



# XM Plural-Component OEM Sprayer

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313292G  
EN

**For spraying two-component epoxy and urethane protective coatings  
in non-hazardous locations.**

**For professional use only.**



**Important Safety Instructions**

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

See page 6 for model information.

See page 31 for maximum working pressure.

For patent information, see [www.graco.com/patents](http://www.graco.com/patents)

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## Related Manuals

Manuals are available at [www.graco.com](http://www.graco.com).

Component Manuals in U.S. English:

<b>Manual</b>	<b>Description</b>
312359	XM Plural-Component Sprayers Operation
313289	XM Plural-Component Sprayers Repair-Parts
311762	Xtreme® Displacement Pumps Instructions-Parts
311328	NXT™ Air Motor Instructions-Parts
312747	Double Wall Hopper Kit Instructions-Parts
309524	Viscon® HP Heater Instructions-Parts
312145	XTR™ 5 and XTR™ 7 Spray Guns Instructions-Parts
312769	Feed Pump and Agitator Kits Instructions-Parts
312794	Merkur® Pump Assembly Instructions-Parts
406699	7-Gallon Hopper Installation Kit Instructions-Parts
406739	Desiccant Kit Instructions-Parts
313258	Electric Heated Hose Power Supply Kit Instructions-Parts
313259	Hopper or Hose Heat Circulation Kit Instructions-Parts
312770	Lower Strainer and Valve Kit Instructions-Parts
312749	XM Mix Manifold Kit Instructions-Parts
313293	Alternator Conversion Kits Instructions-Parts
313342	Dosing Valve Repair Kit Instructions-Parts
313343	High Flow Severe Duty Shutoff Check Valve Repair Kit Instructions-Parts

# 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.

 <b>WARNING</b>	
	<p><b>FIRE AND EXPLOSION HAZARD</b></p> <p>Flammable fumes, such as solvent and paint fumes, in <b>work area</b> can ignite or explode. To help prevent fire and explosion:</p> <ul style="list-style-type: none"> <li>• Use equipment only in well ventilated area.</li> <li>• Eliminate all ignition sources; such as pilot lights, cigarettes, portable electric lamps, and plastic drop cloths (potential static arc).</li> <li>• Keep work area free of debris, including solvent, rags and gasoline.</li> <li>• Do not plug or unplug power cords, or turn power or light switches on or off when flammable fumes are present.</li> <li>• Ground all equipment in the work area.</li> <li>• Use only grounded hoses.</li> <li>• Hold gun firmly to side of grounded pail when triggering into pail.</li> <li>• If there is static sparking or you feel a shock, <b>stop operation immediately</b>. Do not use equipment until you identify and correct the problem.</li> <li>• Keep a working fire extinguisher in the work area.</li> </ul>
	<p><b>SPECIAL CONDITIONS FOR SAFE USE</b></p> <ul style="list-style-type: none"> <li>• To prevent the risk of electrostatic sparking, the equipment's non-metallic parts must be cleaned with only a damp cloth.</li> <li>• Refer to the Viscon HP Heater manual for special conditions for safe use.</li> </ul>
	<p><b>ELECTRIC SHOCK HAZARD</b></p> <p>Improper grounding, setup, or usage of the system can cause electric shock.</p> <ul style="list-style-type: none"> <li>• Turn off and disconnect power at main switch before disconnecting any cables and before servicing equipment.</li> <li>• Connect only to grounded power source.</li> <li>• All electrical wiring must be done by a qualified electrician and comply with all local codes and regulations.</li> </ul>
	<p><b>SKIN INJECTION HAZARD</b></p> <p>High-pressure fluid from gun, 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. <b>Get immediate surgical treatment.</b></p> <ul style="list-style-type: none"> <li>• Do not point gun at anyone or at any part of the body.</li> <li>• Do not put your hand over the spray tip.</li> <li>• Do not stop or deflect leaks with your hand, body, glove, or rag.</li> <li>• Do not spray without tip guard and trigger guard installed.</li> <li>• Engage trigger lock when not spraying.</li> <li>• Follow <b>Pressure Relief Procedure</b> in this manual, when you stop spraying and before cleaning, checking, or servicing equipment.</li> </ul>

 <b>WARNING</b>	
	<p><b>PRESSURIZED EQUIPMENT HAZARD</b></p> <p>Fluid from the gun/dispense valve, leaks, or ruptured components can splash in the eyes or on skin and cause serious injury.</p> <ul style="list-style-type: none"> <li>• Follow <b>Pressure Relief Procedure</b> in this manual, when you stop spraying and before cleaning, checking, or servicing equipment.</li> <li>• Tighten all fluid connections before operating the equipment.</li> <li>• Check hoses, tubes, and couplings daily. Replace worn or damaged parts immediately.</li> </ul>
	<p><b>MOVING PARTS HAZARD</b></p> <p>Moving parts can pinch or amputate fingers and other body parts.</p> <ul style="list-style-type: none"> <li>• Keep clear of moving parts.</li> <li>• Do not operate equipment with protective guards or covers removed.</li> <li>• Pressurized equipment can start without warning. Before checking, moving, or servicing equipment, follow the <b>Pressure Relief Procedure</b> in this manual. Disconnect power or air supply.</li> </ul>
	<p><b>EQUIPMENT MISUSE HAZARD</b></p> <p>Misuse can cause death or serious injury.</p> <ul style="list-style-type: none"> <li>• Do not operate the unit when fatigued or under the influence of drugs or alcohol.</li> <li>• Do not exceed the maximum working pressure or temperature rating of the lowest rated system component. See <b>Technical Data</b> in all equipment manuals.</li> <li>• Use fluids and solvents that are compatible with equipment wetted parts. See <b>Technical Data</b> in all equipment manuals. Read fluid and solvent manufacturer's warnings. For complete information about your material, request MSDS forms from distributor or retailer.</li> <li>• Check equipment daily. Repair or replace worn or damaged parts immediately with genuine manufacturer's replacement parts only.</li> <li>• Do not alter or modify equipment.</li> <li>• Use equipment only for its intended purpose. Call your distributor for information.</li> <li>• Route hoses and cables away from traffic areas, sharp edges, moving parts, and hot surfaces.</li> <li>• Do not kink or over bend hoses or use hoses to pull equipment.</li> <li>• Keep children and animals away from work area.</li> <li>• Comply with all applicable safety regulations.</li> </ul>
	<p><b>TOXIC FLUID OR FUMES HAZARD</b></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"> <li>• Read MSDS's to know the specific hazards of the fluids you are using.</li> <li>• Store hazardous fluid in approved containers, and dispose of it according to applicable guidelines.</li> <li>• Always wear impervious gloves when spraying or cleaning equipment.</li> </ul>
	<p><b>BURN HAZARD</b></p> <p>Equipment surfaces and fluid that's heated can become very hot during operation. To avoid severe burns, do not touch hot fluid or equipment. Wait until equipment/fluid has cooled completely.</p>
	<p><b>PERSONAL PROTECTIVE EQUIPMENT</b></p> <p>You must wear appropriate protective equipment when operating, servicing, or when in the operating area of the equipment to help protect you from serious injury, including eye injury, inhalation of toxic fumes, burns, and hearing loss. This equipment includes but is not limited to:</p> <ul style="list-style-type: none"> <li>• Protective eyewear</li> <li>• Clothing and respirator as recommended by the fluid and solvent manufacturer</li> <li>• Gloves</li> <li>• Hearing protection</li> </ul>

# Models

						
XM OEM sprayers are not approved for use in hazardous locations.						

Use the following matrix to define the construction of the sprayer, based on the six digits. For example, Part **XMEA00** represents an XM Plural-Component OEM sprayer (**XM**); 5200 psi pump set with pump filters (**E**); wall power supply that is not approved for hazardous areas (**A**).

**NOTE:**

To order replacement parts, see Parts section the XM Plural-Component Sprayer Repair-Parts manual 313289. The digits in the matrix do not correspond to the Ref. Nos. in the Parts drawings and lists.

XM	E			A		00	
First and Second Digits	Third Digit			Fourth Digit		Fifth and Sixth Digits	
	System Choice (See Table 1 for lower models)			Control Box Choice			
		Pump Set (hose/gun)	Pump Filters	Remote Manifold		Control Box	Always 00
XM (OEM plural component sprayer without a frame)	<b>A</b>	no pumps			<b>A</b>	Wall Power Supply	
	<b>B</b>	no pumps		✓	<b>D</b>	Alternator	
	<b>E</b>	5200 psi	✓				
	<b>F</b>	5200 psi					
	<b>G</b>	6300 psi	✓				
	<b>H</b>	6300 psi					

**Table 1: Lower Models and Corresponding Identification Codes**

Code	System Pressure (MPa, bar)	Pump Filters	A Lower (see manual 311762)	B Lower (see manual 311762)
<b>E</b>	5200 psi (35, 350)	✓	L250C4	L220C4
<b>F</b>	5200 psi (35, 350)		L250C3	L220C3
<b>G</b>	6300 psi (49, 490)	✓	L180C4	L145C4
<b>H</b>	6300 psi (49, 490)		L180C3	L145C3

**NOTE:**

See **Accessories and Kits**, page 25, for a list of available accessories and kits.

# Overview

## Usage

XM plural-component sprayers can mix and spray most two-component epoxy and urethane protective coatings. When using quick-setting materials (less than 10 minute pot life) a remote mix manifold must be used.

XM plural-component sprayers are operated via user interface, air controls, and fluid controls.

						
XM OEM sprayers are not approved for use in hazardous locations.						

## Isocyanate Hazard

						
<p>Spraying materials containing isocyanates creates potentially harmful mists, vapors, and atomized particulates.</p> <p>Read material manufacturer’s warnings and material MSDS to know specific hazards and precautions related to isocyanates.</p> <p>Prevent inhalation of isocyanate mists, vapors, and atomized particulates by providing sufficient ventilation in the work area. If sufficient ventilation is not available, a supplied-air respirator is required for everyone in the work area.</p> <p>To prevent contact with isocyanates, appropriate personal protective equipment, including chemically impermeable gloves, boots, aprons, and goggles, is also required for everyone in the work area.</p>						

## Material Self-Ignition

						
Some materials may become self-igniting if applied too thick. Read material manufacturer’s warnings and material MSDS.						

## Moisture Sensitivity of Isocyanates

Isocyanates (ISO) are catalysts used in two component urethane coatings. ISO will react with moisture (such as humidity) to form small, hard, abrasive crystals, which become suspended in the fluid. Eventually a film will form on the surface and the ISO will begin to gel, increasing in viscosity. If used, this partially cured ISO will reduce performance and the life of all wetted parts.

**NOTE:**

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

To prevent exposing ISO to moisture:

- Always use a sealed container with a desiccant dryer in the vent, or a nitrogen atmosphere. **Never** store ISO in an open container.
- Use moisture-proof hoses specifically designed for ISO, such as those supplied with your system.
- Never use reclaimed solvents, which may contain moisture. Always keep solvent containers closed when not in use.
- Never use solvent on one side if it has been contaminated from the other side.
- Always park pumps when you shutdown.
- Always lubricate threaded parts with Part 217374 ISO pump oil or grease when reassembling.

## Components A and B

### IMPORTANT!

Material suppliers can vary in how they refer to plural component materials.

Be aware that in this manual:

*Component A* refers to resin or major volume.

*Component B* refers to the hardener or minor volume.

### NOTE:

This equipment doses the B component into the A component flow. An integration hose must always be used after the mix manifold and before the static mixer.

### NOTE:

Please follow these recommendations for setup:

- use at least a 3/8 in. (10 mm) x 25 ft. (7 m) hose as the integration hose.
- install a 24-element static mix tube after the integration hose.

## Keep Components A and B Separate

### NOTICE

To prevent cross-contamination of the equipment's wetted parts, **never** interchange component A (resin) and component B (hardener) parts.

## Changing Materials

- When changing materials, flush the equipment multiple times to ensure it is thoroughly clean.
- Always clean the fluid inlet strainers and outlet filter after flushing, **Flush Mixed Material**, page 16.
- Check with your material manufacturer for chemical compatibility.
- Epoxies often have amines on the B (hardener) side. Polyureas often have amines on the A (resin) side.

### NOTE:

If the amine will switch between the two sides, see **Flush Mixed Material**, page 16.

## Location



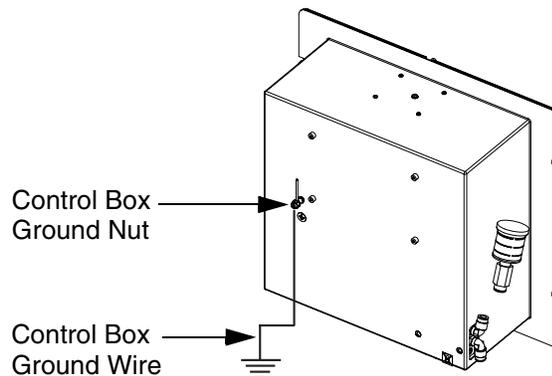
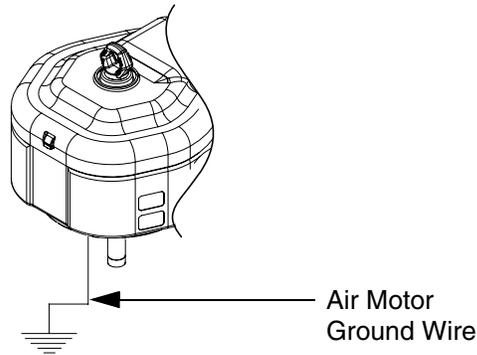
## Grounding



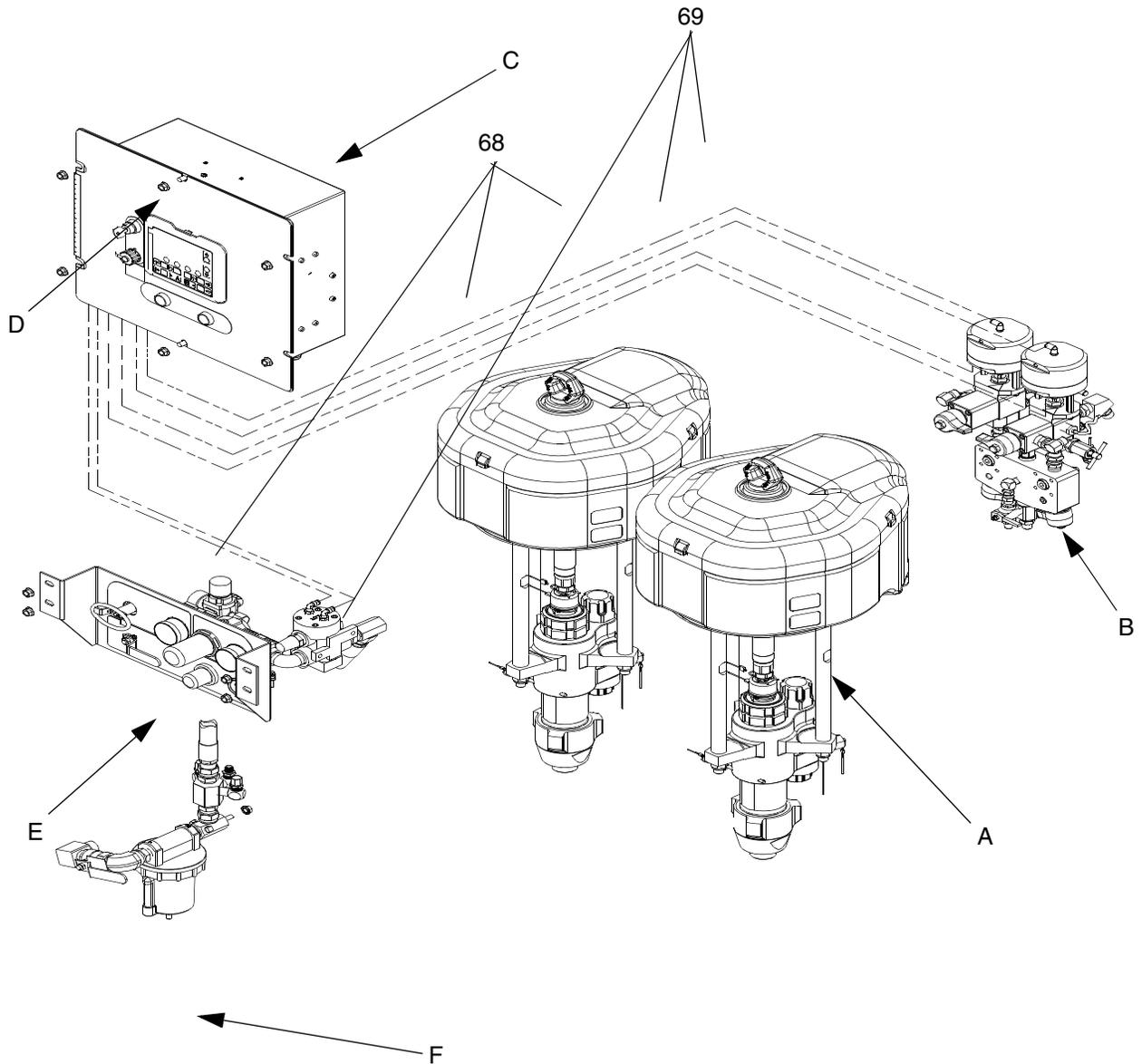
Ground control box (ground wire attached) and both air motors to a true earth ground.

### NOTE:

If wall power is used, ground electrical connection properly according to local codes.



# Component Identification



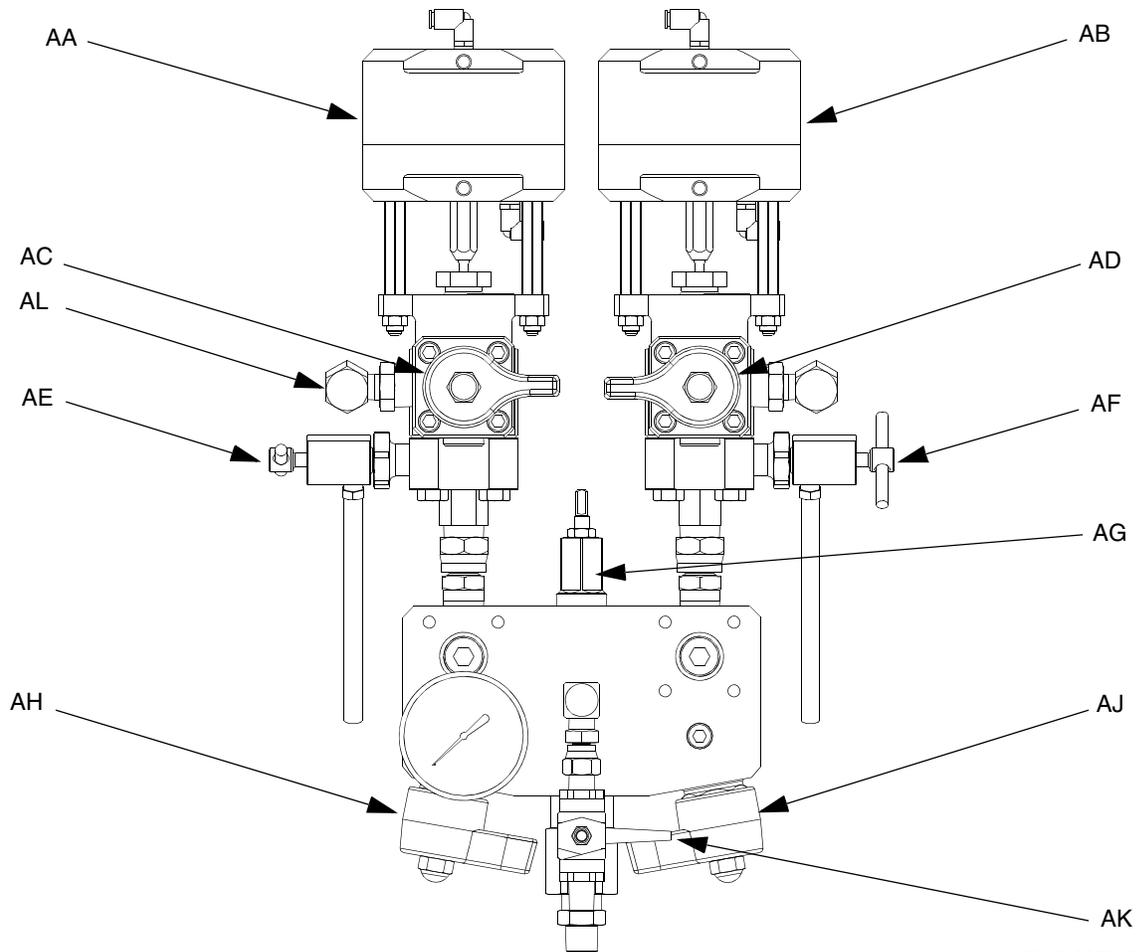
**FIG. 1: Typical OEM Sprayer Components**

**Key:**

- A Pump Assembly
- B Fluid Control Assembly (see **Fluid Control Assembly**, page 10)
- C Control Box
- D User Interface Display (see **User Interface Display**, page 13)

- E Air Controls (see **Air Controls**, page 11)
- F Air Inlet Manifold Assembly
- 68 Air Line
- 69 Air Line

## Fluid Control Assembly

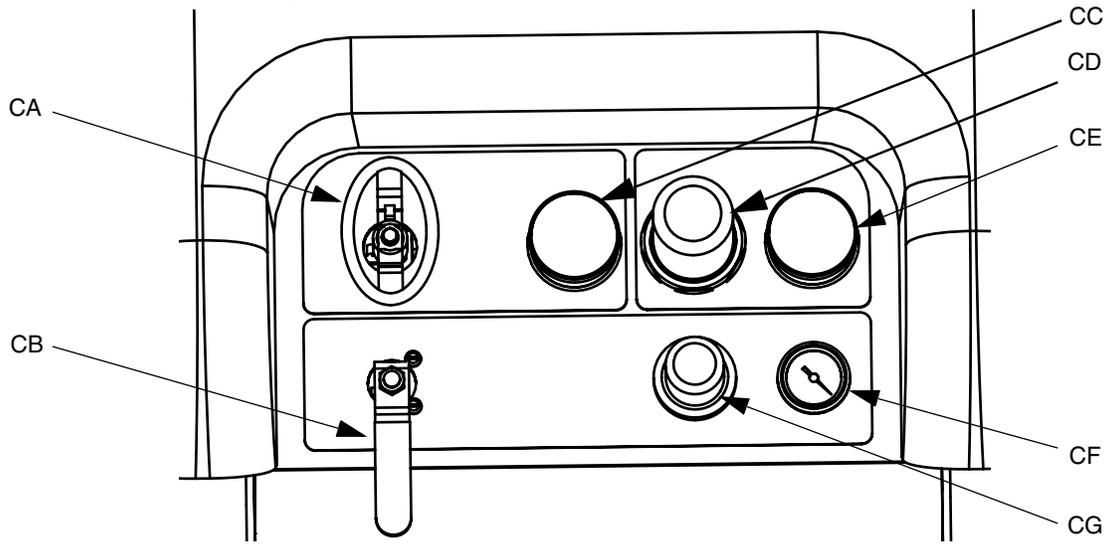


r\_XM1A00\_312359\_313289\_18A

**FIG. 2: Fluid Control Assembly**

- |                          |   |
|--------------------------|---|
| AA Dosing Valve A        | AF Sampling Valve B                     |
| AB Dosing Valve B        | AG Restriction Valve                    |
| AC Recirculation Valve A | AH Mix Manifold Shutoff / Check Valve A |
| AD Recirculation Valve B | AJ Mix Manifold Shutoff / Check Valve B |
| AE Sampling Valve A      | AK Solvent Shutoff Valve                |
|                          | AL Pressure Sensor (hidden)             |

## Air Controls



r\_XM1A00\_312359\_313289\_14A

**FIG. 3: Air Controls**

CA Main Pump and Air On/Off Control  
CB Solvent Pump Air On/Off Control  
CC Inlet Air Pressure Gauge  
CD Main Pump Air Regulator

CE Main Pump Air Regulator Gauge  
CF Solvent Pump Air Gauge  
CG Solvent Pump Air Regulator

# User Interface

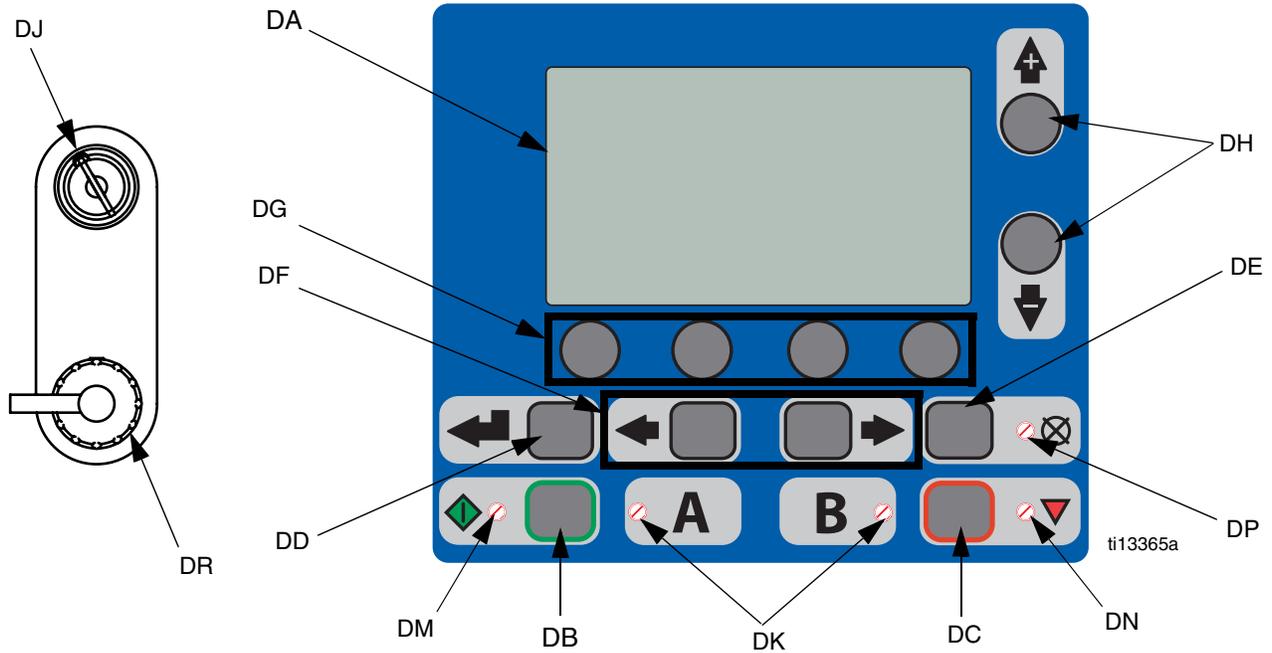


FIG. 4: User Interface

## Buttons

Call out	Button	Function
DA	Display Screen	Use to view GCA display. Ratio, Mode Selection, Error Conditions, Totalizers, System Information.
DB	Start	Initiates Active Run Mode function currently selected in Run Screen.
DC	Stop	Terminates Active Run Mode function currently selected.
DD	Enter	Press to open drop-down fields, selection options, and save values.
DE	Alarm Reset	Resets alarms and advisories.
DF	Left/Right	Move between screens in run or setup modes.
DG	Function	Activates mode or action represented by the icon above each of the four buttons in the LCD.
DH	Up/Down	Move between selection boxes, drop-down fields, and selectable values within Setup screens.
DJ	Setup Key Lock	Change ratio or enter Setup mode.
DR	USB Port	Connection for data download. Use only in non-hazardous areas.

## LEDs

There are four types of LEDs on the display.

Call out	LED	Function
DK	Blue	Dosing valve active <ul style="list-style-type: none"> <li>on - dosing valve is active</li> <li>off - dosing valve is not active</li> </ul>
DM	Green	Spray mode active <ul style="list-style-type: none"> <li>selected mode is on (active)</li> <li>selected mode is off (inactive)</li> </ul>
DN	Red	Alarm <ul style="list-style-type: none"> <li>on - alarm is present</li> <li>off - no alarm</li> </ul>
DP	Yellow	Warning <ul style="list-style-type: none"> <li>on - is active.</li> <li>off - no warning indicated. Ratio and setup fields are not changeable.</li> <li>flashing - key is present and turned. Ratio and setup fields are changeable.</li> </ul>

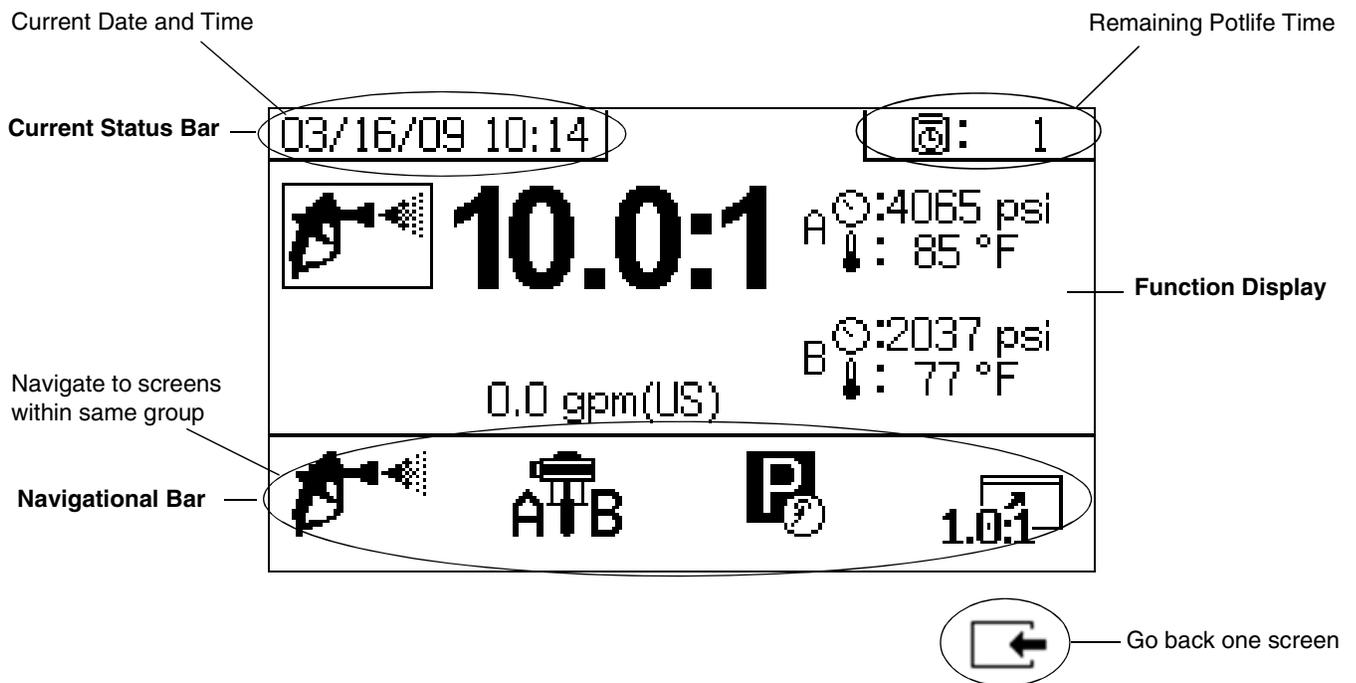
## User Interface Display

**NOTE:**

For details regarding the user interface display see the XM Plural-Component Sprayer operation manual 312359.

### Main Display Screen Components

The following figure calls out the navigational, status, and general informational components of each display screen.



**FIG. 5: Main Display Screen Components**

# Pressure Relief Procedure

<p>Follow <b>Flush Mixed Material</b> procedure prior to relieving pressure.</p> <p>Follow <b>Pressure Relief Procedure</b> when you stop spraying or dispensing; and before cleaning, checking, servicing, or transporting equipment.</p>						

## Relieve A and B Fluid Pressure

1. Engage trigger lock.



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2. Press Stop

3. If fluid heaters are used, shut them off.
4. Shut off feed pumps, if used.
5. Remove spray tip and clean.
6. Disengage trigger lock.



ti1950a

7. Hold a metal part of the gun firmly to a grounded metal pail with a splash guard in place. Trigger gun to relieve pressure in material hoses.



ti1953a

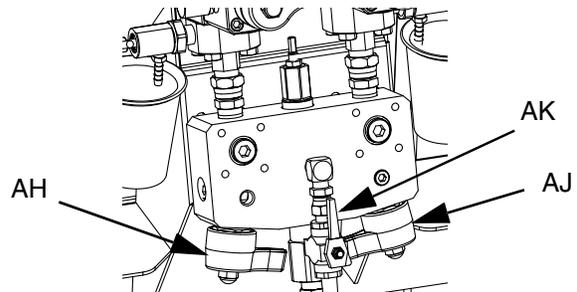
8. Engage trigger lock.



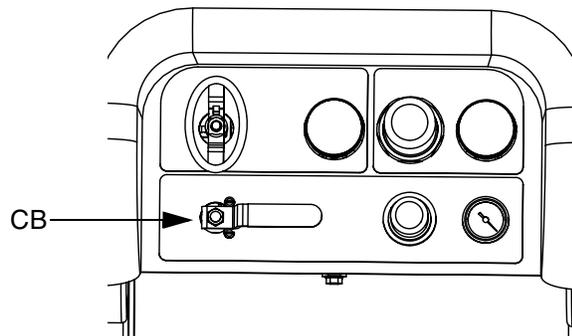
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## Relieve Pump Fluid Pressure and Flush Mix Hose

9. Close mix manifold valves (AH, AJ), then open solvent flush valve (AK) on mix manifold.



10. Open solvent flush ball valve (CB). Use lowest pressure needed to flush material out of hose.

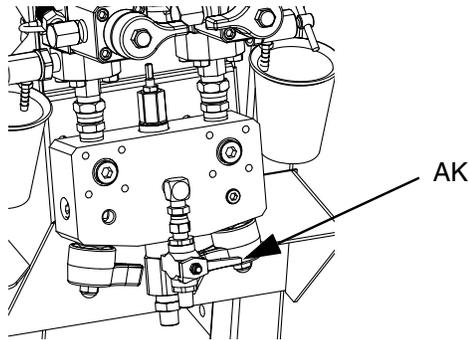


11. Disengage trigger lock.



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12. Hold a metal part of the gun firmly to a grounded metal pail with a splash guard in place. Trigger gun to flush mixed material out of line with clean solvent.
13. Shut off solvent pump air control valve (CB).
14. Repeat steps 11 and 12. Then continue to step 15.
15. Close solvent flush valve (AK) on mix manifold.



16. Release any residual gun pressure and engage trigger lock.



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# Flush Mixed Material



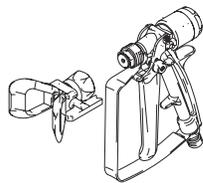
## Flush Mix Manifold

### Use Solvent Pump

1. Press Stop  to turn off system. Engage trigger lock. Remove spray tip.

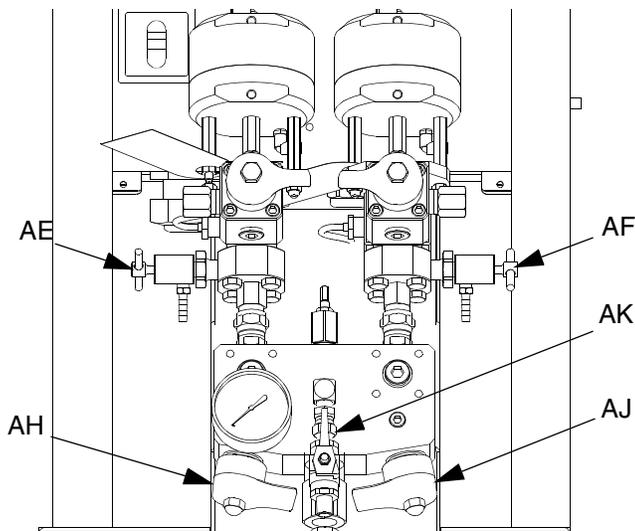


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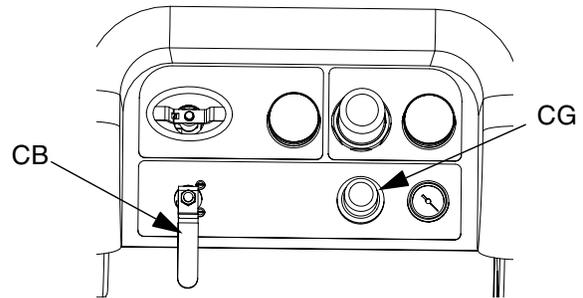


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2. Ensure sampling valves (AE, AF) and mix manifold valves (AH, AJ) are closed.



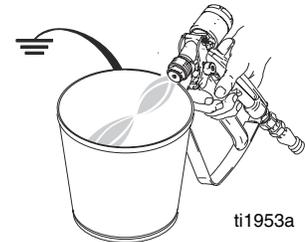
3. Open solvent shutoff valve (AK) at mix manifold.
4. Open solvent pump air valve (CB). Pull out and slowly turn solvent pump air regulator (CG) clockwise to increase air pressure. Use lowest possible pressure.



5. Disengage trigger lock and trigger gun into a grounded pail. Use a pail lid with a hole to dispense through. Seal around hole and gun with a rag to prevent splash back. Be careful to keep fingers away from front of gun. Flush out mixed material until clean solvent dispenses.

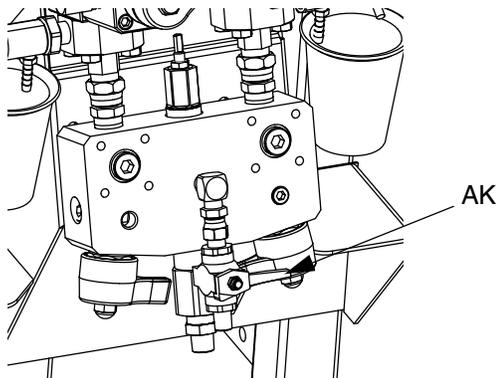


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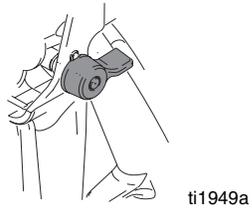


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6. Close solvent pump air valve (CB) and solvent shut-off valve (AK) at mix manifold. Trigger spray gun to relieve pressure.



7. Engage trigger lock.



8. Disassemble and clean spray tip with solvent by hand. Reinstall on gun.

# Installation and Setup

**NOTE:**

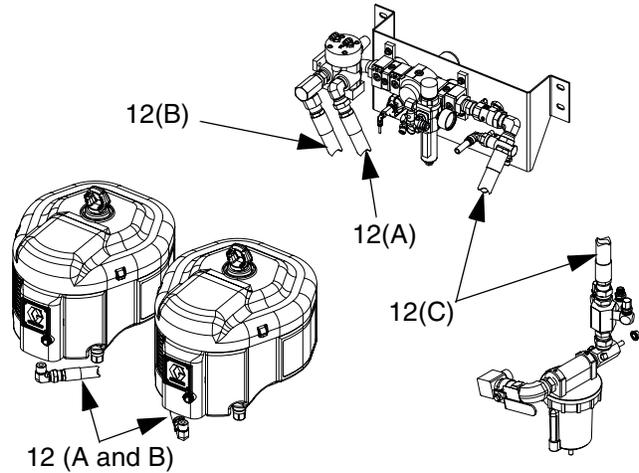
See , page 27, to aid in component installation.

## Connect Air Lines

Refer to component identification in FIG. 1, page 9.  
Refer to the pneumatic schematic drawings in the XM Plural-Component Sprayer repair-parts manual 313289 for guidance.

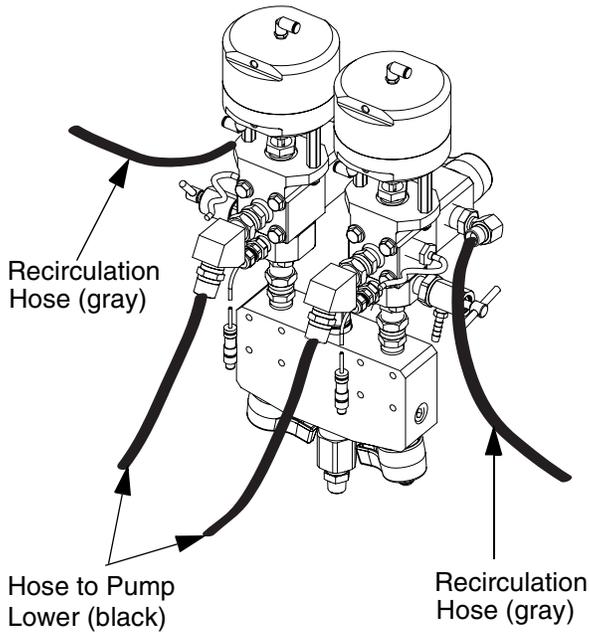
- Connect air lines (68, 69) between the fluid control assembly (B) and the control box (C).
- Connect air lines (68, 69) between the air controls assembly (E) and the control box.

- Connect air hose (12) between air controls assembly and both air motors. (Hose called out has 12(A) and 12 (B)).



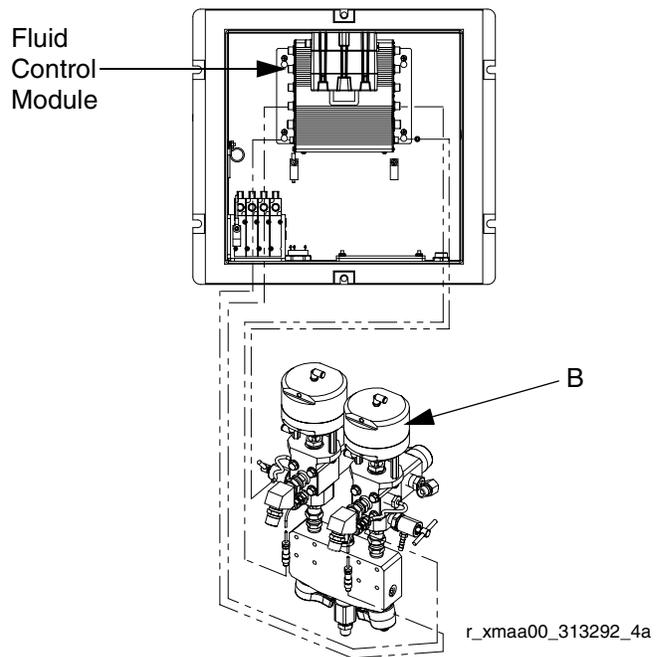
## Connect Fluid Hoses

Use the following illustration as a guide to connect the fluid hoses.



## Connect Sensor Cables

Connect pressure and temperature sensor cables (supplied with fluid control assembly (B)) to the fluid control module.



## Connect Air Hoses

- Connect air hose (12) between air inlet manifold and air controls assembly. (Hose called out as 12(C)).

## Operation

For operation instructions, see XM Plural-Component Sprayer Operation manual 312359.

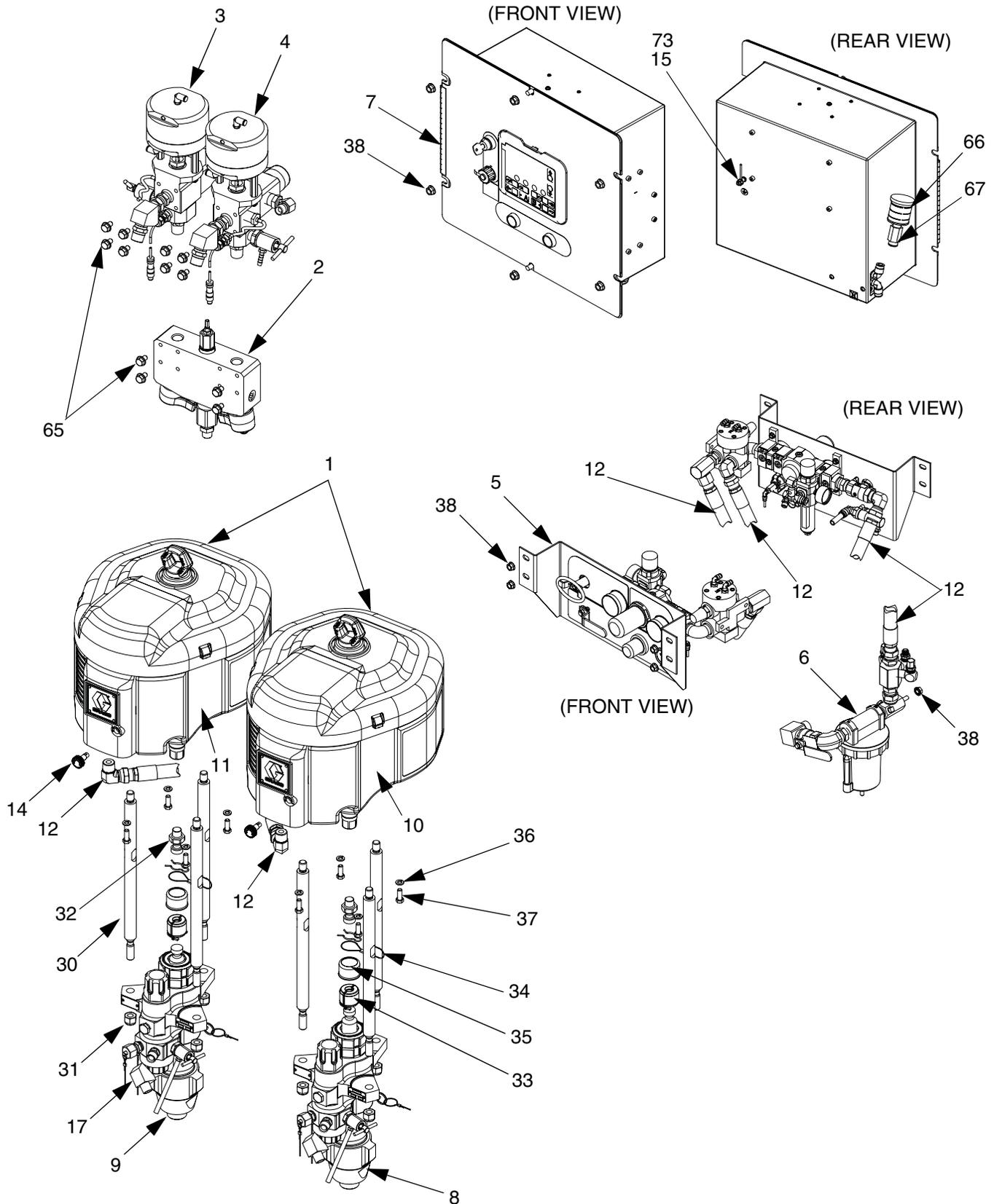
## Repair

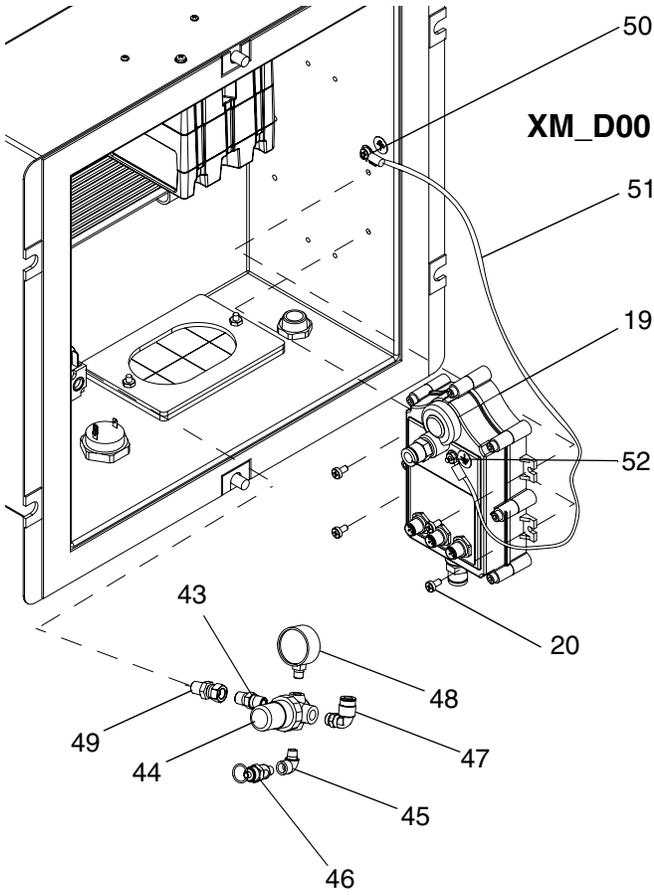
For maintenance, troubleshooting, and repair instructions, see XM Plural-Component Sprayer Repair-Parts manual 313289.

## Schematics

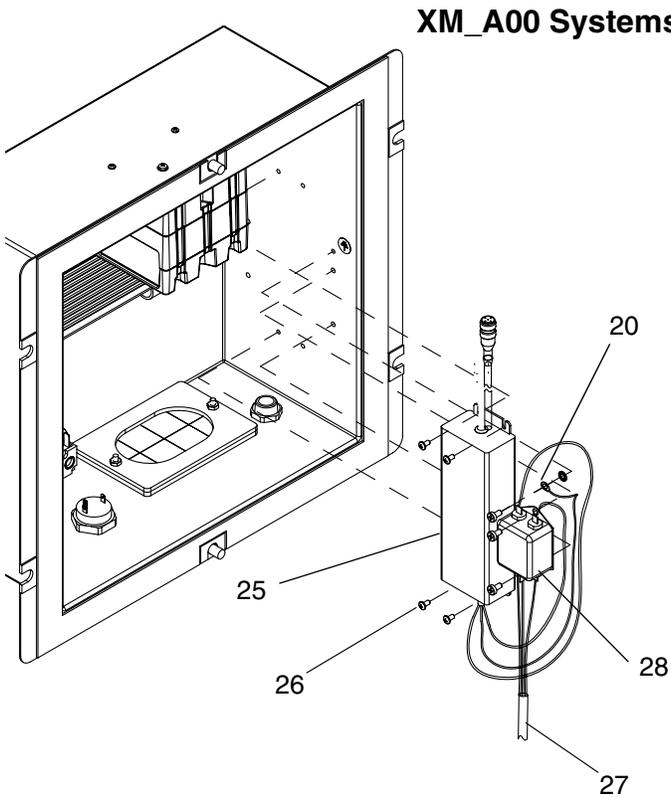
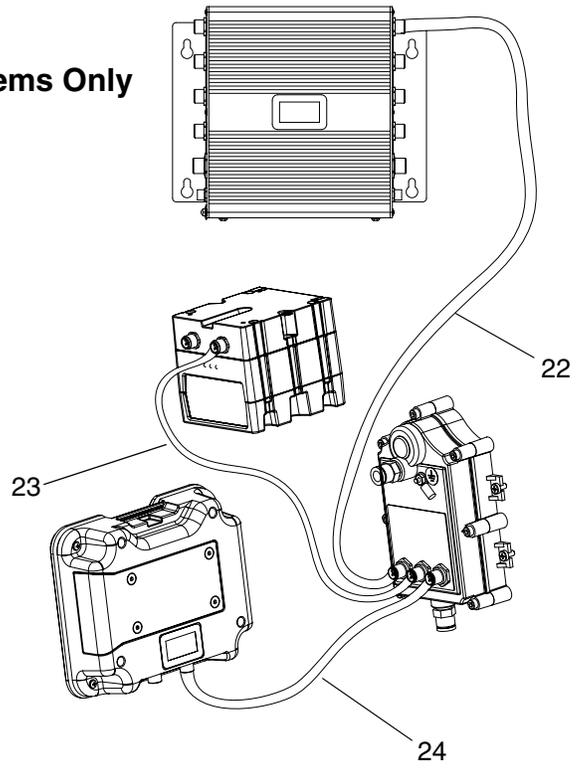
See XM Plural-Component Sprayer Repair-Parts manual 313289 for all electrical schematics.

# Parts

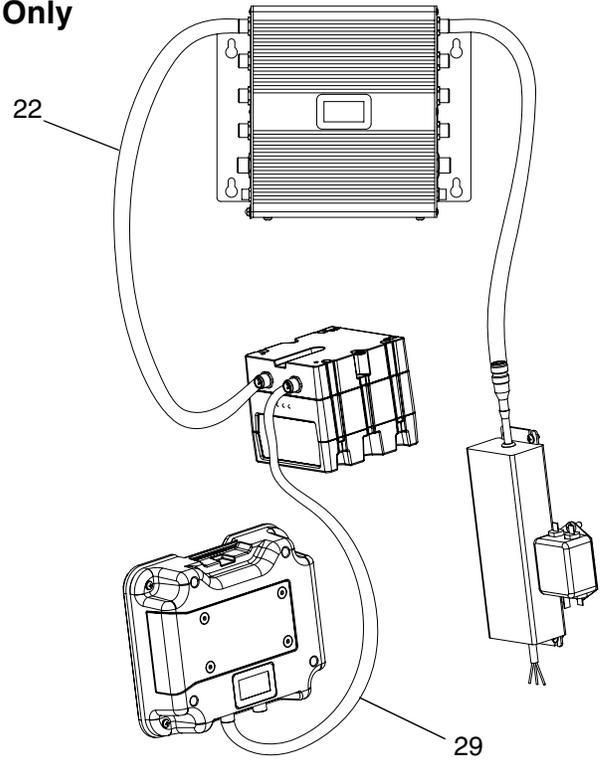




**XM\_D00 Systems Only**



**XM\_A00 Systems Only**





## XME\_00 and XMF\_00 Parts

**NOTE: Reference numbers not listed are not included with XME\_00 and XMF\_00 systems.**

Ref.	Part	Description	Qty	Ref.	Part	Description	Qty
1	257055	MOTOR, 6500, de-icing; see manual 311238	2	40★▲	15X393	LABEL, warning, USB	1
2	255684	MANIFOLD, mix; see manual 313289	1	41★	15X126	LABEL, codes	1
3		VALVE, ratio control, left; see manual 313289	1	42★▲	15W598	LABEL, warning	1
4		VALVE, ratio control, right; see manual 313289	1	43✘	156971	NIPPLE, short	1
5	255761	MODULE, air controls, upper; see manual 313289	1	44✘	115243	REGULATOR, air; 1/4 npt	1
6	255762	MANIFOLD, inlet air distribution; see manual 313289	1	45✘	112307	ELBOW, street; 1/8 nptf x 1/8 nptm	1
7	255771	BOX, control; see manual 313289	1	46✘	15W017	VALVE, safety, regulator	1
8	L250C4	LOWER, Xtreme, 250; see manual 311762	1	47✘	115841	ELBOW, swivel, male; 1/4 npt	1
9	L220C4	LOWER, Xtreme, 220; see manual 311762	1	48✘	104655	GAUGE, pressure, air	1
10	15H652	LABEL, Xtreme, X50	1	49✘	156823	UNION, swivel	1
11	15H654	LABEL, Xtreme, X60	1	50✘	102063	WASHER, lock, ext	1
12	15B554	HOSE, coupled; 48 in.	3	51✘	15B090	WIRE, grounding, door	1
14	NXT102	CONTROL, de-ice, assy	2	52✘	100284	NUT, hex mscr	1
15	119402	CABLE, coiled	2	65	111801	SCREW, cap, hex hd	12
16★	15T258	WRENCH	1	66	108636	MUFFLER	1
17	15M987	ELBOW, 60 degrees	2	67	121688	CONNECTOR; 3/8 npt x 3/8 tube	1
19✘	255728	MODULE, alternator	1	68	054172	TUBE, nylon, 1/4 OD, black; 10 ft; see <b>Component Identification</b> , page 9	
20	110637	SCREW, machine, pan hd XMEA00 and XMFA00 XMED00 and XMFD00	3	69	054757	TUBE, nylon, 1/4 OD natural; 10 ft; see <b>Component Identification</b> , page 9	
21✘★	C12508	TUBING, nylon, round	5	73	238909	WIRE, grounding assy	1
22	15V778	CABLE, I.S. CAN, female/female; 20 in.	1	74★	16A004	FLASH DRIVE, USB, 2.0	1
23✘	15V782	CABLE, I.S. CAN, male/female; 20 in.	1	82★	126786	WRENCH, restrictor	1
24✘	15V783	CABLE, male/female; 39 in.	1				
25✘	15V747	POWER SUPPLY, assy.; 24Vdc, 2.5A, 60W	1				
26✘	100035	SCREW, machine, pan hd	4				
27✘	15X407	CABLE, power	1				
28✘	115306	FILTER, power	1				
29✘	15V779	CABLE, I.S. CAN, female/female; 34 in.	1				
30	257150	ROD, tie	6				
31	101712	NUT, lock; 5/8 in. - 11 unc	6				
32	15H392	ROD, adapter	2				
33	244819	COUPLING, assy	2				
34	244820	CLIP, hairpin with lanyard	2				
35	197340	COVER, coupler	2				
36	100133	WASHER, LOCK; 3/8	8				
37	100101	SCREW, cap, hex hd	8				
38	112958	NUT, hex, flanged	11				
39	160327	UNION, adapter; 90 degrees	2				

- ✘ *Included with XMED00 and XMFD00 systems only.*
- ✘ *Included with XMEA00 and XMFA00 systems only.*
- ★ *Not shown.*
- ▲ *Replacement Danger and Warning labels, tags, and cards are available at no cost.*

## XMG\_00 and XMH\_00 Parts

**NOTE: Reference numbers not listed are not included with XMG\_00 and XMH\_00 systems.**

Ref.	Part	Description	Qty
1	257055	MOTOR, 6500, de-icing; see manual 311238	2
2	255684	MANIFOLD, mix; see manual 313289	1
3		VALVE, ratio control, left; see manual 313289	1
4		VALVE, ratio control, right; see manual 313289	1
5	255761	MODULE, air controls, upper; see manual 313289	1
6	255762	MANIFOLD, inlet air distribution; see manual 313289	1
7	255771	BOX, control; see manual 313289	1
8	L180C4	LOWER, Xtreme, 180; see manual 311762	1
9	L145C4	LOWER, Xtreme, 145; see manual 311762	1
10		LABEL, Xtreme, X70	1
11		LABEL, Xtreme, X90	1
12	15B554	HOSE, coupled; 48 in.	3
14	NXT102	CONTROL, de-ice, assy	2
15	119402	CABLE, coiled	2
16★	15T258	WRENCH	1
17	15M987	ELBOW, 60 degrees	2
19‡	255728	MODULE, alternator	1
20	110637	SCREW, mach, pan hd XMGA00 and XMHA00 XMGD00 and XMHD00	3 5
21‡★	C12508	TUBING, nylon, round	5
22	15V778	CABLE, I.S. CAN, female/female; 20 in.	1
23‡	15V782	CABLE, I.S. CAN, male/female; 20 in.	1
24‡	15V783	CABLE, male/female; 39 in.	1
25◆	15V747	POWER SUPPLY, assy.; 24Vdc, 2.5A, 60W	1
26◆	100035	SCREW, machine, pan hd	4
27◆	15X407	CABLE, power	1
28◆	115306	FILTER, power	1
29◆	15V779	CABLE, I.S. CAN, female/female; 34 in.	1
30	257150	ROD, tie	6
31	101712	NUT, lock; 5/8 in. - 11 unc	6
32	15H392	ROD, adapter	2
33	244819	COUPLING, assy	2
34	244820	CLIP, hairpin with lanyard	2
35	197340	COVER, coupler	2
36	100133	WASHER, LOCK; 3/8	8
37	100101	SCREW, cap, hex hd	8
38	112958	NUT, hex, flanged	11
39	160327	UNION, adapter; 90 degrees	2

Ref.	Part	Description	Qty
40★▲	15X393	LABEL, warning, USB	1
41★	15X126	LABEL, codes	1
42★▲	15W598	LABEL, warning	1
43‡	156971	NIPPLE, short	1
44‡	115243	REGULATOR, air; 1/4 npt	1
45‡	112307	ELBOW, street; 1/8 nptf x 1/8 nptm	1
46‡	15W017	VALVE, safety, regulator	1
47‡	115841	ELBOW, swivel, male; 1/4 npt	1
48‡	104655	GAUGE, pressure, air	1
49‡	156823	UNION, swivel	1
50‡	102063	WASHER, lock, ext	1
51‡	15B090	WIRE, grounding, door	1
52‡	100284	NUT, hex mscr	1
65	111801	SCREW, cap, hex hd	12
66	108636	MUFFLER	1
67	121688	CONNECTOR; 3/8 npt x 3/8 tube	1
68	054172	TUBE, nylon, 1/4 OD, black; 10 ft; see <b>Component Identification</b> , page 9	
69	054757	TUBE, nylon, 1/4 OD natural; 10 ft; see <b>Component Identification</b> , page 9	
73	238909	WIRE, grounding assy	1
74★	16A004	FLASH DRIVE, USB, 2.0	1
82★	126786	WRENCH, restrictor	1

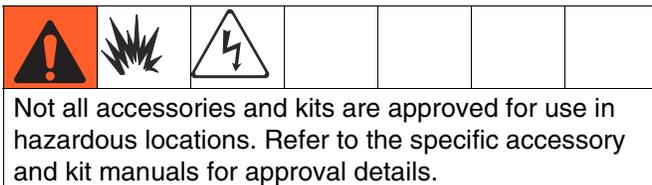
‡ Included with XMGD00 and XMHD00 systems only.

◆ Included with XMGA00 and XMHA00 systems only.

★ Not shown.

▲ Replacement Danger and Warning labels, tags, and cards are available at no cost.

## Accessories and Kits



### 20-Gallon Hopper Kit, 255963

One complete double-wall 20-gallon hopper. See manual 312747 for more information.

### Hopper Heater Kit (240V), 256257

For heating fluid in a 20-gallon hopper. See manual 312747 for more information.

### T2 Feed Pump Kit, 256275

For supplying viscous material from a 20-gallon hopper to an XM sprayer. See manual 312769 for more information.

### 5:1 Feed Pump Kit, 256255

For supplying viscous materials from a 20-gallon hopper to an XM sprayer. See manual 312769 for more information.

### 7-Gallon Hopper and Bracket Kit, 256260

One 7-gallon hopper and mounting brackets. Mounts to the side or back of an XM sprayer. See manual 406999 for more information.

### 2:1 Drum Feed Kit, 256232

One T2 pump feed kit and one Twistork agitator kit for mixing and supplying viscous materials from a with 55-gallon drum to an XM sprayer. See manual 312769 for more information.

### 5:1 Drum Feed Kit, 256276

One 5:1 pump feed kit and one Twistork agitator kit for mixing and supplying viscous materials from a with 55-gallon drum to an XM sprayer. See manual 312769 for more information.

### Hopper/Hose Heat Circulation Kit, 256273

For circulating heated water through 20-gallon hoppers, heated hose, and Viscon HP heater. See manual 313259 for more information.

### Desiccant Dryer Kit, 256512

For use with 20-gallon hoppers. See manual 406739 for more information.

### Lower Strainer and Valve Kit, 256653

For straining material from a feed pump to an XM sprayer fluid inlet. See manual 312770 for more information.

### Electric Heated Hose Power Supply Kit, 256876

For monitoring and controlling fluid temperature in low-voltage heated hoses. See manual 313258 for more information.

### **5000 psi Two-Component Main Heated Hose Set Kit**

Electric heated hose set for adding additional sections.

<b>Part</b>	<b>Description</b>
248907	Heated hose set; 1/4 in. ID x 3/8 in. ID; 50 ft.
248908	Heated hose set; 3/8 in. ID x 3/8 in. ID; 50 ft.

### **10:1 Drum Feed Kit, 256433**

For supplying highly viscous material from a 55-gallon drum to an XM sprayer. See manual 312769 for more information.

### **Shutoff/Check Valve Kit, 255278**

For replacing shutoff valve or check valve. See manual 313343 for more information.

### **Alternator Conversion Kit, 256991**

For converting an XM sprayer from wall power supply to intrinsically safe alternator power supply. See manual 313293 for more information.

### **Mix Manifold Kit, 255684**

See manual 312749 for more information.

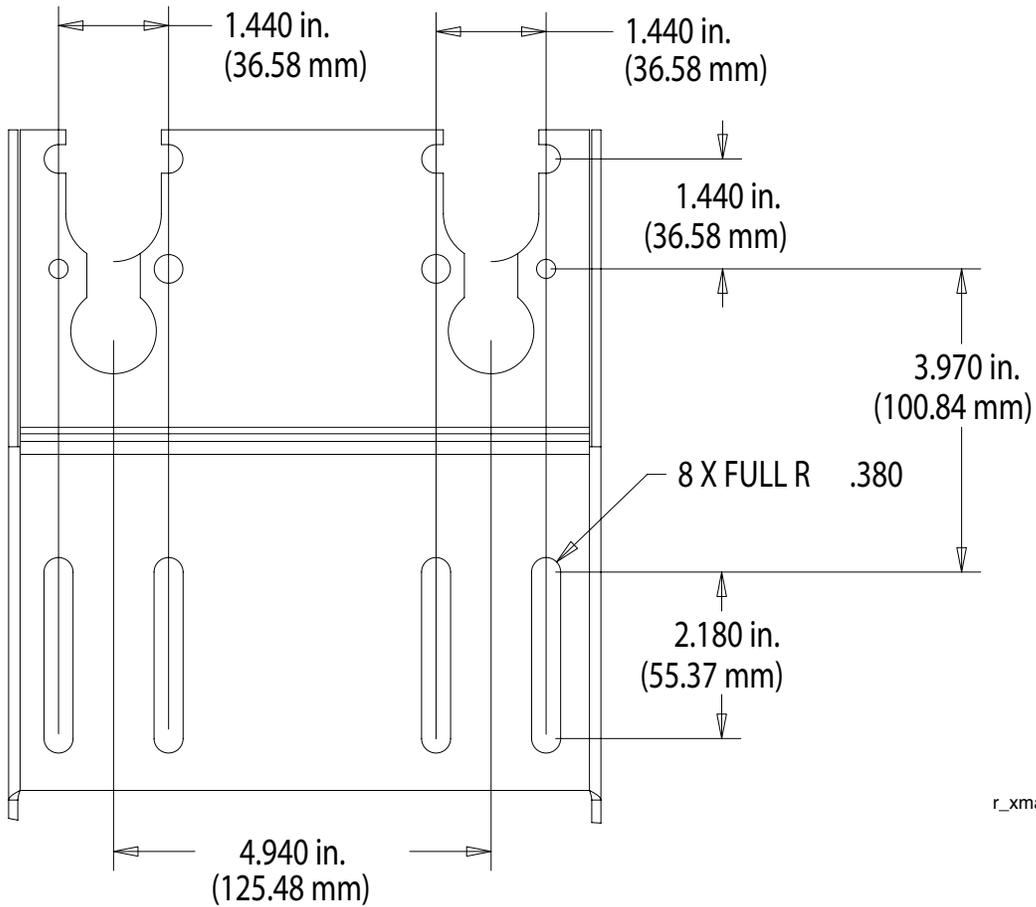
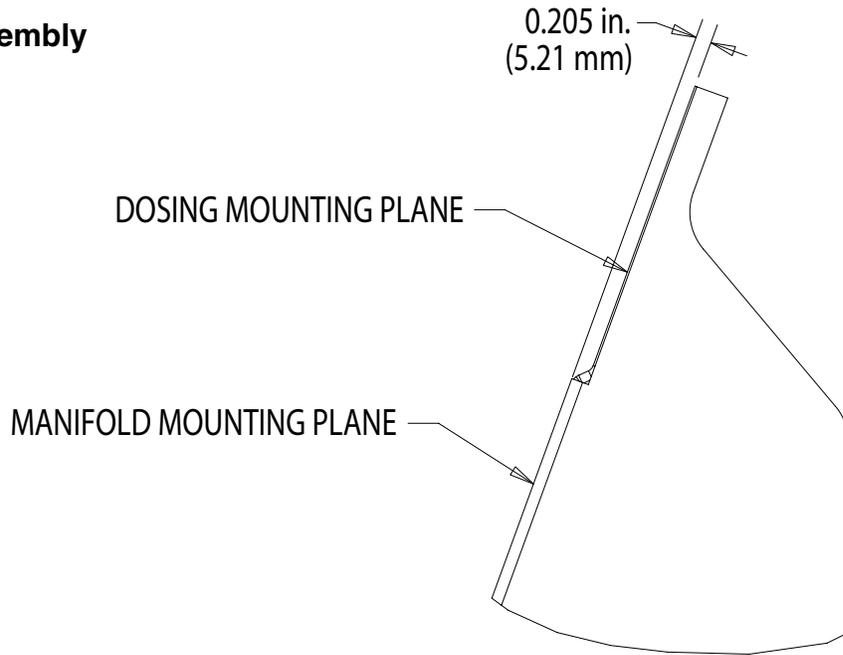
### **Remote Mix Manifold and Carriage Kit, 256980**

For converting to a remote mix manifold kit with a protective guard. See manual 312749 for more information.



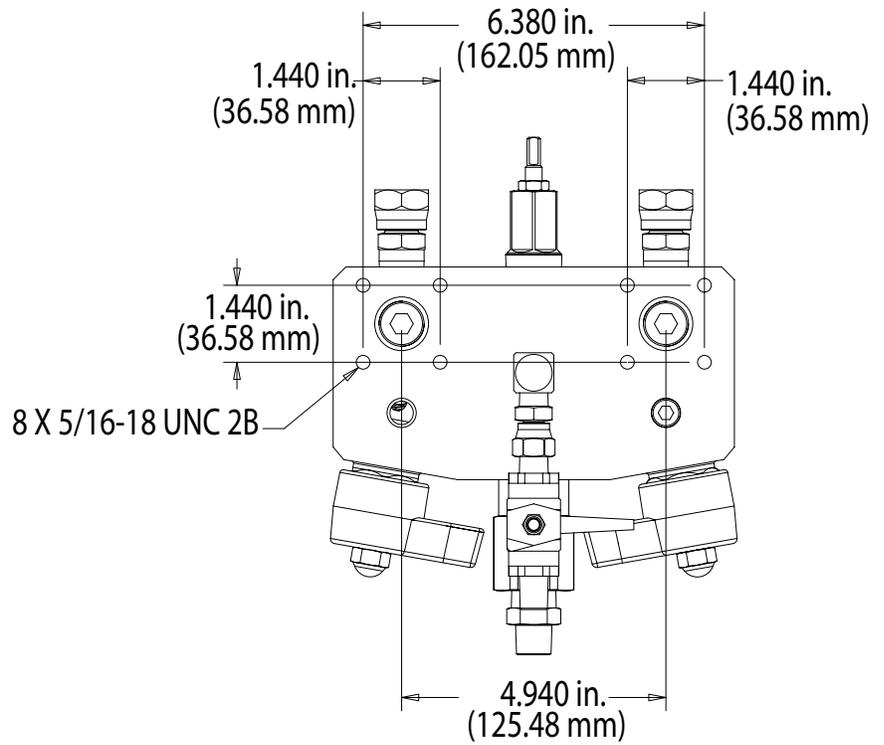
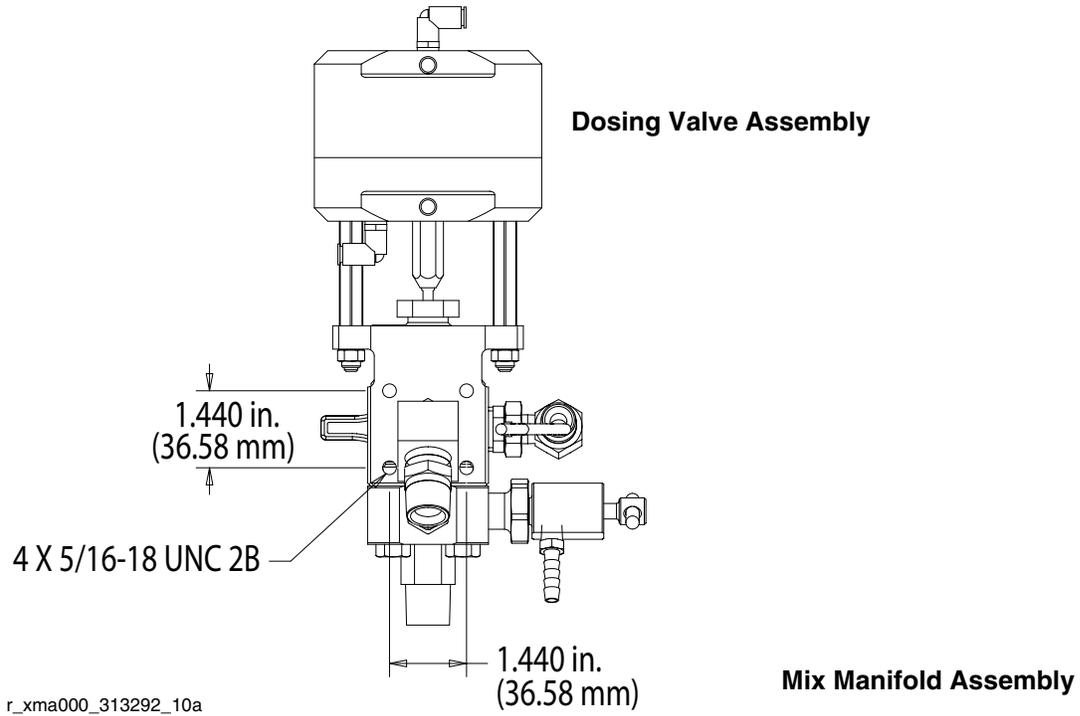
# Dimensions

## Fluid Control Assembly Mounting Plate

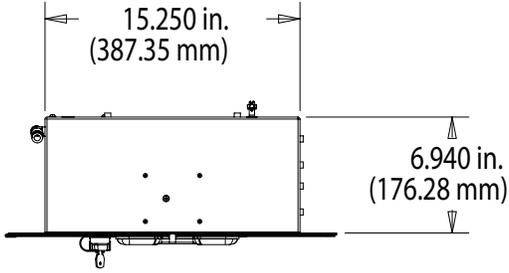


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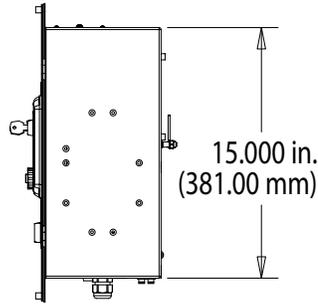
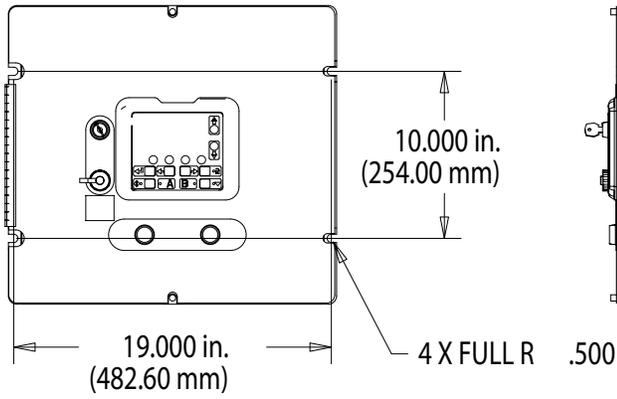
### Fluid Control Assembly



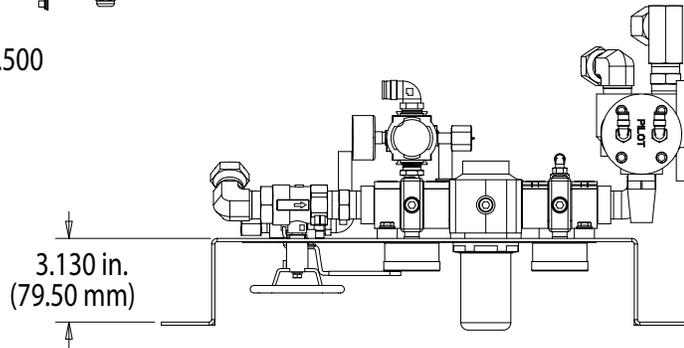
Dimensions



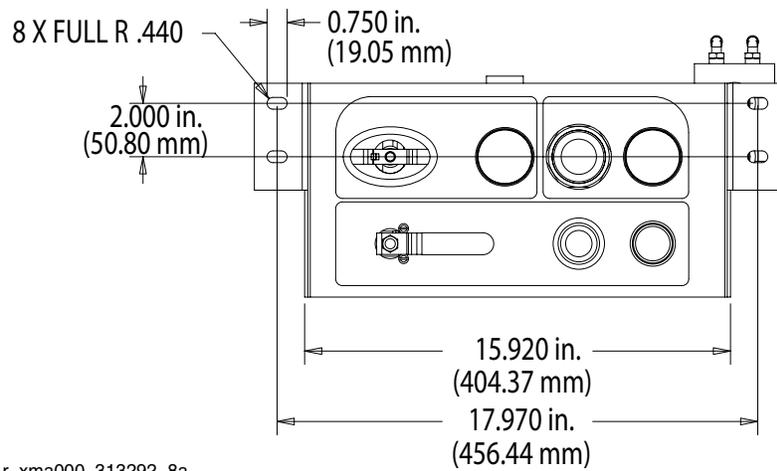
**Control Box Assembly**



r\_xma000\_313292\_7a



**Air Control Assembly**



r\_xma000\_313292\_8a

# Technical Data

Mixed ratio range . . . . .	1:1-10:1 (in 0.1 increments)
Ratio tolerance range . . . . .	+/- 5%
Flow rates	
Minimum . . . . .	1 qt./min. (0.95 liter/min.)*
Maximum . . . . .	3 gal./min/ (11.4 liter/min.)
Fluid viscosity range . . . . .	200-20,000 cps (heavier viscosities can be mixed using heat, circulation, and/or pressure feeding)
Fluid filtration . . . . .	60 mesh, (238 micron) standard on pump outlets (filter assembly not included on some models)
Air inlet . . . . .	3/4 npt(f)
Fluid inlets without feed kits . . . . .	1 1/4 npt(m)
Maximum fluid working pressure of mixed material	
50:1 . . . . .	5200 psi (35.8 MPa, 358 bar)
70:1 . . . . .	6300 psi (43.5 MPa, 435 bar)
Maximum fluid temperature . . . . .	160° F (71° C)
Air supply pressure range . . . . .	50-150 psi (0.35-1.0 MPa, 3.5-10.3 bar)
Maximum pump air set pressure	
50:1 . . . . .	100 psi (0.7 MPa, 7.0 bar)
70:1 . . . . .	90 psi (0.62 MPa, 6.2 bar)
Maximum pump inlet fluid feed pressure . . . . .	250 psi (1.7 MPa, 17 bar)
Maximum air consumption at 100 psi (0.7 MPa, 7.0 bar) in scfm (m <sup>3</sup> /min.) . . . . .	70 scfm per gpm (1.96 m <sup>3</sup> /min. per lpm)
Ambient temperature range	
Operating . . . . .	32-135° F (0-57° C)
Storage . . . . .	30-160° F (-1-71° C)
Environmental conditions rating . . . . .	Indoor/outdoor use Altitude up to 4000 m Maximum relative humidity to 99% up to 130° F (54° C) Pollution degree (11) Installation category (2)
Sound pressure . . . . .	86 dBA at 100 psi (0.7 MPa, 7 bar)
Sound power . . . . .	98 dBA at 100 psi (0.7 MPa, 7 bar)
Wetted parts	
Suction tubes . . . . .	aluminum
Flush pump . . . . .	carbide, PTFE, stainless steel, UHMWPE
Hoses . . . . .	nylon
Pumps (A and B) . . . . .	carbon steel, alloy steel, 303, 440, 17-ph grades stainless steel, zinc and nickel plating, ductile iron, tungsten carbide, PTFE, leather
Metering valves . . . . .	carbon steel, nickel plating, carbide, polyethylene, leather
Manifold . . . . .	carbon steel, nickel plating, carbide, 302 stainless steel, PTFE, UHMWPE
Mixer . . . . .	stainless steel housing with acetal elements
Spray gun . . . . .	Refer to spray gun manual

\* Minimum flow rate is dependent on material being sprayed and mixing capability. Test your material specific to flow rate.

# Graco Standard Warranty

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 a period of twelve months 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.

This warranty does not cover, and Graco shall not be liable for general wear and tear, or any malfunction, damage or wear caused by faulty installation, misapplication, abrasion, corrosion, inadequate or improper maintenance, negligence, accident, tampering, or substitution of non-Graco component parts. Nor shall Graco be liable for malfunction, damage or wear caused by the incompatibility of Graco equipment with structures, accessories, equipment or materials not supplied by Graco, or the improper design, manufacture, installation, operation or maintenance of structures, accessories, equipment or materials not supplied by Graco.

This warranty is conditioned upon the prepaid return of the equipment claimed to be defective to an authorized Graco distributor for verification of the claimed defect. If the claimed defect is verified, Graco will repair or replace free of charge any defective parts. The equipment will be returned to the original purchaser transportation prepaid. If inspection of the equipment does not disclose any defect in material or workmanship, repairs will be made at a reasonable charge, which charges may include the costs of parts, labor, and transportation.

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In no event will Graco be liable for indirect, incidental, special or consequential damages resulting from Graco supplying equipment hereunder, or the furnishing, performance, or use of any products or other goods sold hereto, whether due to a breach of contract, breach of warranty, the negligence of Graco, or otherwise.

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For the latest information about Graco products, visit [www.graco.com](http://www.graco.com).

For patent information, see [www.graco.com/patents](http://www.graco.com/patents).

**TO PLACE AN ORDER**, contact your Graco distributor or call to identify the nearest distributor.

**Phone:** 612-623-6921 **or Toll Free:** 1-800-328-0211 **Fax:** 612-378-3505

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Original instructions. This manual contains English. MM 313292

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Revised April 2014