



# VRM and VPM Metering Systems

Variable Ratio Metering Systems for Resin and Paste Applications



## High-volume dispensing equipment for maximized productivity

- High flow rates provide faster cycle times to improve your productivity
- Accurate, on-ratio dispense means less waste, more profits
- Variable ratio allows flexibility for different materials or temperature variations
- Intuitive, easy-to-use controls cut training time and reduce operator error
- Well-suited for rotor blade production in the wind energy market

Distributed by



**Sealant Equipment  
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Advanced Graco Distributor and Design Center for Adhesive and Sealant Equipment

PROVEN QUALITY. LEADING TECHNOLOGY.

# Expand your capacity with high-volume metering systems

## Graco VRM Metering System for resin applications

The Graco VRM Metering System is a hydraulic variable ratio metering system that uses positive displacement pumps to dispense resin materials.

### High flow rates

- Meet demands for increased production requirements
- Delivers accurate continuous material flow and shot dispensing as well
- Up to 66 lb (30 kg) per minute

### Accurate, on-ratio mixing

- Results in higher yield, less material waste and more process confidence
- Ratio accuracies better than  $\pm 2$  percent

### Variable ratio

- Allows you to change ratios on the fly
- Easy to program the exact output of A and B materials
- Ratio range: 1:1 to 5:1

### Applications

- Resin infusion

### Materials

- Resin



### Intuitive, easy to use user interface

Both the Graco VRM and VPM Metering Systems feature intuitive user controls based on the Graco Control Architecture.

### Less training time

Products using Graco Control Architecture provide similar functionality across your plant – which results in less training time for your operators. In other words, if you learn one system, you are already familiar with the other.

## Graco VPM Metering System for high-viscosity applications

The Graco VPM Metering System is a hydraulic variable ratio metering system that uses positive displacement pumps to dispense tooling pastes, adhesives and other high-viscosity materials.

### High flow rates

- Speeds production with high-volume dispensing
- Delivers accurate continuous material flow and shot dispensing as well
- Up to 55 lb (25 kg) per minute

### Ratio assurance

- Accurate, on-ratio mixing results in better yield, less material waste, less scrap
- Ratio accuracies better than  $\pm 2$  percent

### Variable ratio

- Allows you to change ratios on the fly
- Easy to program the exact output of A and B materials
- Ratio range: 1:1 to 5:1

### Applications

- Bonding
- Molding

### Materials

- Adhesives
- Tooling paste



### USB interface

The user controls offer a USB interface for easy data downloads. It lets you download process data, plus job and error logs onto a flash drive for further analysis, and also lets you archive valuable setup parameters.

### Features

- Programmable shot sizes and sequencing – up to 100 different shot sizes and five sequences of 20 positions each
- Easy configuration of integrated temperature controls
- Immediate access to error/event history
- Material usage and pump cycle counter
- Simple interface for machine calibration
- USB interface

# Technical Specifications & Ordering Information

Everything you need to make an informed decision

## Technical Specifications

Models	VRM-30	VPM-25
Max flow rate*	Up to 66 lb/min (30 kg/min) @ 70°F (21°C)	Up to 55 lb/min (25 kg/min) @ 70°F (21°C)
Output per cycle** (A+B)	0.27 gal (1.01 L)	0.2 gal (0.76 L)
Mixing ratio	Variable ratio 1:1 to 5:1	Variable ratio 1:1 to 5:1
Max fluid working pressure	2000 psi (138 bar, 14 MPa)	3000 psi (207 bar, 21 MPa)
Fluid viscosity range	10 to 10,000 cps	Thixotropic paste
Power supply	System: 24kW; 60A-230V, 3-ph or 55A-400V, 3-ph	System: 24kW; 60A-230V, 3-ph or 55A-400V, 3-ph
Max air inlet pressure	100 psi (6.9 bar, 0.69 MPa)	100 psi (6.9 bar, 0.69 MPa)
Dimensions	115L x 79H x 63W in (2921 x 2007 x 1600 cm)	190L x 110H x 90W in (4826 x 2794 x 2286 cm)
Weight	1390 lb (630 kg)	3816 lb (1731 kg)
Ratio accuracy	Shot accuracy better than $\pm 2\%$	Shot accuracy better than $\pm 2\%$
Shot sizes	Minimum 0.53 gal (2.02 L)	Minimum 0.39 gal (1.5 L)
Materials	For typical resin infusion materials: 1000-1500 cP resin bases @ 70°F (21°C) 10-50 cP hardeners @ 70°F (21°C)	For typical bonding and tooling pastes: 100,000 cP thixotropic base @ 70°F (21°C) 75,000 cP thixotropic hardener @ 70°F (21°C)
Part numbers	24F872 - 230V 3-ph 50/60Hz 60A 24F391 - 400V 3-ph 50/60Hz 55A 24F873 - 400V 3-ph 50/60Hz 55A CE	24F874 - 230V 3-ph 50/60Hz 60A 24F226 - 400V 3-ph 50/60Hz 55A 24F875 - 400V 3-ph 50/60Hz 55A CE
Operation and repair manual	313873	313875

\* Values are dependent on mixing ratio, viscosity, temperature and installed pump size. Values shown are for largest available pump size.

## Contact us today!

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