable) to gun and power pack.

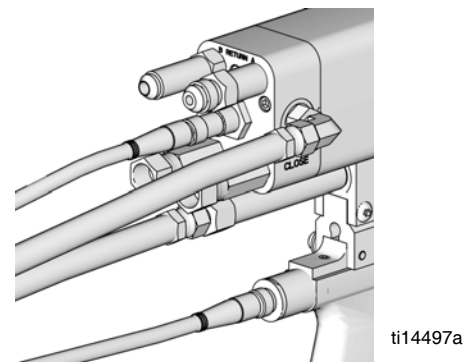


FIG. 8

10. Verify power pack pressure is 1800 - 2500 psi. Adjust pressure as required.

11. Install chemical hoses to gun. See FIG. 5 on page 10 and FIG. 9.

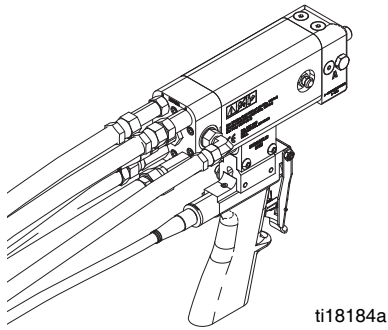


FIG. 9

Shutoff Valve Setup



The shutoff valves are used to control chemical flow.

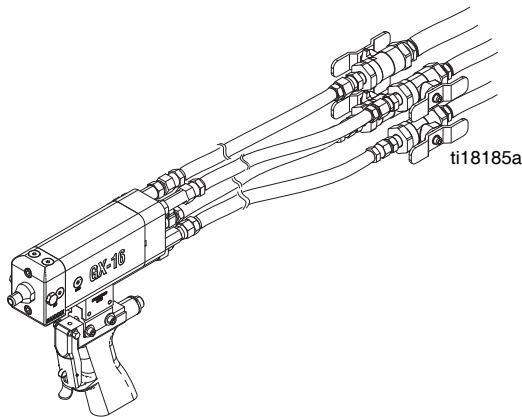
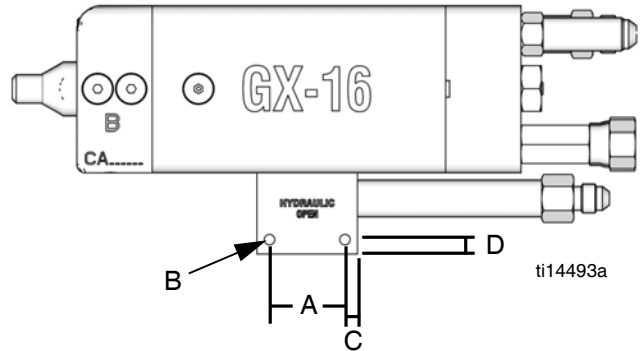


FIG. 10: Shutoff Valve Setup

1. Perform pressure relief procedure. See **Pressure Relief Procedure** on page 15.
2. Use four chemical hoses to connect shutoff valves to gun. See FIG. 10.
3. Perform gun setup procedure to connect remaining hoses. See **Gun Setup** on page 11.
4. Perform **Startup** procedure on page 13.

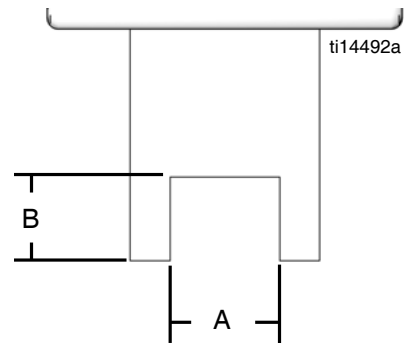
Mounting

Use the following mounting dimensions to mount the GX-16 gun body.



- A Width: 1.125 in. (28.58 mm)
- B Diameter: 0.159 in. (4.04 mm),
10/32 UNF Thread on one side
- C From edge: 0.188 in. (4.78 mm)
- D From edge: 0.218 in. (5.54 mm)

FIG. 11: Mounting Hole Dimensions

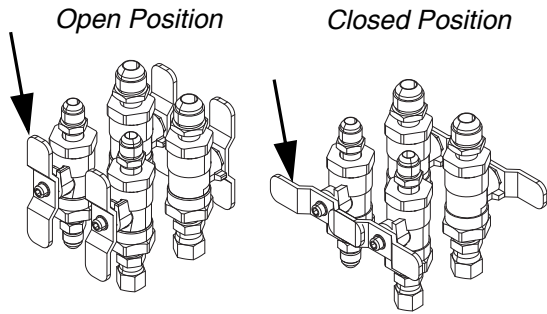


- A Width: 0.578 in. (14.7 mm)
- B Height: 0.440 in. (11.2 mm)

FIG. 12: Mounting Block Dimensions

Startup

1. If your setup uses the optional shutoff valves, rotate the handles to the “open” position.



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FIG. 13: Shutoff Valves Positions

2. Verify cables and hoses are correctly setup. See **Gun Connections** section on page 10.
3. Check for excessive wear on cables and hoses. Replace as necessary.

4. Close dump valve on hydraulic power pack.

Hydraulic pressure must not exceed the maximum working pressure of 2500 psi (17 MPa, 172 bar).						

5. Start power pack and verify hydraulic pressure is 1800 - 2500 psi.
6. Start chemical pumps.

Chemical pressure must not exceed the maximum working pressure of 3000 psi (21 MPa, 207 bar).						

7. Verify chemical pressure is in desired range.

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8. Dispense a test shot into a waste container.
9. Clean any residual material from the tip of the gun.

Operation

Theory of Operation

Circulation

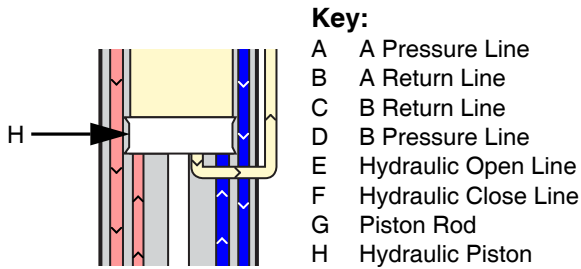
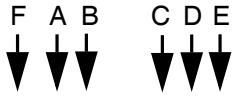


FIG. 14: Circulation

Hydraulic pressure extends the piston rod to the circulation position. Material enters the material pressure line and is sent to the material return line.

When the piston rod is extended to this position, it removes gelled material from the nose assembly.

Dispense

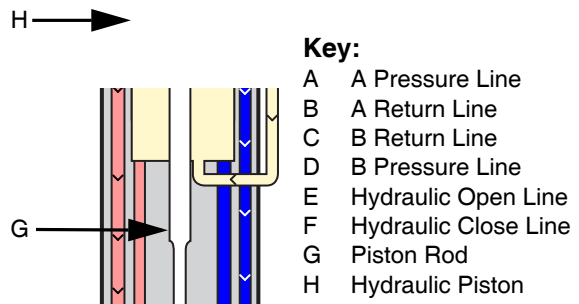
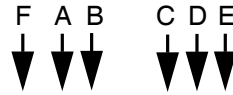


FIG. 15: Dispense

Hydraulic pressure retracts the piston rod to the dispense position. Material enters the A and B material pressure lines and mixes in the mixing chamber.

When the piston rod is in this position, it blocks material flow from entering the material return line.

Pressure Relief Procedure



1. **If your setup uses the optional shutoff valves**, rotate the handles to the “open” position.
2. Shut down chemical pumps.
3. Drain air pressure from the A and B side chemical tanks.
4. After tank air pressure is at zero, close the A and B tank outlet valves.
5. Verify pressures read zero on chemical pressure gauges.
6. Turn off hydraulic power pack.
7. Bleed hydraulic pressure via dump valve on power pack.
8. Verify pressures read zero on hydraulic pressure gauges.

Shutdown



1. Perform **Pressure Relief Procedure**.
2. Perform any required maintenance. See **Maintenance** on page 16.
3. **If system will not be in use for longer than two weeks**, the A and B chemical tanks must have 10 psi of dry air pressure.

NOTICE

Air must be dry. Moist air will react with isocyanate and cause crystallization resulting in significant component damage.

4. **If the gun will not be used for longer than four weeks**, flush the gun.

Maintenance

Procedure	Frequency
Inspect the gun, fluid lines, trigger switch cable and, if installed, the proximity switch cable for wear or damage	Daily
Grease the gun	Weekly or Every 15,000 Shots
Clean and service the orifices and filters	As Needed

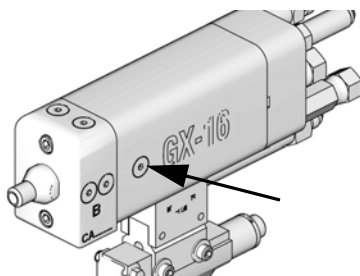
Recommended Tools

- 7/16 in. open end wrench
- 3/8 in. open end wrench
- 1/8 in. allen key
- 1/4 in. allen key
- Pin vise 117661
- Drill bit (see etching on orifice for size, drill bit should be same size as orifice)
- O-Ring Pick
- Small brass brush
- 1/4 in. brass barrel brush
- Small flashlight
- Small solvent pump can
- Cleaning rags
- Chemically impermeable gloves
- Safety glasses
- Small chemical and solvent waste container
- Grease gun
- Grease, part 0553-6

Grease the Gun

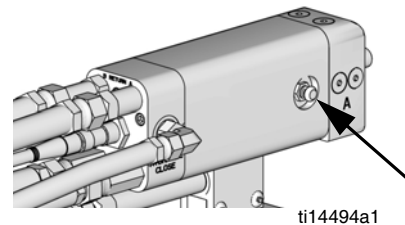


1. Perform pressure relief procedure. See **Pressure Relief Procedure** on page 15.
2. Use a 1/8 in. allen key to remove the plug.



ti12899a1

3. Use a grease gun with the required synthetic grease, part 0553-6, to purge the gun body until grease exits the weep hole without evidence of hydraulic oil or hardened material.



ti14494a1

FIG. 16: Grease Fitting

4. Use a 1/8 in. allen key to install the plug.

Recommended Hydraulic Oil

NOTICE

Recommended Hydraulic Oil

Use Graco-approved Hydraulic Oil, Part No. 169236 (5 gal) or 207428 (1 gal)) or a premium, ISO grade 46 petroleum-based hydraulic oil containing rust and oxidation inhibitors and anti-wear agents.

Before using any other type of oil in this motor, contact your Graco distributor. Unauthorized use of lesser grade oil or substitutes may void the warranty.

Hydraulic Oil Working Temperature

The maximum hydraulic oil operating temperature is 180 °F (82 °C).

Recommended Grease

NOTICE

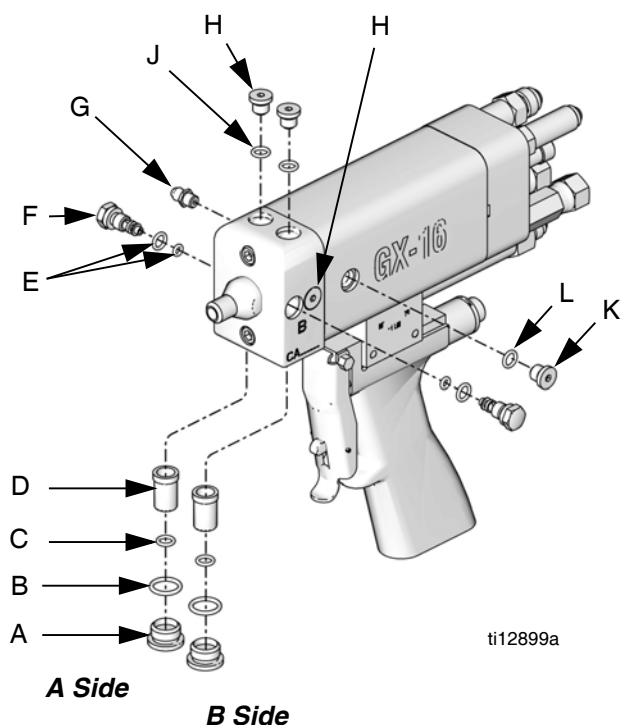
Recommended Grease

Use Graco-approved grease, Part No. 0553-6. This is a synthetic grease with an operating temperature up to 450 °F.

Clean and Service the Orifices and Filters



Cross-contamination can result in cured material in fluid lines which could cause serious injury or damage equipment. To prevent cross-contamination of the equipment's wetted parts, **never** interchange component A (isocyanate) and component B (resin) parts.



Key:

A	Filter Plug	G	Grease Port Plug
B	Filter Plug O-Ring	H	Cleanout Plug
C	Filter O-Ring	J	Cleanout Plug O-Ring
D	Filter	K	Plug
E	Orifice O-Rings	L	Plug O-Ring
F	Orifice		

FIG. 17:

NOTE: See **Dispenser Models 257513, 257514, 257515** on page 28 for applicable part numbers.

1. Perform pressure relief procedure. See **Pressure Relief Procedure** on page 15.

2. If your setup uses the optional shutoff valves, rotate the handles to the "close" position.
3. Use a 7/16 in. wrench to remove the orifice.
4. Use a 1/8 in. allen key to remove the cleanout plug next to the orifice.
5. Use a 1/4 in. allen key to remove the filter plug (A).
6. Remove the filter (D).
7. Use a pick to remove any hardened material from filter.
8. Use solvent to flush residue from this side of the gun block.
9. Use a pin vise and drill bit to carefully clean the orifice.
10. Remove the orifice o-rings.
11. Use a pick to remove any hardened material from the orifice body.
12. Flush the orifice body with solvent then dry the orifice.
13. Install new o-rings on the orifice.
14. Install new filter.
15. Replace filter retainer o-ring if needed.
16. Apply grease to filter retainer threads then use a 1/4 in. allen key to install the filter retainer.
17. Apply grease to the o-ring plug threads.
18. Install o-rings then use a 1/8 in. allen key to install cleanout plug next to the orifice.
19. Apply grease to orifice threads then install the orifice assembly.
20. Repeat for opposite chemical side of gun.

Proximity Switch Replacement Procedure



1. Perform pressure relief procedure. See **Pressure Relief Procedure** on page 15.
2. Remove proximity switch cable attached to proximity switch.
3. Remove proximity switch from rear of gun body.

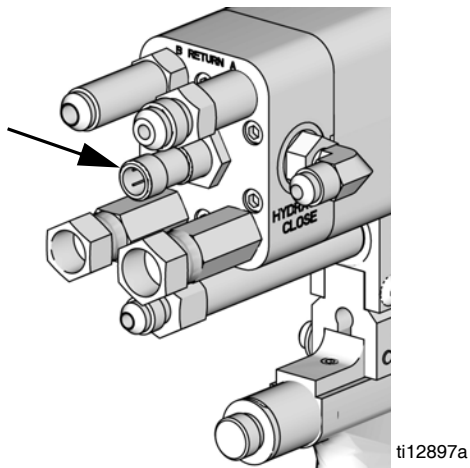


FIG. 18

4. Install new proximity switch.
5. Attach proximity switch cable to proximity switch.

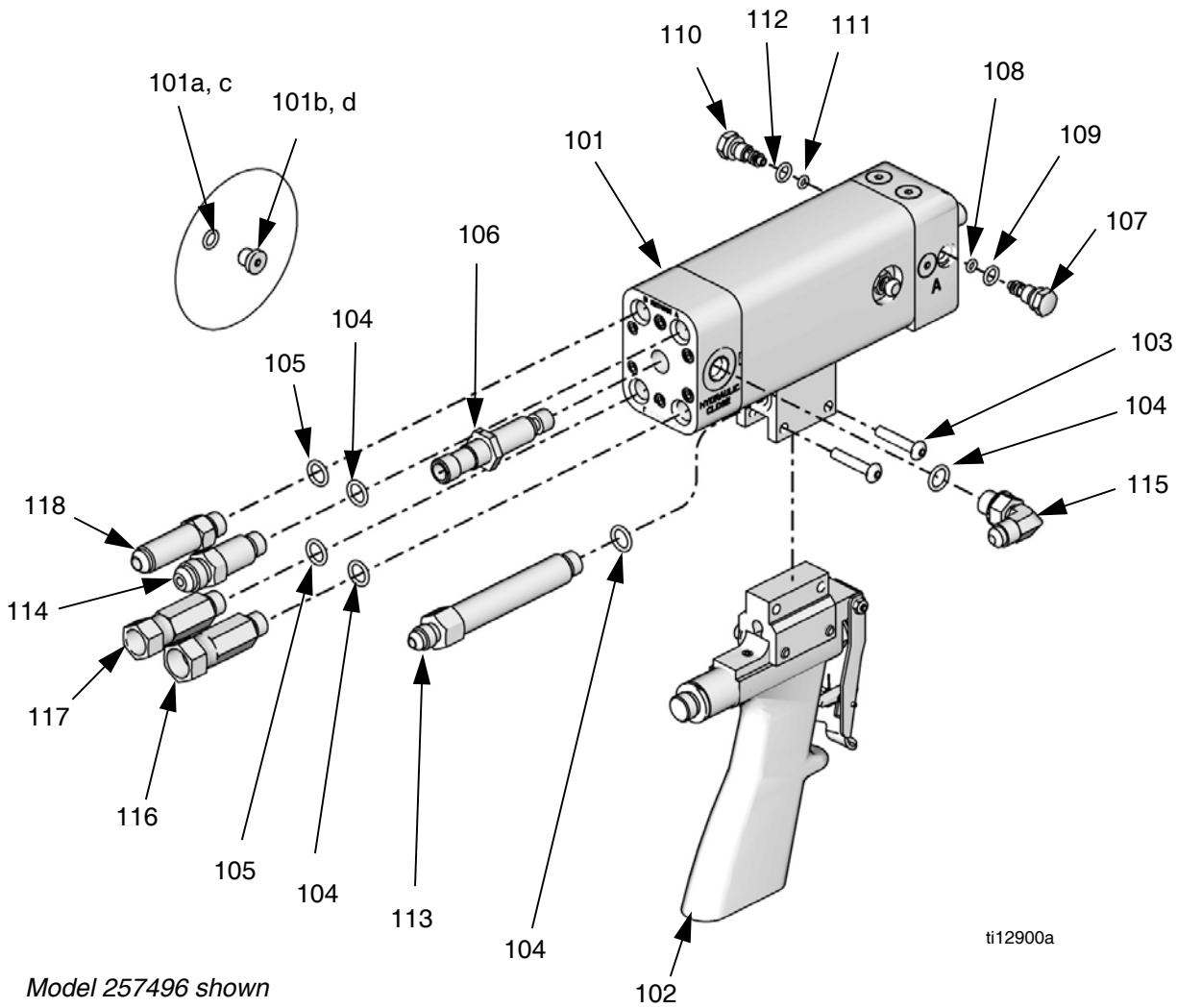
Troubleshooting



Problem	Cause	Solution
Poor mixing	One or both sides of gun are clogged	Clean the gun, see Maintenance on page 16 One or both orifices may need to be replaced
	Hydraulic piston not opening fast enough due to insufficient hydraulic pressure	Verify hydraulic unit pressure and accumulator charge
No fluid being dispensed	Insufficient pressure to move hydraulic piston to the dispense position	Verify hydraulic unit pressure and accumulator charge
	Faulty proximity switch	Replace proximity switch
	Damaged piston u-cup seals	Send gun to Graco for repair
Chemical crossover	Seal failure on piston rod	Send gun to Graco for repair
Hydraulic leak into divorce chamber (hydraulic fluid found in purged grease when greasing the gun)	Damaged seal u-cup	Send gun to Graco for repair
Proximity switch not working	Damaged proximity switch	Remove and test the switch, replace as needed
	Damaged proximity switch cord	Remove and test the cord, replace as needed
Valve opens on power up	Air in hydraulic lines	Disconnect hydraulic hoses from gun. Follow Gun Setup on page 11.

Parts

**Gun Models 257496, 257498, 257499,
257505, 257506, 257507, 24J187, 24E876**



ti12900a

Model 257496 shown

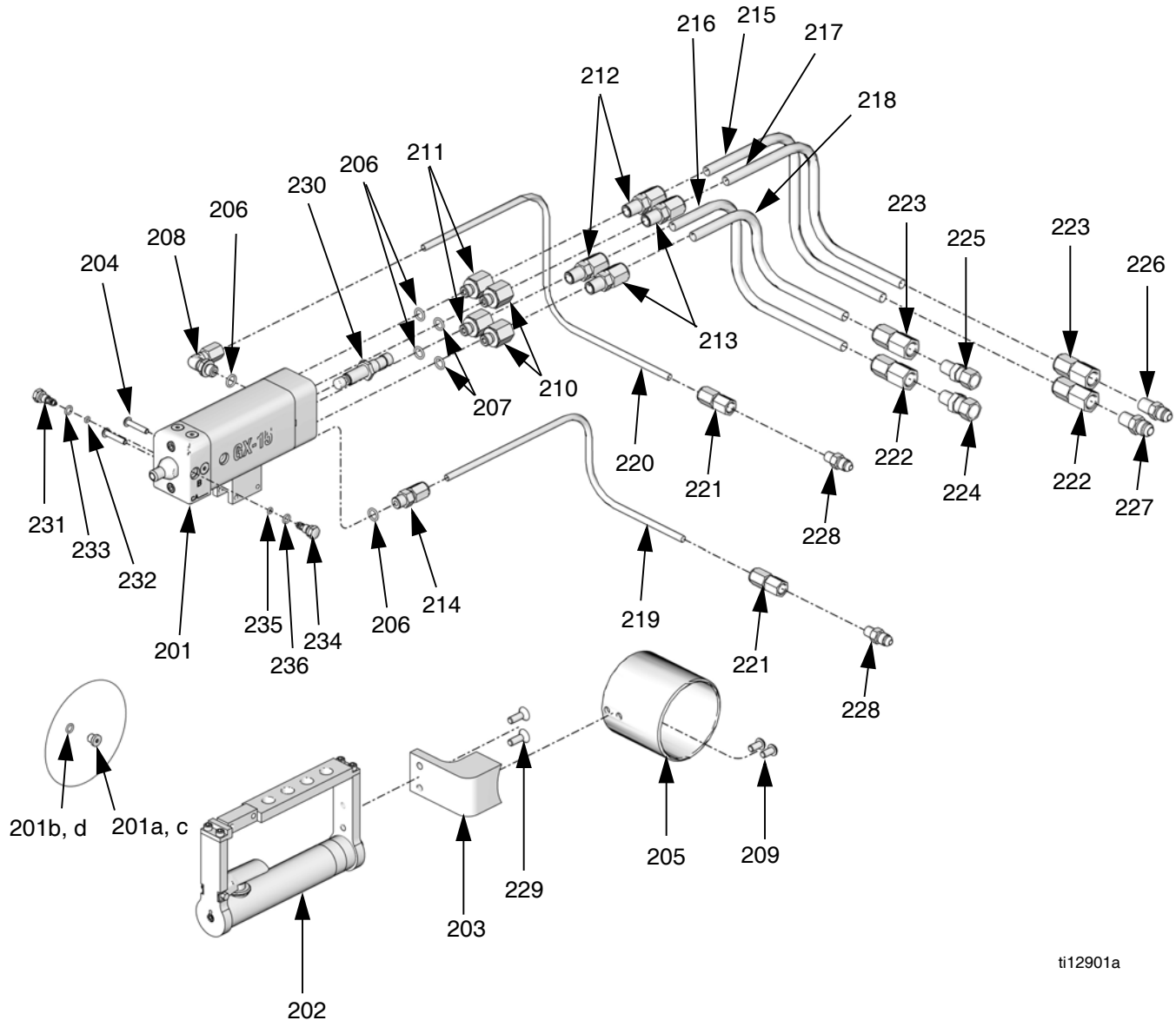
Ref.	Part	Description	Quantity by Model							
			257496	257498	257499	257505	257506	257507	24J187	24E876
101	257513	DISPENSER, GX-16, 1:1, pre-assy				1	1	1		
	257514	DISPENSER, GX-16, 24:1, pre-assy	1	1					1	1
	257515	DISPENSER, GX-16, rev block, pre-assy			1					
. 101a◆	. 122685	. PLUG, sae02, socket head, m, ms, 6k	1	1	1	2	2	2		
. 101b◆	. 261500	. O-RING, #902, fluoroelastomer	1	1	1	2	2	2		
. 101c◆	. 122687	. PLUG, sae02, 316 ss	1	1	1					

Ref.	Part	Description	Quantity by Model							
			257496	257498	257499	257505	257506	257507	24J187	24E876
. 101d◆	. 122679	. O-RING, epr, #902	1	1	1					
102	257509	HANDLE, GX-16, pistol grip				1				
	257510	HANDLE, GX-16, pistol grip, isolated	1				1	1		
103	122694	SCREW, bhsc, 10-32x1.00, ms	2			2	2	2		
104	122707	O-RING, fluoroelastomer, #904, 75a	4	4	4	6	6	6	3	3
105	122714	O-RING, ep, 904, 70a	2	2	2				2	2
106	122713	SWITCH, proximity	1	1	1		1		1	1
	15Y178	PLUG, cavity, proximity switch				1		1		
107	257724	RESTRICTOR, orifice assy, 0.061	1						1	
	257717	RESTRICTOR, orifice assy, 0.039					1			
108*	168518	PACKING, o-ring, fluoroelastomer	1							
109*	261500	O-RING, #902, fluoroelastomer	1							
110	257701	RESTRICTOR, orifice assy, 0.011	1						1	
	257717	RESTRICTOR, orifice assy, 0.039					1			
111*	285967	O-RING, #006 epr	1							
112*	122679	O-RING, epr, #902	1							
113	15Y177	FITTING, 7/16 org x 7/16 jic ext	1	1	1	1	1	1	1	1
114	298408	FITTING, 7/16 org x 9/16 jic ext	1	1	1	1	1	1		
	122710	ADAPTER, jic05xsae04, mm, ss, 6k							1	1
115	122711	FITTING, elbow, 90, jic04xsae04	1	1	1	1	1	1	1	1
116	122708	ADAPTER, swivel, jic06xsae04, fm, ss, 6k	1	1	1	1	1	1		
	122709	ADAPTER, swivel, jic05xsae04, fm, ss, 6k							1	1
117	122709	ADAPTER, swivel, jic05xsae04, fm, ss, 6k	1	1	1	1	1	1		
	122708	ADAPTER, swivel, jic06xsae04, fm, ss, 6k							1	1
118	122710	ADAPTER, jic05xsae04, mm, ss, 6k	1	1	1	1	1	1		
	298408	FITTING, 7/16 org x 9/16 jic ext							1	1

* **For all models**, o-ring materials are marked on the gun below the A side orifice

◆ Parts are used in the maintenance of the gun. Parts are shipped loose.

Gun Models 257492, 257493, 257494, 257495



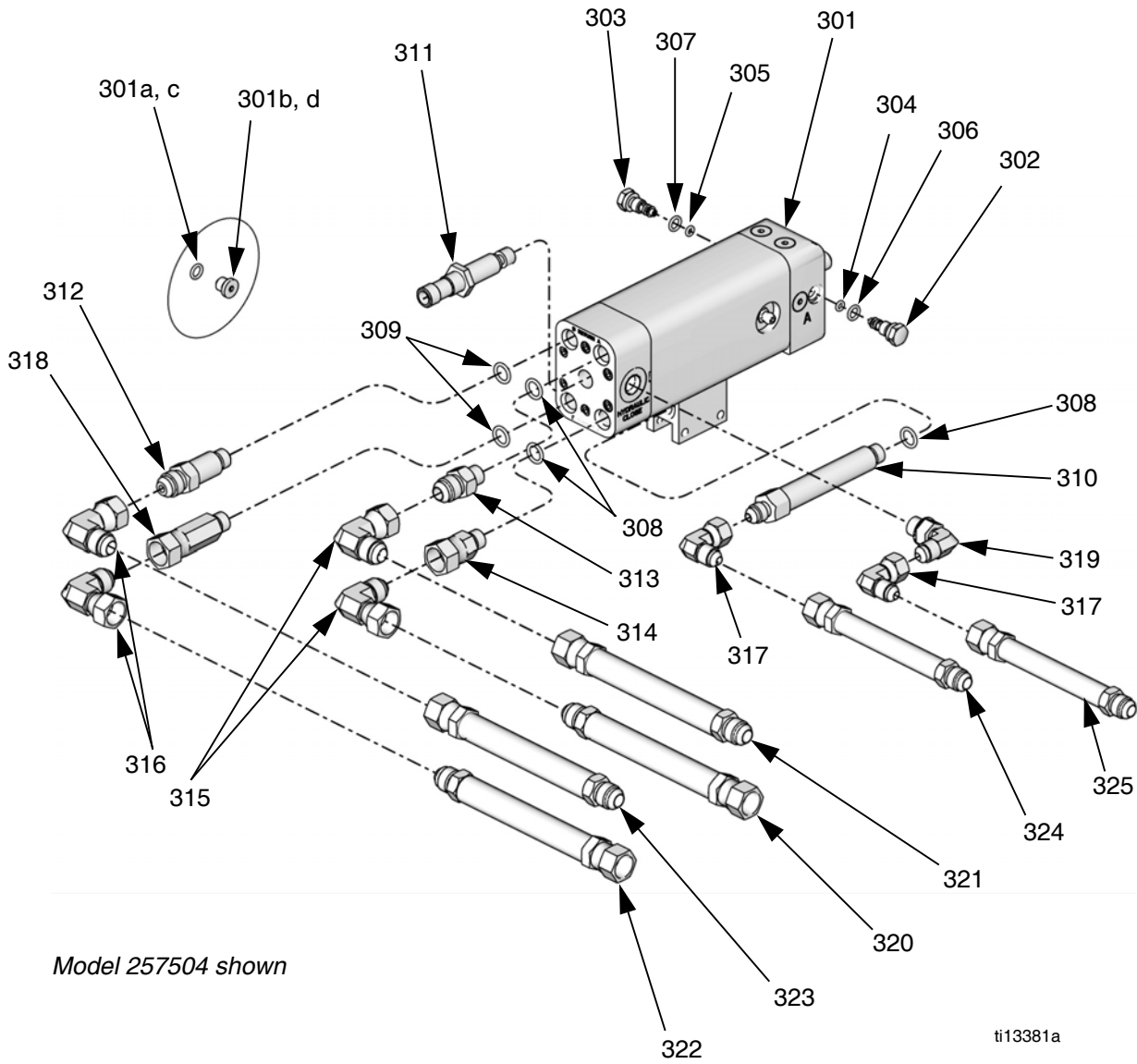
ti12901a

Model 257492 shown

Ref.	Part	Description	Quantity by Model			
			257492	257493	257494	257495
201	257514	DISPENSER, GX-16, 24:1, pre-assy	1	1	1	1
. 201a◆	. 122685	. PLUG, sae02, socket head, m, ms, 6k	1	1	1	1
. 201b◆	. 261500	. O-RING, #902, fluoroelastomer	1	1	1	1
. 201c◆	. 122687	. PLUG, sae02, 316 ss	1	1	1	1
. 201d◆	. 122679	. O-RING, epr, #902	1	1	1	1
202	257594	HANDLE, GX-16, pour	1	1		
	257596	HANDLE, GX-16, pour			1	1
203	15Y246	BRACKET, hose, pour handle	1	1	1	1
204	122694	SCREW, bhsc, 10-32x1.00, ms	2	2	2	2
205	15Y247	BRACKET, hose, cylinder	1	1	1	1
206	122707	O-RING, fluoroelastomer, #904, 75a	4	4	4	4
207	122714	O-RING, ep, 904, 70a	2	2	2	2
208	285874	FITTING, 7/16 o-ring x 1/4 tube 90 elbow	1	1	1	1
209	122741	SCREW, bhcs, 1/4-20x0.50, ms	2	2	2	2
210	122730	ADAPTER, 1/4nptxsae04, fm, ss, 6k, 316	2	2	2	2
211	122731	ADAPTER, 1/4nptxsae04, fm, ms, 6k	2	2	2	2
212	122729	ADAPTER, 1/4nptx3/8tube, mf, ms, 5k	2	2	2	2
213	122732	ADAPTER, 1/4nptx3/8tub, mf, ss, 5k	2	2	2	2
214	122733	ADAPTER, sae04x1/4tub, mf, ms, 5k	1	1	1	1
215	15Y332	TUBE, a-return, left side		1		1
	15Y326	TUBE, a-return, right side	1		1	
216	15Y333	TUBE, a-supply, left side		1		1
	15Y327	TUBE, a-supply, right side	1		1	
217	15Y334	TUBE, b-return, left side		1		1
	15Y328	TUBE, b-return, right side	1		1	
218	15Y335	TUBE, b-supply, left side		1		1
	15Y329	TUBE, b-supply, right side	1		1	
219	15Y336	TUBE, hyd open, left side		1		1
	15Y330	TUBE, hyd open, right side	1		1	
220	15Y337	TUBE, hyd close, left side		1		1
	15Y331	TUBE, hyd close, right side	1		1	
221	122734	ADAPTER, 1/8nptx1/4tub, ff, ms, 5k	2	2	2	2
222	122735	ADAPTER, 1/4nptx3/8tub, ff, ms, 5k	2	2	2	2
223	122736	ADAPTER, 1/4nptx3/8tb, ff, ss, 5k, 316	2	2	2	2
224	122721	ADAPTER, swivel, jic6x1/4npt, fm, ms, 5k	1	1	1	1
225	122737	ADAPTER, swivel, 1/4nptxjic05, fm, ss, 6	1	1	1	1
226	122727	ADAPTER, jic05x1/4npt, mm, ss, 6k, 316	1	1	1	1
227	122722	ADAPTER, jic06x1/4npt, mm, ms, 6k	1	1	1	1
228	122726	FITTING, adapter, jic04x1/8npt	2	2	2	2
229	122742	SCREW, fhcs, 1/4-20x0.750, ms	2	2	2	2
230	122713	SWITCH, proximity	1	1	1	1
231	257724	RESTRICTOR, orifice assy, 0.061	1	1	1	1
232	168518	PACKING, o-ring, fluoroelastomer	1	1	1	1
233	261500	O-RING, #902, fluoroelastomer	1	1	1	1
234	257701	RESTRICTOR, orifice assy, 0.011	1	1	1	1
235	285967	O-RING, #006 epr	1	1	1	1
236	122679	O-RING, epr, #902	1	1	1	1

◆ Parts are used in the maintenance of the gun. Parts are shipped loose.

Gun Models 257497, 257502, 257503, 257504, 24E877, 24E878

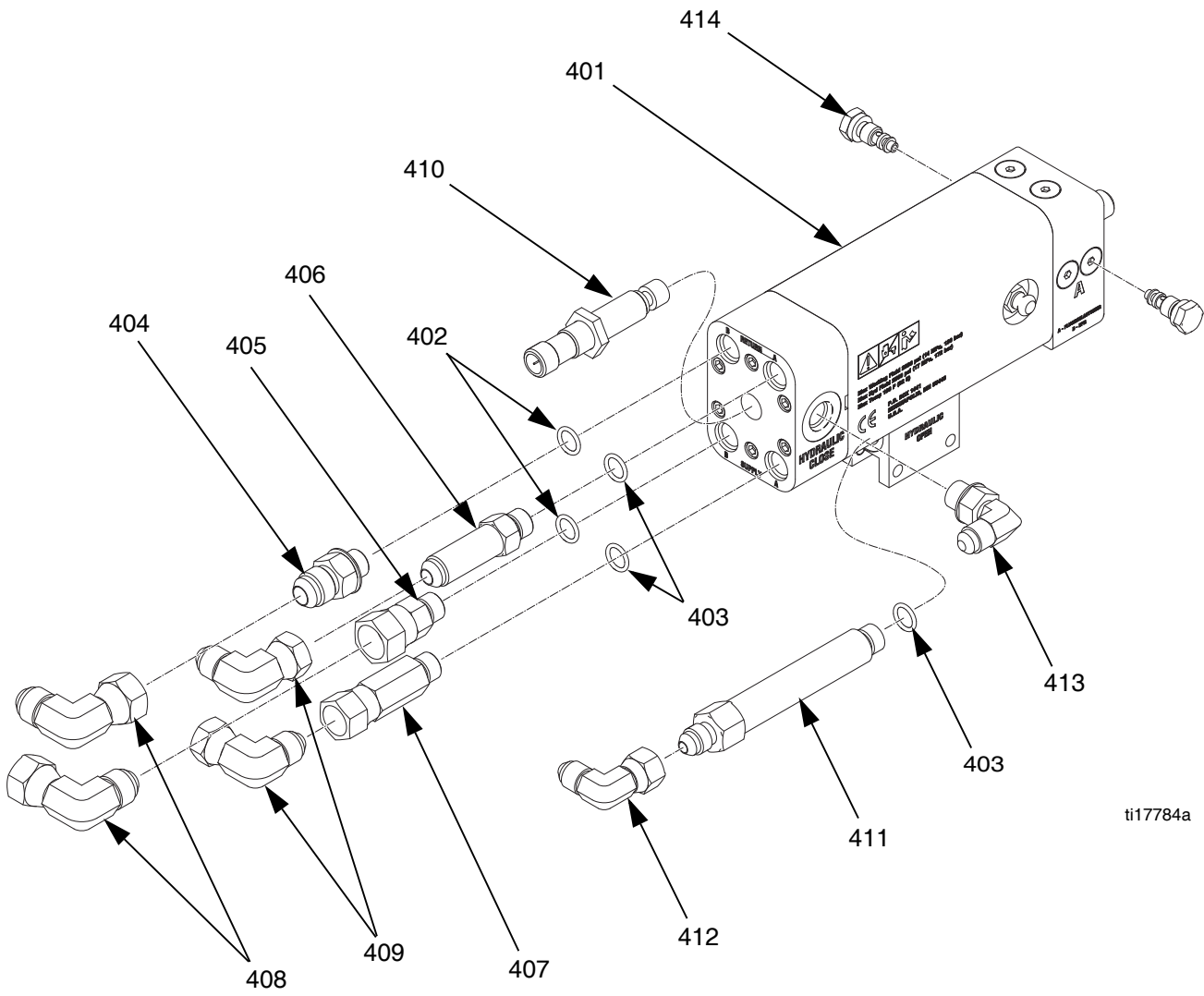


Ref.	Part	Description	Quantity by Model					
			257497	257502	257503	257504	24E877	24E878
301	257513	DISPENSER, GX-16, 1:1, pre-assy		1	1	1		
	257514	DISPENSER, GX-16, 24:1, pre-assy	1				1	1
. 301a◆	. 122685	. PLUG, sae02, socket head, m, ms, 6k	1	1	1	1		
. 301b◆	. 261500	. O-RING, #902, fluoroelastomer	1	1	1	1		
. 301c◆	. 122687	. PLUG, sae02, 316 ss	1	1	1	1		
. 301d◆	. 122679	. O-RING, epr, #902	1	1	1	1		
302	257724	RESTRICTOR, orifice assy, 0.061	1				1	
	257717	RESTRICTOR, orifice assy, 0.039		1	1	1		

Ref.	Part	Description	Quantity by Model					
			257497	257502	257503	257504	24E877	24E878
303	257701	RESTRICTOR, orifice assy, 0.011	1				1	
	257717	RESTRICTOR, orifice assy, 0.039		1	1	1		
304	168518	PACKING, o-ring, fluoroelastomer	1	1	1	1		
305	285967	O-RING, #006 epr	1					
	168518	PACKING, o-ring, fluoroelastomer		1	1	1		
306	261500	O-RING, #902, fluoroelastomer	1	1	1	1		
307	122679	O-RING, epr, #902	1					
	261500	O-RING, #902, fluoroelastomer		1	1	1		
308	122707	O-RING, fluoroelastomer, #904, 75a	3	3		3	3	3
309	122714	O-RING, fluoroelastomer, #904, 75a	2				2	2
	122707	O-RING, fluoroelastomer, #904, 75a		2		2		
310	15Y177	FITTING, 7/16 org x 7/16 jic ext	1	1		1	1	1
311	122713	SWITCH, proximity	1	1	1	1	1	1
312	298408	FITTING, 7/16 org x 9/16 jic ext		1		1	1	1
	122710	ADAPTER, jic05xsae04, mm, ss, 6k	1					
313	122720	ADAPTER, jic06xsae04, mm, ms, 6k, fluoroelastomer	1	1		1		
	124221	ADAPTER, jic05xsae04, mm, ss, 6k					1	1
314	122717	ADAPTER, swivel, jic06xsae04, fm, ms, 6k	1	1		1		
	125541	FITTING, swivel, jic05xsae04, fm, ss, 6k					1	1
315	129342	FITTING, elbow, swivel, 90, jic06, fm, ss	2	2		2		
	122715	FITTING, elbow, swivel, 90, jic05, fm, ss					2	2
316	122715	FITTING, elbow, swivel, 90, jic05, fm, ss	2					
	129342	FITTING, elbow, swivel, 90, jic06, fm, ss		2		2	2	2
317	122718	FITTING, elbow, swivel, 90, jic04, fm, ms	2	2		2	2	2
318	122708	ADAPTER, swivel, jic06xsae04, fm, ss, 6k		1		1	1	1
	122709	ADAPTER, swivel, jic05xsae04, fm, ss, 6k	1					
319	122711	FITTING, elbow, 90, jic04xsae04	1	1		1	1	1
320	24C481	HOSE, 3 ft, A-supply, yellow tape				1		
321	24C482	HOSE, 3 ft, A-return, yellow/white tape				1		
322	24C483	HOSE, 3 ft, B-supply, green tape				1		
323	24C484	HOSE, 3 ft, B-return, green/white tape				1		
324	24C485	HOSE, 3 ft, hydraulic open, black tape				1		
325	24C486	HOSE, 3 ft, hydraulic close, black/white tape				1		

◆ Parts are used in the maintenance of the gun. Parts are shipped loose.

Gun Models 24K233, 24K234

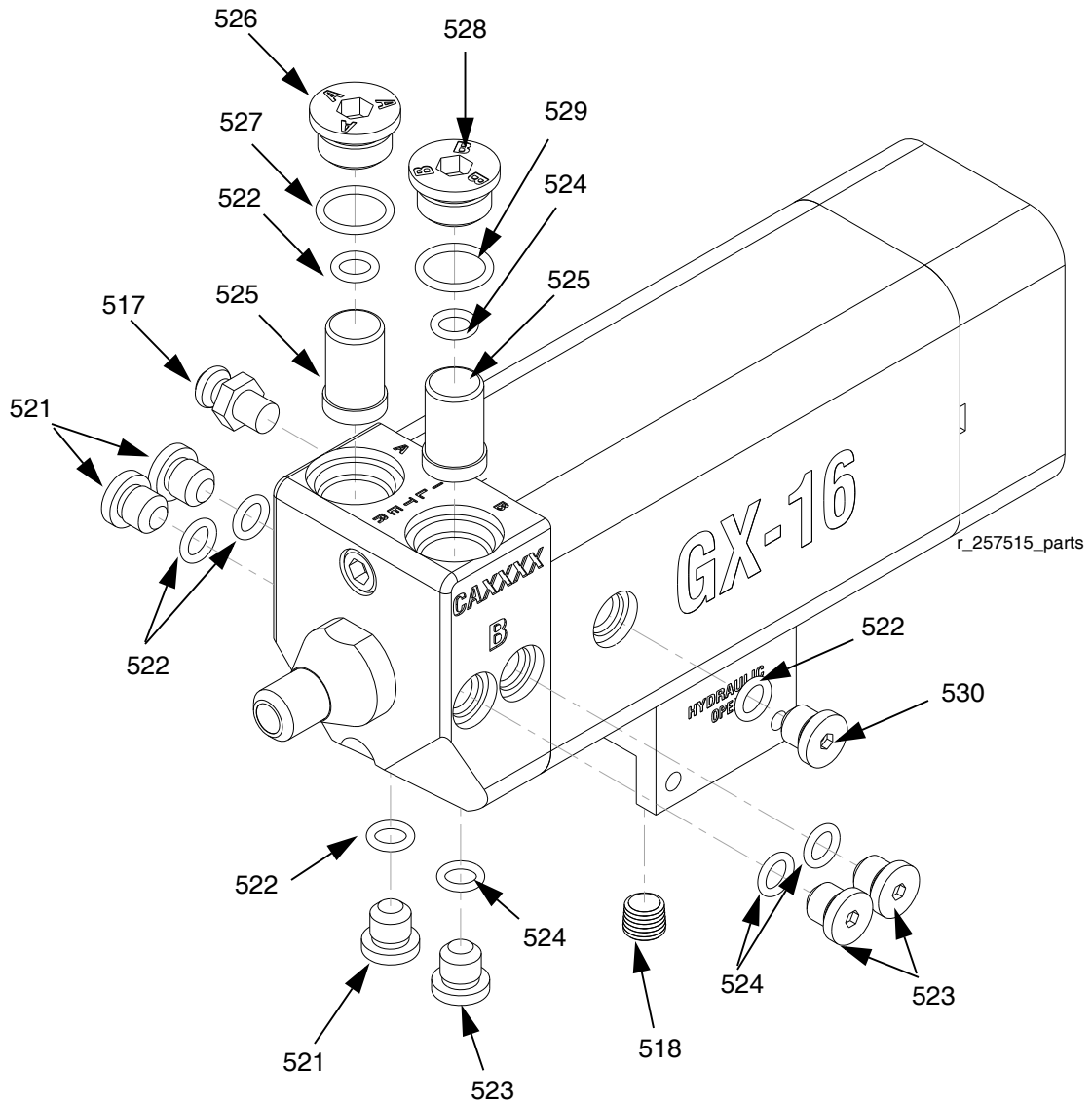


ti17784a

Model 24K233 shown

Ref.	Part	Description	Quantity	
			24K233	24K234
401	257514	DISPENSER, GX-16, 24:1, pre-assy	1	1
402	122714	O-RING, fluoroelastomer, #904, 75a	2	2
403	122707	O-RING, fluoroelastomer, #904, 75a	3	3
404	122720	ADAPTER, jic06xsae04, mm, ms, 6k, fluoroelastomer	1	1
405	122717	ADAPTER, swivel, jic06xsae04, fm, ms, 6k	1	1
406	122710	ADAPTER, jic05xsae04, mm, ss, 6k	1	1
407	122709	ADAPTER, swivel, jic05xsae04, fm, ss, 6k	1	1
408	129342	FITTING, elbow, swivel, 90, jic06, fm, ss	2	2
409	122715	FITTING, elbow, swivel, 90, jic05, fm, ss	2	2
410	122713	SWITCH, proximity	1	1
411	15Y177	FITTING, 7/16 org x 7/16 jic ext	1	1
412	122718	FITTING, elbow, swivel, 90, jic04, fm, ms	2	2
413	122711	FITTING, elbow, 90, jic04xsae04	1	1
414	257701	RESTRICTOR, orifice assy, 0.011	1	
415	257724	RESTRICTOR, orifice assy, 0.061	1	

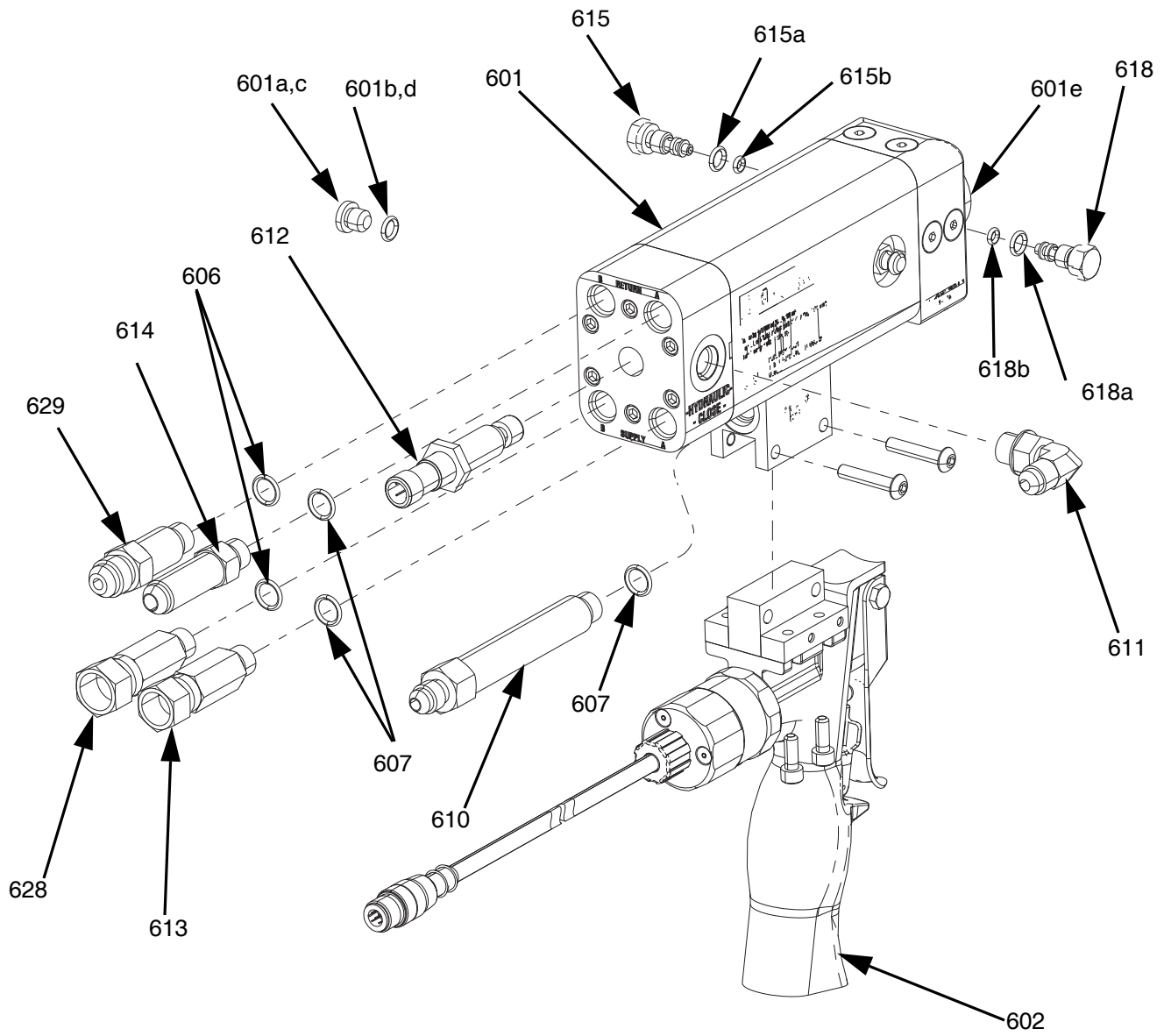
Dispenser Models 257513, 257514, 257515



Model 257515 shown

Ref.	Part	Description	Quantity		
			257513	257514	257515
517	295229	FITTING, grease, 1/4-28	1	1	1
518	295693	PLUG, pipe	1	1	1
521	122687	PLUG, sae02, 316 ss		3	
	122685	PLUG, sae02, skt hd, ms, 6k	3		3
522	261500	O-RING, #902	4		5
	122679	O-RING, #902		5	
523	122687	PLUG, sae02, 316 ss			3
	122685	PLUG, sae02, skt hd, ms, 6k	3	3	
524	122679	O-RING, #902			4
	261500	O-RING, #902	3	4	
525	285917PKG	SCREEN, 230 micron		2	2
526	15X857	PLUG, filter			1
	15X858	PLUG, filter	1	1	
527	122681	O-RING, #906	1		1
	122680	O-RING, #906		1	
528	15X858	PLUG, filter			1
	15X857	PLUG, filter	1	1	
529	122680	O-RING, #906			1
	122681	O-RING, #906	1	1	
530	122685	PLUG, sae02, skt hd	1	1	1

Gun Models 26C466, 25E973, 25E974, 25E975



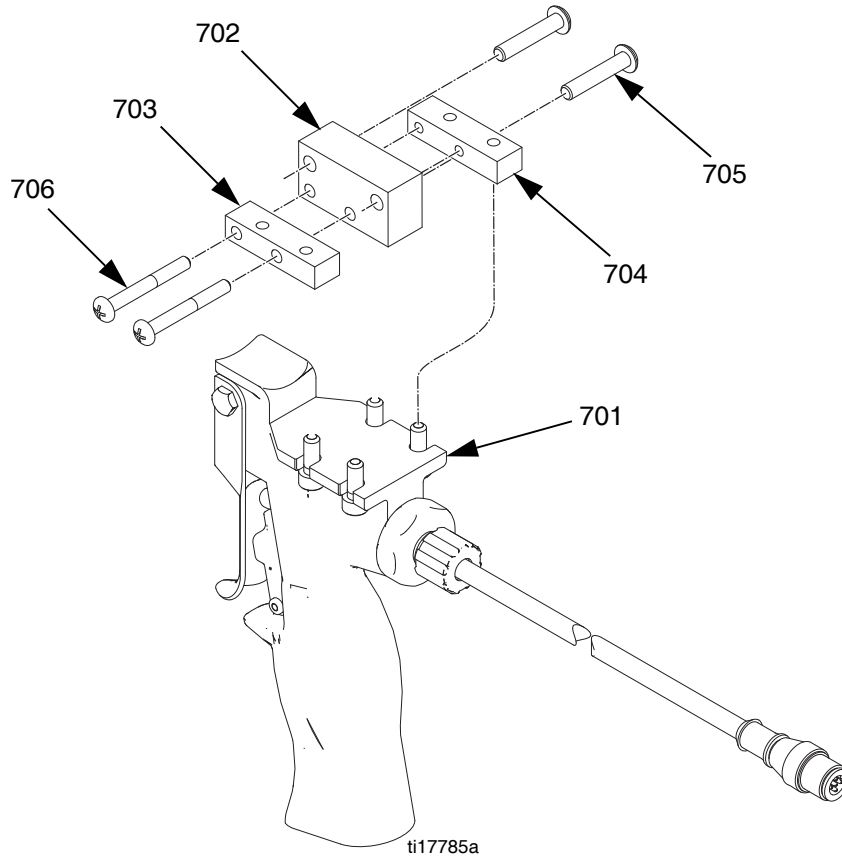
Ref.	Part	Description	Quantity							
			26C466 24:1 MAG	25E973 1:1 RING	25E974 24:1 RING	25E975 1:1 MAG	25R248 24:1 PLAIN	25P155 2:1 PLAIN	25P154 2:1 PLAIN	25R249 1:1 PLAIN
601	26C465	DISPENSER, gx-16, 24:1, pre-assy, mag	1							
	25E972	DISPENSER, gx-16, 24:1, pre-assy, ring			1					
	25R538	DISPENSER, gx-16, 1:1, pre-assy, mag				1				
	25R539	DISPENSER, gx-16, 1:1, pre-assy, ring		1						
	257514	DISPENSER, gx-16, 24:1, pre-assy, plain					1	1	1	
	257513	DISPENSER, gx-16, 1:1, pre-assy, plain								1
. 601a	122685	PLUG, sae02, socket head	1	1	1	1	1	1	1	1
. 601b	261500	O-RING, #902, fkm	1	1	1	1	1	1	1	1
. 601c	122687	PLUG, sae02, 316 ss	1	1	1	1	1	1	1	1
. 601d	122679	O-RING, epr, #902	1	1	1	1	1	1	1	1
. 601e	26C464	BLOCK, gx-16, chamber, magnet	1			1				
	25E971	BLOCK, gx-16, chamber, non-magnet		1	1					
	257511	BLOCK, gx-16, chamber, plain					1	1	1	1
602	26C463	KIT, handle, gx-16, hfr, nvh, led	1			1	1		1	1
606	122714	O-RING, ep	2	2	2	2	2	2	2	2
607	122707	O-RING, fkm	3	3	3	3	3	3	3	3
610	15Y177	FITTING	1	1	1	1	1	1	1	1
611	122711	FITTING, elbow	1	1	1	1	1	1	1	1
612	122713	SWITCH, prox	1	1	1	1	1	1	1	1
613	122709	ADAPTER, swivel	1	1	1	1	1	1	1	1
614	122710	ADAPTER	1	1	1	1	1	1	1	1
615	257712	RESTRICTOR, orifice assembly, .029		1		1	1			1
	257701	RESTRICTOR, orifice assembly .011	1		1					
	257713	RESTRICTOR, orifice assembly .032						1	1	
. 615a	122679	O-RING, epr	1	1	1	1	1	1	1	1
. 615b	285967	O-RING, epr	1	1	1	1	1	1	1	1
618	257712	RESTRICTOR, orifice assembly, .029		1		1				1
	257724	RESTRICTOR, orifice assembly, .061	1		1		1			
	257717	RESTRICTOR, orifice assembly, .039						1	1	
. 618a	122679	O-RING, epr	1	1	1	1	1	1	1	1
. 618b	285967	O-RING, epr	1	1	1	1	1	1	1	1
628	122708	ADAPTER, swivel	1	1	1	1	1	1	1	1
629	298408	FITTING	1	1	1	1	1	1	1	1

Orifices

Part	Orifice Assembly Size
257700	Orifice Plug
257701	0.011 in.
257702	0.013 in.
257703	0.016 in.
257704	0.018 in.
257705	0.020 in.
257706	0.022 in.
257707	0.023 in.
257708	0.024 in.
257709	0.025 in.
257710	0.026 in.
257711	0.028 in.
257712	0.029 in.
257713	0.032 in.
257714	0.035 in.
257715	0.036 in.
257716	0.038 in.
257717	0.039 in.
257718	0.040 in.
257719	0.042 in.
257720	0.043 in.
257721	0.044 in.
257722	0.049 in.
257723	0.052 in.
257724	0.061 in.
24K682	0.085 in.

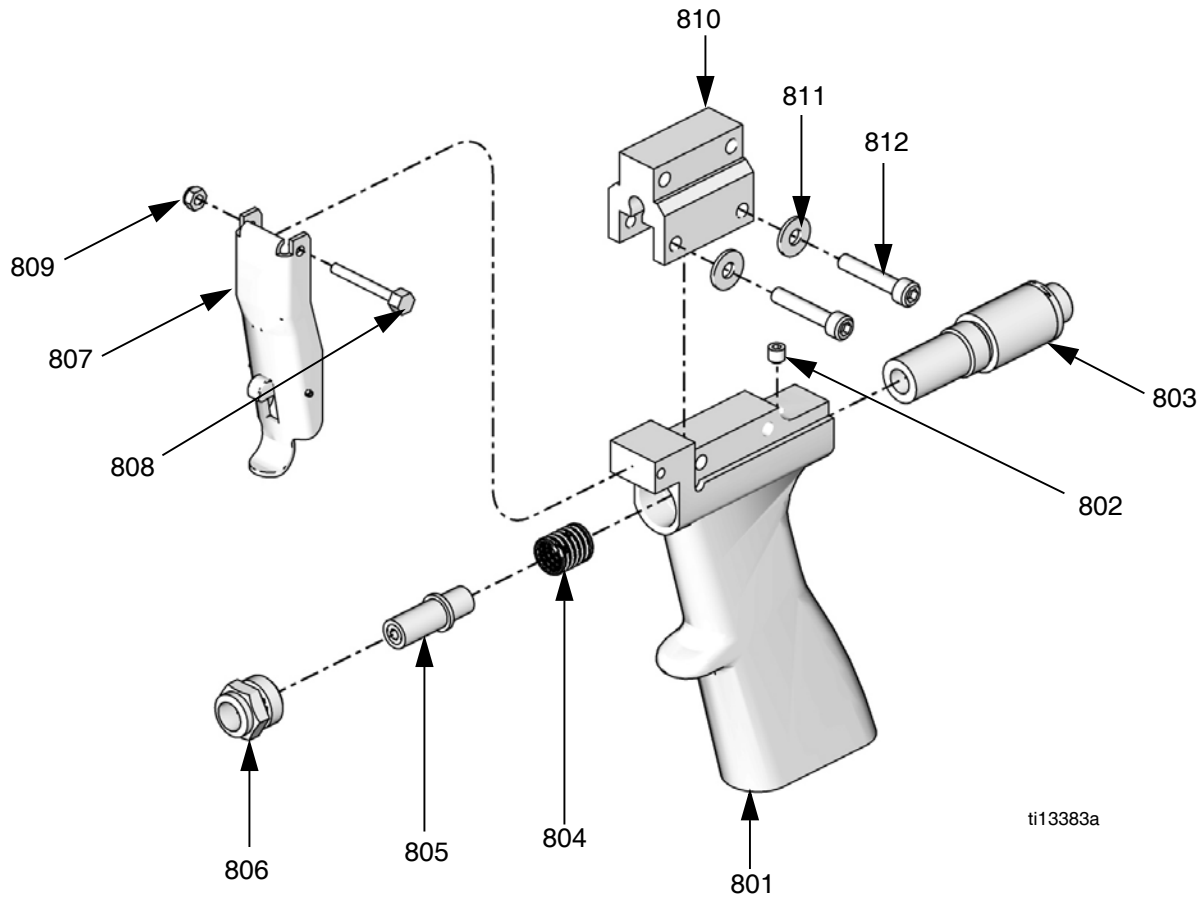
NOTE: O-rings and cleanout drill bits are included in all orifice parts listed.

Gun Handle Kit 24K223



Ref.	Part	Description	Qty
701	24D073	KIT, handle, EP	1
702	16H435	ISOLATOR, handle, GX-16 to MD2	1
703	16H436	ISOLATOR, handle, GX-16 to MD2, left	1
704	16H437	ISOLATOR, handle, GX-16 to MD2, right	1
705	122694	SCREW, button head	2
706	121070	SCREW, machine	2

Gun Handle Models 257509, 257510

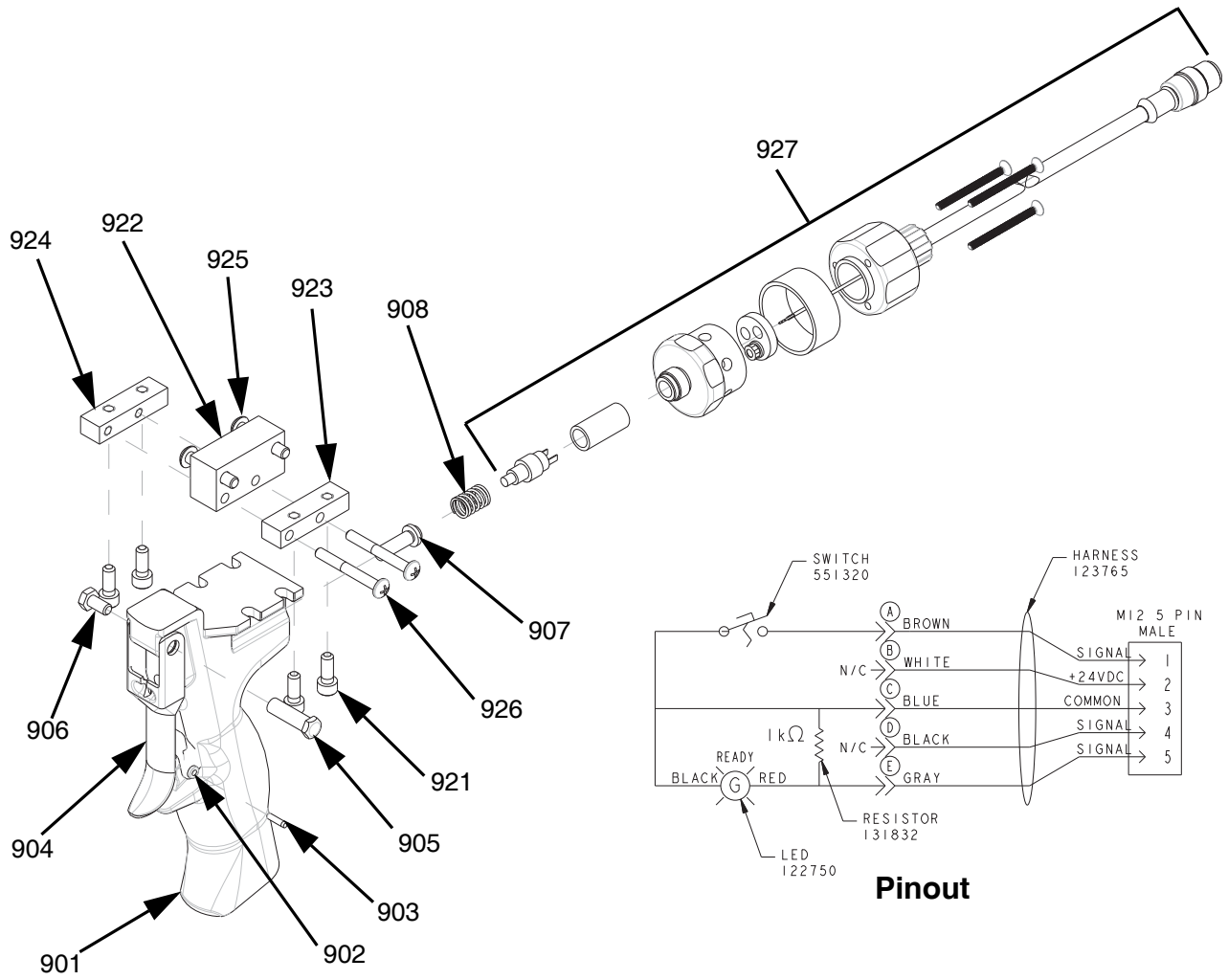


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Model 257510 shown

Ref.	Part	Description	Qty
801	257576	HANDLE	1
802	112095	SCREW, set	1
803	257578	SWITCH, trigger	1
804	299650	SPRING	1
805	257577	PLUNGER, spring	1
806	15Y159	NUT, retainer	1
807	257579	TRIGGER, safety, gun	1
808	295671	SCREW, mounting, trigger	1
809	295438	NUT, stop, elastic, 5-40	1
810	15Y160	ISOLATOR, handle (Model 257510 only)	1
811	122706	WASHER, flat, #10, ms, 1/2od, 0.49 thick (Model 257510 only)	2
812	105210	SCREW, 10-32 x 1 shcs (matrix) (Model 257510 only)	2

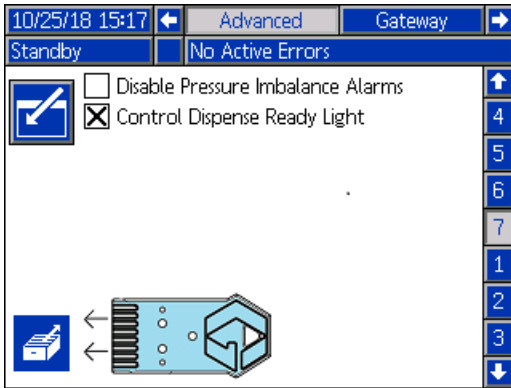
Gun Handle Model 26C463



Ref.	Part	Description	Qty
901	15K666	HANDLE, 2K dispense valve, electric	1
902	276745	STOP, trigger	1
903	112033	PIN, dowel	1
904	15B209	TRIGGER, gun	1
905	192272	PIN, pivot	1
906	203953	SCREW, cap hex hd	1
907	15K668	PLUNGER, trigger, 2K handle	1
908	551396	SPRING, .26 x .37 x .51 music wire	1
922	16H435	ISOLATOR, handle, GX-16 to MD2	1
923	16H436	ISOLATOR, handle, GX-16 to MD2, left	1
924	16H437	ISOLATOR, handle, GX-16 to MD2, right	1
925	122694	SCREW, bhsc, 10 x 1.00, ms	2
926	121070	SCREW, machine, #8 x 1.375	2
927	25E988	KIT, led handle	1

LED Trigger for HFR-NVH

The HFR setup Advanced #7 screen contains the following control options for gun handle 26C463:



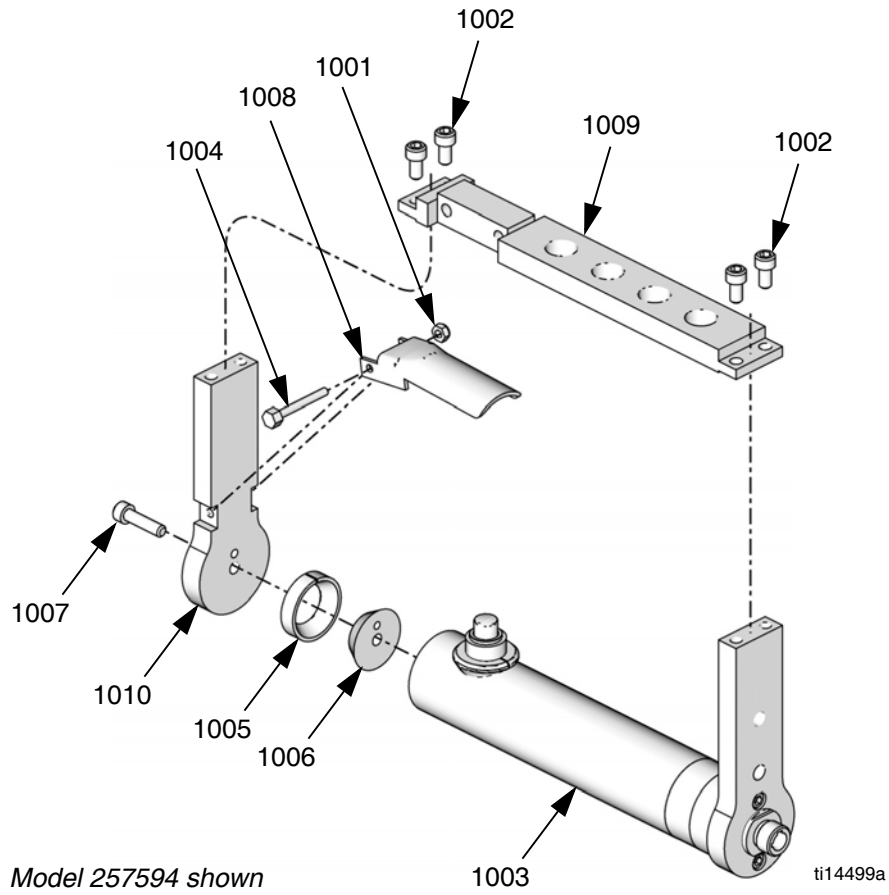
- **Control Dispense Ready Light** – Checking this option will reassign the I/O originally used to sense an optional hydraulic tank low level sensor to an output for driving a ready lamp. Typically a ready lamp (LED) is installed in the handle of a dispense valve.

NOTE: This option can only be enabled when using software version 1.15.079 of 16E122 or later.

When this function is checked or turned ON, the ready lamp will be in one of the following states:

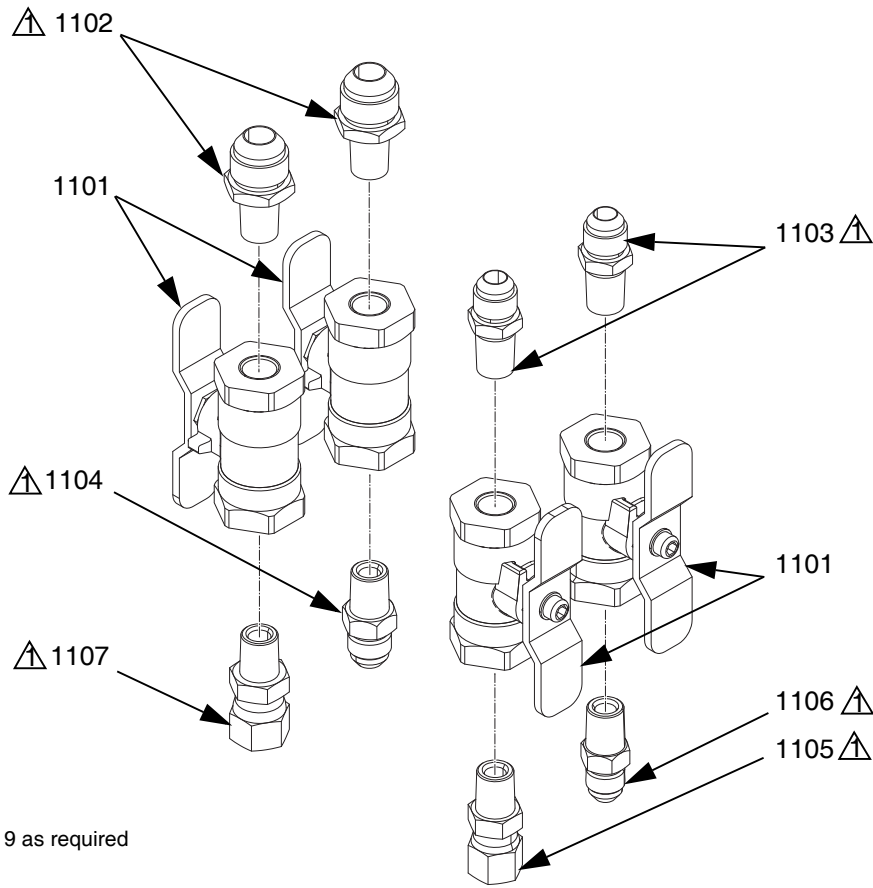
- Not Ready** (Dark or OFF) - This will occur when not in a dispense mode (disable or night modes), the user is on a setup screen when idle, an alarm is active, the system is in low pressure recirculation mode or not moving (full recirculation type systems only), the system is performing a manual or semi-automatic recirculation operation (Auto Circulate Between Dispenses is OFF), or when the stall to pressure logic is OFF (Fusion/P2 dispense valve type systems only).
- Ready** (LED is flashing at a rate of 4 hertz) - This will occur when all conditions outlined in the previous state are NOT true, the system is idle (or in high pressure recirculation mode if using a full recirculation system), and when the system is NOT dispensing.
- Dispensing** (LED is ON) - This will occur when the system is actively dispensing material out of the valve, or when recirculating material through a manual or semi-automatic recirculation kit.

Pour Handle Models 257594, 257596



Ref.	Part	Description	Qty
1001	295438	NUT, stop, elastic, 5-40	1
1002	122746	SCREW, shc, 10-32x.375, ms, nyloc	4
1003	257595	CONTROL, circular connector/led (assembly 257594 only)	1
	257597	CONTROL, star-shaped connector/led (assembly 257596 only)	1
1004	295671	SCREW, mounting, trigger	1
1005	15Y276	CLIP, expander, female	1
1006	257593	CHOCK, male expander, w/pin	1
1007	122747	SCREW, shc, 110-32x0.75, ms	1
1008	15Y277	TRIGGER, pour gun	1
1009	15Y278	MODULE, pour handle mount, w/holes	1
1010	15Y280	FLANGE	1

Optional Shutoff Valve Kit



24L498 Shown

Apply items 8 and 9 as required

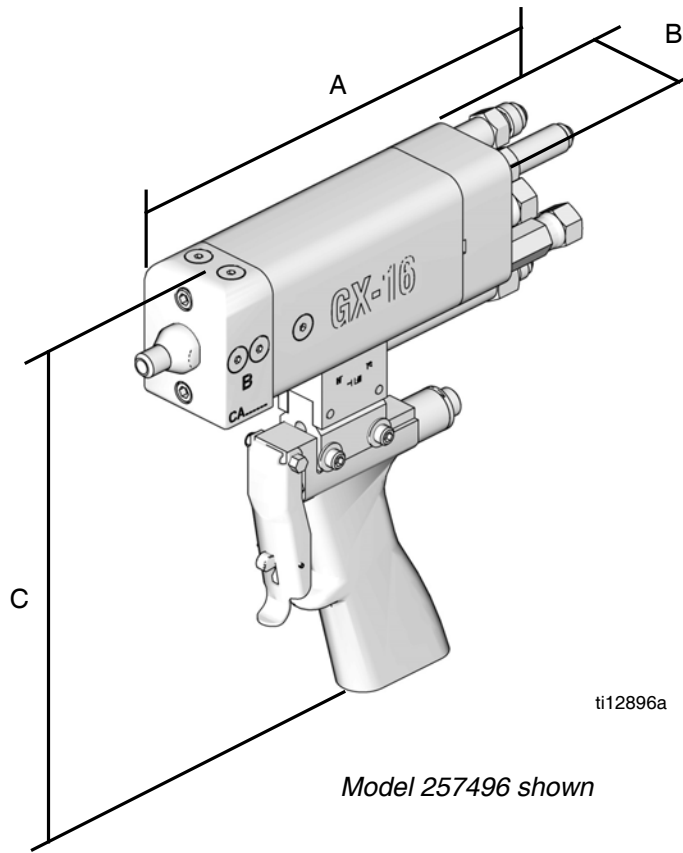
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Ref.	Part	Description	Quantity	
			24L498, KIT, valve shutoff, GX-16	24M596, KIT, valve shutoff, GX-16, NVH
1101	---	VALVE, ball, 2 way, 1/4 NPT, female	4	4
1102	---	ADAPTER, 1/2-20 JIC x 1/4 NPT		2
	---	ADAPTER, JIC08x1/4, MS	2	
1103	---	ADAPTER, JIC06x1/4, SS	2	2
1104	---	ADAPTER, JIC06x1/4 NPT, MS	1	
	---	ADAPTER, swivel, JIC05x1/4 NPT, MS		1
1105	---	ADAPTER, swivel, JIC06x1/4 NPT, MS	1	
	---	ADAPTER, swivel, JIC05x1/4 NPT, MS		1
1106	---	ADAPTER, JIC05x1/4 NPT, SS	1	
	---	ADAPTER, swivel, JIC06x1/4 NPT, MS		1
1107	---	ADAPTER, swivel, 1/4 NPTxJIC05, SS	1	
	---	ADAPTER, swivel, JIC06x1/4 NPT, MS		1
1108	---	TAPE, TFE, sealant	1	1
1109	---	SEALANT, pipe, SST	1	1

Accessories

Description	Part
Hose Kit	24C999
Gun Cover, straight fittings	123694
Gun Cover, 90 deg. fittings	124226
Hose Cover, 12 ft	123698
Right Fitting Adapter Kit	24K672
Left Fitting Adapter Kit	24K674
Grease Fitting Flush Kit	24T326

Dimensions



Model	Dimension		
	A	B	C
257492, 257493, 257494, 257495	15.1 (383)	9.6 (244)	7.9 (201)
257497, 257502, 257503, 257504, 24E877, 24E878, 24K233, 24K234 (no hoses)	10.3 (262)	3.6 (91)	3.7 (94)
257496, 257507, 26C466, 25E975	9.3 (236)	3.0 (76)	8.9 (226)
257505, 257506	9.3 (236)	3.0 (76)	8.1 (206)
257498, 257499, 24J187, 24E876, 25E973, 25E974	9.3 (236)	2.8 (71)	3.7 (94)

Technical Data

Maximum Fluid Working Pressure	3000 psi (21 MPa, 207 bar)
Maximum Hydraulic Working Pressure	2500 psi (17 MPa, 172 bar)
Maximum Fluid Temperature	180°F (82°C)
Fitting Sizes	See Gun Connections section on page 10
Max Sound Power Level	68.5 dB
Wetted Parts	Aluminum, stainless steel, carbon steel, disogrin (urethane), Rulon, EPDM, fluoroelastomer, PTFE
Flow Rate, lb/min (kg/min)	4.6 to 40 (2 to 18)

Weight

Model	Weight*, lb (kg)
257492, 257493, 257494, 257495	8.1 (3.7)
257497, 257502, 257503, 257504, 24E877, 24E878, 24K233, 24K234 (no hoses)	5.0 (2.3)
257496, 257507, 26C466, 25E975	5.2 (2.4)
257505, 257506	5.1 (2.3)
257498, 257499, 24J187, 24E876, 25E973, 25E974	4.6 (2.1)

* Weights are approximate.

California Proposition 65

CALIFORNIA RESIDENTS

 **WARNING:** Cancer and reproductive harm – www.P65warnings.ca.gov.

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Graco warrants all equipment referenced in this document which is 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 up to 250,000 dispense cycles or a period of twelve months, whichever ever occurs first 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.

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Original instructions. This manual contains English. MM 313536

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