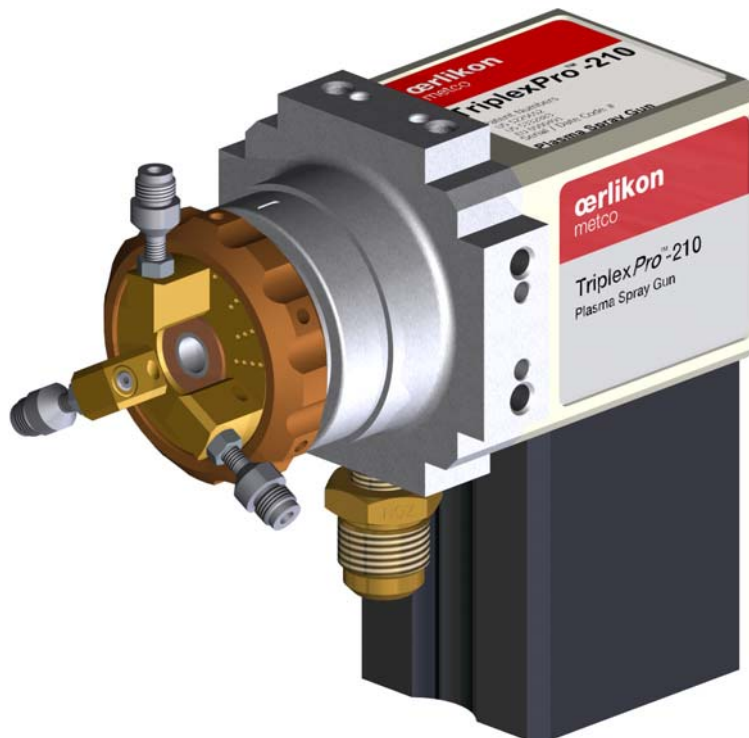


TriplexPro™-210 Plasma Gun

Plasma Spraying

Parts List
PL 105134 EN 08





US Patent Nos.: 5225652; 5332885; 5406046; D545851; D545852; D545853; 7582846; 7759599
EU Patent Nos.: 0500491; 0500492; 0596830; 1801256

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Spare Parts Categories

C = Consumable Parts

Parts subjected to major wear during normal operation. These parts require replacement on a regular basis.

Recommended in order to avoid downtimes.

W = Wear Parts

Parts used for maintenance service. These parts are likely and expected to wear out during the life of the product.

Wear parts are not subject to warranty.

K = Critical Parts

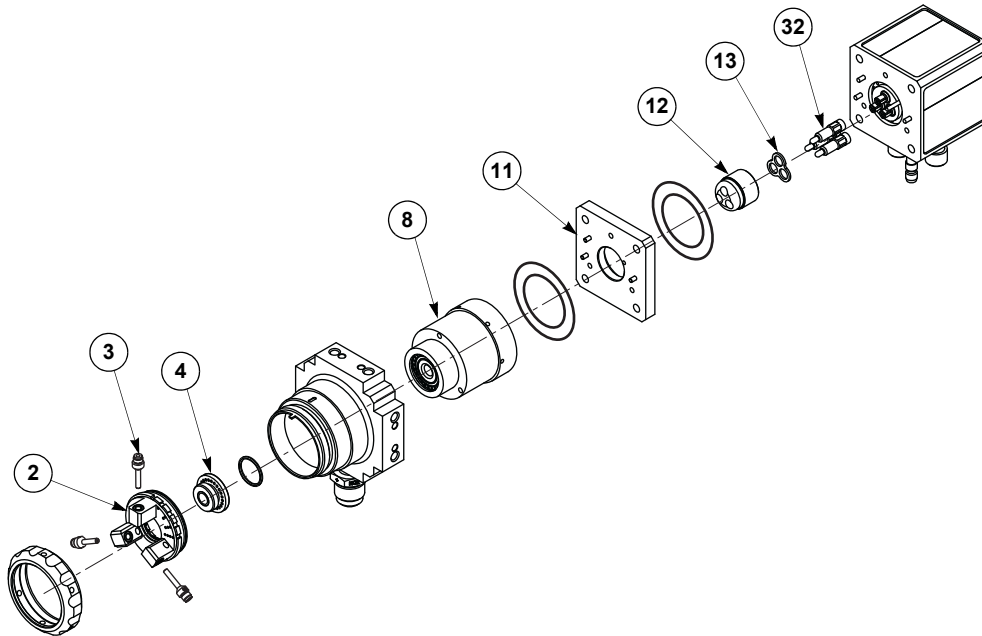
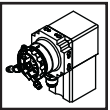
Parts recommended in order to guarantee maximum availability of component. This prevents downtime caused by delay in procurement.



Warranty Disclaimer

Installing non-Oerlikon Metco spare parts on Oerlikon Metco equipment voids the product warranty.

1 List of Recommended Spare Parts for TriplexPro-210



tpro-spare

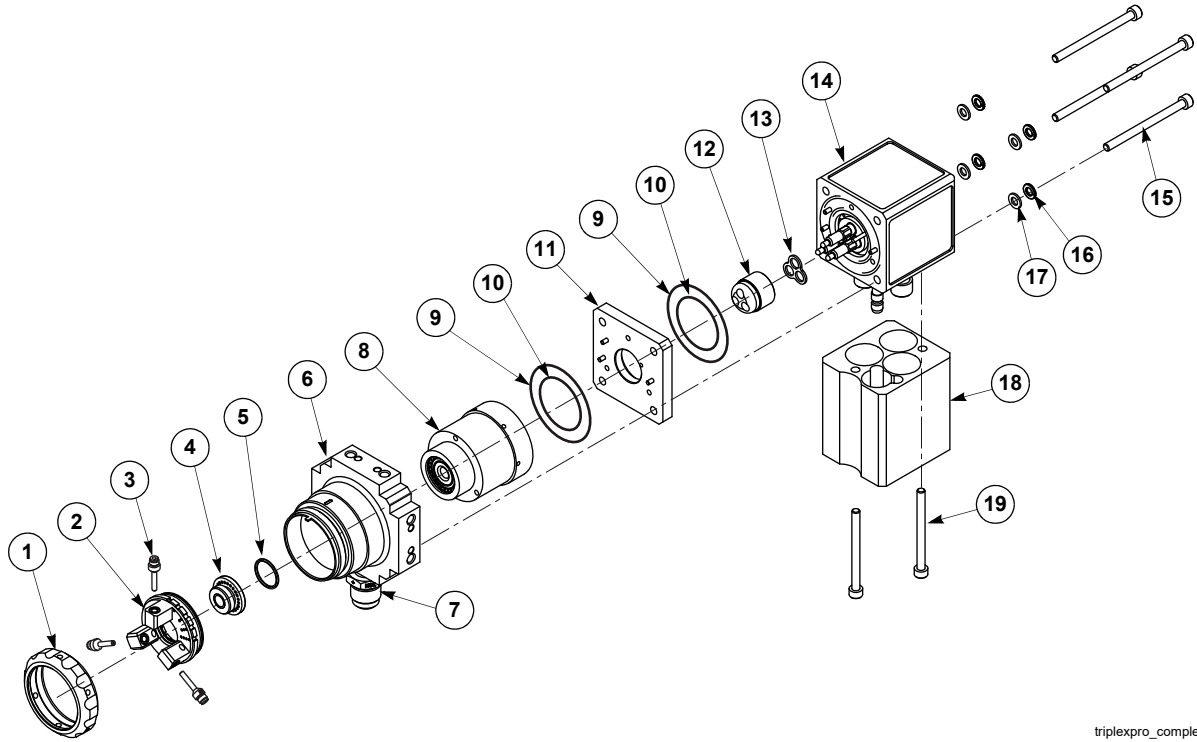
Item No.	Designation	Cat.	Qty.	Order No.
2	Injector Ring	K	1	(See page 6.)
3	Powder Injector	C	3	(See page 7.)
4	Nozzle	C	1	(See page 6.)
8	Neutrode Stack Assembly	W	1	1075110
11	Spacer Plate	K	1	1072023
12	Electrode Insulator	W	1	1072025
13	Electrode Gasket	W	1	1073420
32	Electrode	C	3	1072495
71	Ringlube	C	1	1000508
72	Silver Conductive Grease	C	1	1086603
73	Spare O-ring Kit	W	1	1075595

2 Parts List for TriplexPro™-210 Plasma Gun

2.1 Complete Gun Assembly

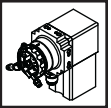
TriplexPro™-210 Plasma Gun

1074984

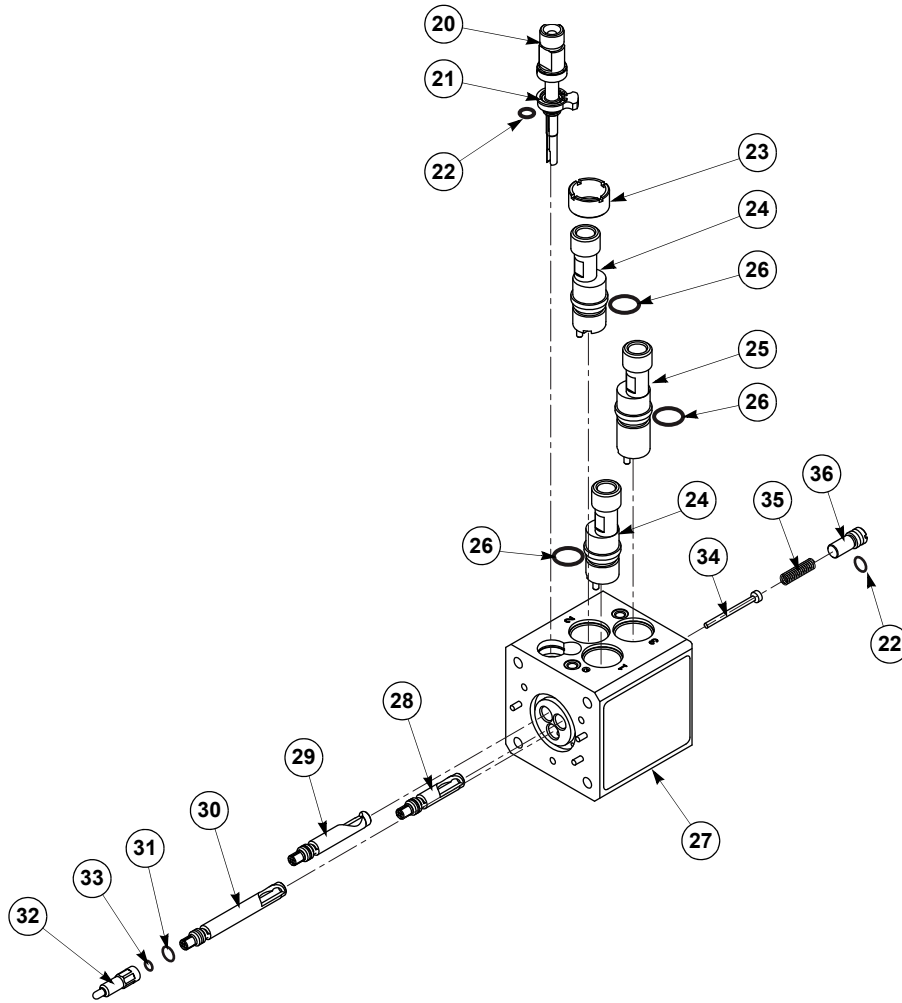


triplexpro_complete

Item No.	Designation	Qty.	Order No.
1	Nozzle Nut	1	1060231
2	Injector Ring Assembly	1	(See page 6.)
3	Powder Injector	3	(See page 7.)
4	Nozzle Assembly	1	(See page 6.)
5	O-ring, (Quad Ring) 0.801 X 0.070	1	1061036
6	Front Gun Body Assembly	1	1060232
7	Water (NOZ +) Hose Fitting	1	1000103
8	Neutrode Stack Assembly	1	1075110
9	O-ring, 2.364 x 0.070 Viton	2	1000366
10	O-ring, 1.614 x 0.070 Black Viton	2	1059685
11	Spacer Plate	1	1072023
12	Electrode Insulator	1	1072025
13	Electrode Gasket	1	1073420
14	Rear Gun Body Assembly	1	(See page 5.)
15	Hex Socket Cap Screw, M6	4	1072026
16	Lockwasher, M6	4	1059048
17	Washer, M6	4	1059047
18	Hose Insulator	1	1059688
19	Hex Socket Cap Screw, M6 x 70 mm	2	1059687



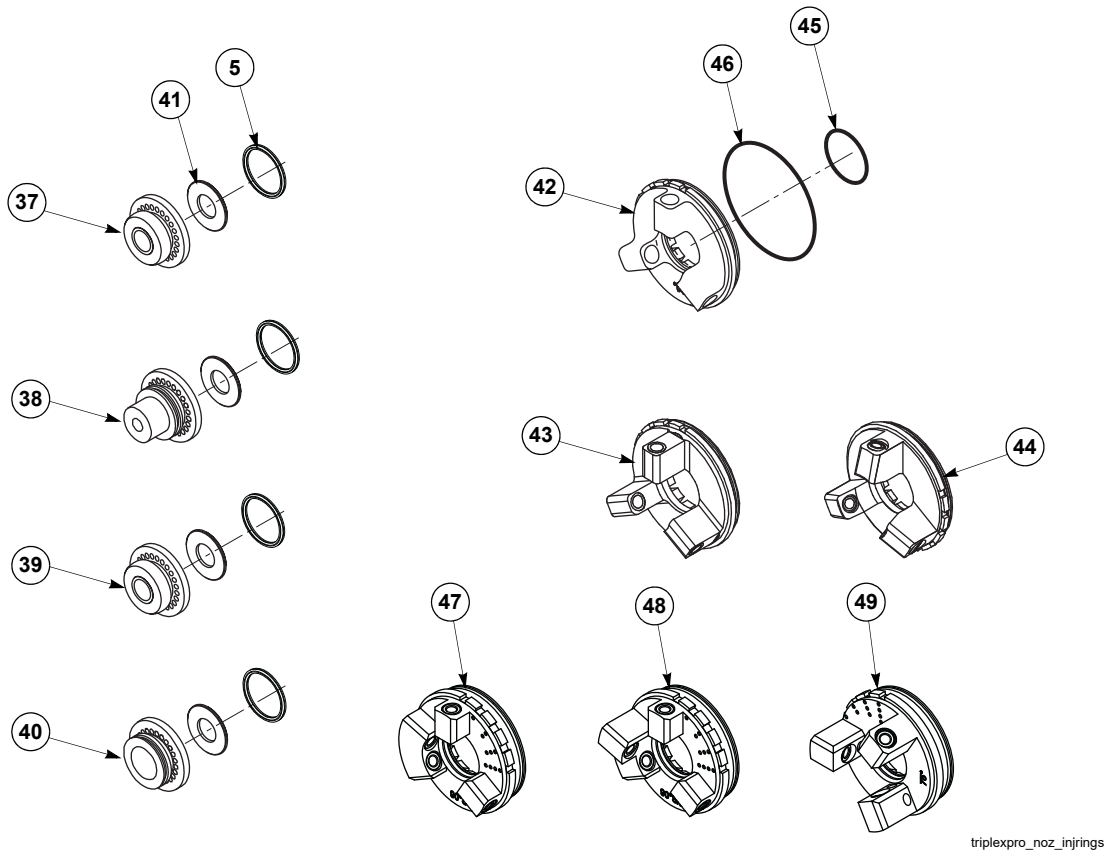
2.2 Rear Gun Body Assembly



triplexpro_rear_pl

Item No.	Designation	Qty.	Order No.
20	Gas & Ignition Fitting (includes items 18, 21 & 22)	1	1078780
21	Retaining Ring	1	1058999
22	O-ring, 0.239 x 0.070 Black Viton (pkg. of 2)	2	1031639
23	Power Connector Nut	3	1058688
24	Power Connector A (Electrodes R1&R2) (includes item 26)	2	1072490
25	Power Connector B (Electrode R3) (includes item 26)	1	1072491
26	O-ring, 0.551 X 0.070 Black Viton (pkg. of 4)	3	1020266
27	Rear Gun Body	1	1074987
28	Electrode Holder R1 (includes item 31)	1	1072492
29	Electrode Holder R2 (includes item 31)	1	1072493
30	Electrode Holder R3 (includes item 31)	1	1072494
31	O-Ring, 6.5 x 1 mm Viton	3	1073418
32	Electrode (includes item 33)	3	1072495
33	O-Ring, 4.5 x 1 mm Viton	3	1003667
34	Contact Pin	1	1072024
35	Compression Spring	1	1059000
36	Insulator Screw	1	1059001

2.3 Nozzles and Injector Rings

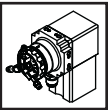


Item No.	Designation	Qty.	Order No.
Nozzles			
37	Nozzle Assembly, 9 mm (standard) (includes items 5, 41) ⁽¹⁾	1	1058689
38	Nozzle Assembly, 5 mm (standard) (includes items 5, 41) ⁽¹⁾	1	1059485
39	Nozzle Assembly, 6.5 mm (standard) (includes items 5, 41) ⁽¹⁾	1	1059488
40	Nozzle Assembly, 11 mm (optional) (includes items 5, 41) ⁽¹⁾	1	1059541
41	BN Insulator Ring (18 mm OD / 10.5 mm ID) ⁽²⁾	1	1008803
5	O-ring, (Quad Ring) 0.801 X 0.070	1	1061036
Injector Rings ⁽³⁾			
42	Short Injector Ring Assembly (includes items 45, 46)	1	1059495
43	Long Injector Ring Assembly (includes items 45, 46)	1	1059468
44	105° Injector Ring Assembly (includes items 45, 46)	1	1059498
45	O-ring, 0.801 X 0.070 Black Viton (pkg. of 2)	1	1000549
46	O-ring, 1.86 X 0.070 Silicone	1	1017675
Optional Injector Rings ⁽³⁾			
47	Quad Injector Ring, Short (includes items 45, 46)	—	1075303
48	Injector Ring Short/Long (includes items 45, 46)	—	1075743
49	75° Injector Ring Assembly (includes items 45, 46)	—	1087101

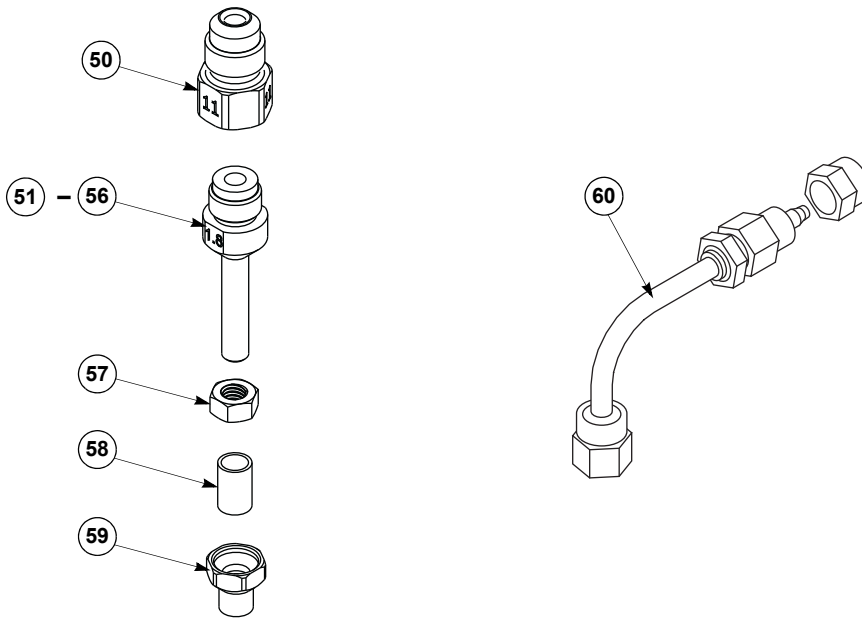
1. BN (boron-nitride) Insulator Ring (41) is glued onto Nozzle Assembly.

2. OD = Outside Diameter, ID = Inside Diameter

3. The TriplexPro-210 can also use SinplexPro injector rings. Refer to PL 115252.



2.4 Powder Injectors

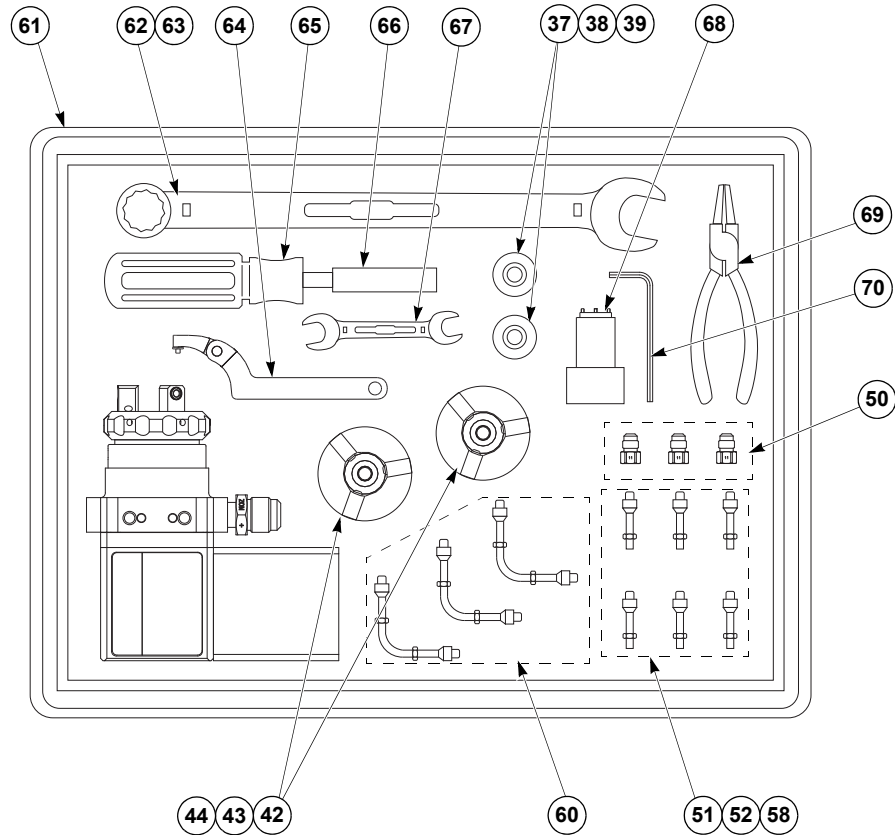


triplexpro_powder

Item No.	Designation	Qty.	Order No.
50	Powder Fitting Adapter	3	1002329
51	Powder Injector 1.8 (standard)	3	1003436
52	Powder Injector 2.0 (standard)	3	1003439
53	Powder Injector 1.5 (optional)	3	1003434
54	Powder Injector 1.8 (with hard metal insert; long-life; optional)	3	1003437
55	Powder Injector 2.0 (with hard metal insert; long-life; optional)	3	1003440
56	Powder Injector 1.5 (with hard metal insert; long-life; optional)	3	1003435
57	Lock Nut, M5 (supplied with all injectors)	1	1003518
58	Powder Injector Sleeve	3	1059512
59 ⁽¹⁾	Powder Injector Lock Nut (pkg. of 3)	—	1093600
60	Powder Elbow Fitting Assembly, 90°	3	1003759

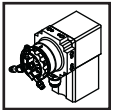
1. Optional. Use instead of Lock Nut (57) and and Powder Injector Sleeve (58) when using Short Injector Ring (42).

2.5 Accessories



triplexpro_tools

Item No.	Designation	Qty.	Order No.
61	Gun Case	1	—
62	Wrench, 1 inch	1	1059503
63	Wrench, 21 mm	1	1059508
64	Spanner Torque Wrench	1	1078860
65	Driver Handle, 1/4" Drive	1	1072028
66	Socket, 5/16", Deep	1	1072027
67	Wrench, 8/10 mm	1	1059509
68	Multi-tool	1	1059501
69	Snap Ring Pliers	1	1001148
70	Hex Wrench, 5 mm	1	—
71	Ringlube (not shown)	1	1000508
72	Silver Conductive Grease (not shown)	1	1086603
73	Spare O-ring Kit	includes the following items:	1 1075595
5	O-ring, (Quad Ring) 0.801 X 0.070	1	1061036
9	O-ring, 2.364 X 0.070 Viton	2	1000366
10	O-ring, 1.614 X 0.070 Black Viton	2	1059685
22	O-ring, 0.239 X 0.070 Black Viton	2	1031639
26	O-ring, 0.551 X 0.070 Black Viton	3	1020266
31	O-ring, 6.5 x 1mm Viton	3	1073418
33	O-ring, 4.5 x 1mm Viton	3	1003667
45	O-ring, 0.801 X 0.070 Black Viton	1	1000549
46	O-ring, 1.86 X 0.070 Silicone	1	1017675



2.6 Additional Equipment

Items in this section are supplied, as required, with the engineered system or as options.

2.6.1 Cables, Hoses and Packages

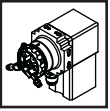
Item No.	Designation	Qty.	Order No.
Water-Cooled Electrical Cables			
74	Triplex Gun Cable Set (-), Small, 13 m (43') (includes item 75)	—	1077923
75	Triplex Gun Cable (-), Small, 13 m (43')	3	1077918
76	Triplex Gun Cable Set (-), Small, 10 m (33') (includes item 77)	—	1077924
77	Triplex Gun Cable (-), Small, 10 m (33')	3	1077919
78	Triplex Gun Cable Set (-), Small, 8 m (26.4') (includes item 79)	—	1077925
79	Triplex Gun Cable (-), Small, 8 m (26.4')	3	1077920
80	Triplex Gun Cable Set (-), Small, 5 m (16.5') (includes item 81)	—	1077926
81	Triplex Gun Cable (-), Small, 5 m (16.5')	3	1077921
82	Triplex Gun Cable Set (-), Small, 3 m (10') (includes item 83)	—	1077927
83	Triplex Gun Cable (-), Small, 3 m (10')	3	1077922
84	Spray Gun Cable Set, 13 m (43') (includes items 85 & 86)	—	1038932
85	Power Cable (-), 13 m (43')	3	1064977
86	Power Cable (+), 13 m (43')	1	1064978
87	Spray Gun Cable Set, 10 m (33') (includes items 88 & 89)	—	1059064
88	Power Cable (-), 10 m (33')	3	1019905
89	Power Cable (+), 10 m (33')	1	1019907
90	Spray Gun Cable Set, 8 m (26.4') (includes items 91 & 92)	—	1035404
91	Power Cable (-), 8 m (26.4')	3	1020971
92	Power Cable (+), 8 m (26.4')	1	1020972
93	Spray Gun Cable set, 5 m (16.5') (includes items 94 & 95)	—	1059063
94	Power Cable (-), 5 m (16.5')	3	1059058
95	Power Cable (+), 5 m (16.5')	1	1037180
96	Spray Gun Cable Set, 3 m (10') (includes items 97 & 98)	—	1059062
97	Power Cable (-), 3 m (10')	3	1059059
98	Power Cable (+), 3 m (10')	1	1059006
Ignition Cable			
99	Ignition Cable, 20 m (66') (includes item 100)	—	1078927
100	O-Ring, Buna, 0.070 x 0.070 in	1	1083088
Hoses			
101	Powder Hose PTFE 2.7/4.7 mm Black (requires items 102 & 103)	—	1004517
102	Powder Hose Nut 4.7 mm	6	1004363
103	Powder Hose Clamping Ring 4.7 mm	6	1004365
104	Powder Hose PTFE 4/6 mm Black (requires items 105 & 106)	—	1004515
105	Powder Hose Nut 6 mm	6	1004362
106	Powder Hose Clamping Ring 6 mm	6	1004364
107	Air Jet Hose	—	1059061

Item No.	Designation	Qty.	Order No.
Plasma Gas Hoses ⁽¹⁾			
108	Plasma Gas Hose, 2 m (6.6')	—	1008157
109	Plasma Gas Hose, 3 m (10')	—	1065336
110	Plasma Gas Hose, 4 m (13.1')	—	1065379
111	Plasma Gas Hose, 5 m (16.5')	—	1064275
112	Plasma Gas Hose, 6 m (19.7')	—	1064276
113	Plasma Gas Hose, 7 m (23')	—	1064277
114	Plasma Gas Hose, 8 m (26.4')	—	1064279
115	Plasma Gas Hose, 9 m (29.5')	—	1065395
116	Plasma Gas Hose, 10 m (33')	—	1051270
117	Plasma Gas Hose, 11 m (36')	—	1064280
118	Plasma Gas Hose, 12 m (39.3')	—	1064281
119	Plasma Gas Hose, 13 m (43')	—	1038928
120	Plasma Gas Hose, 15 m (49.2')	—	1003089

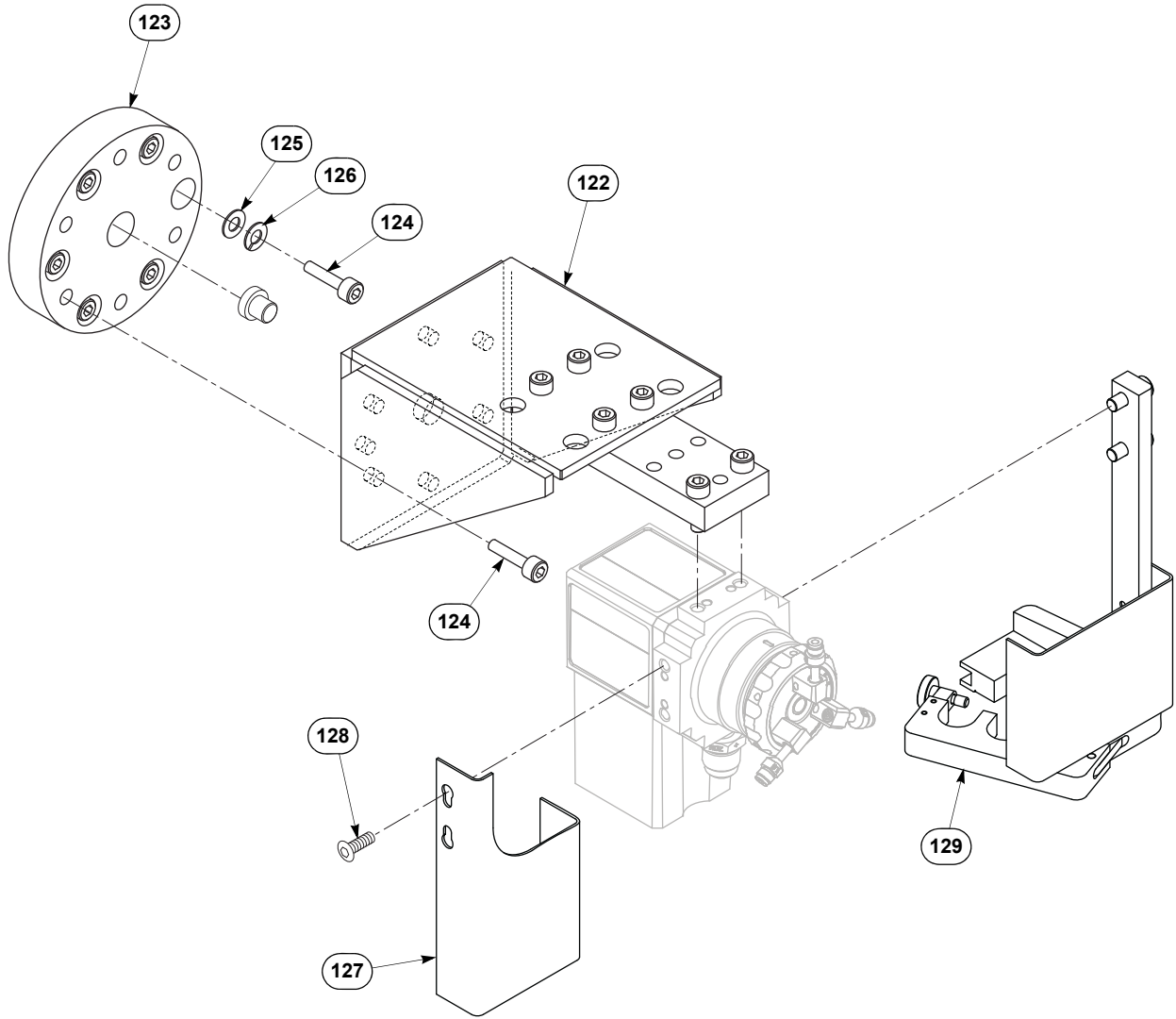
1. Plasma gas hose may include quick-disconnect coupling 1004354, not used with TriplexPro™-210 Plasma Gun.

2.6.2 Service Kit

Item No.	Designation	Qty.	Order No.
121	Service Kit	includes the following items:	— 1078949
5	O-ring, (Quad Ring) 0.801 X 0.070	1	1061036
8	Neutrode Stack Assembly	1	1075110
9	O-ring, 2.364 x 0.070 Viton	2	1000366
10	O-ring, 1.614 x 0.070 Black Viton	2	1059685
12	Electrode Insulator	1	1072025
13	Electrode Gasket	1	1073420
32	Electrode	3	1072495
33	O-Ring, 4.5 x 1 mm Viton	3	1003667



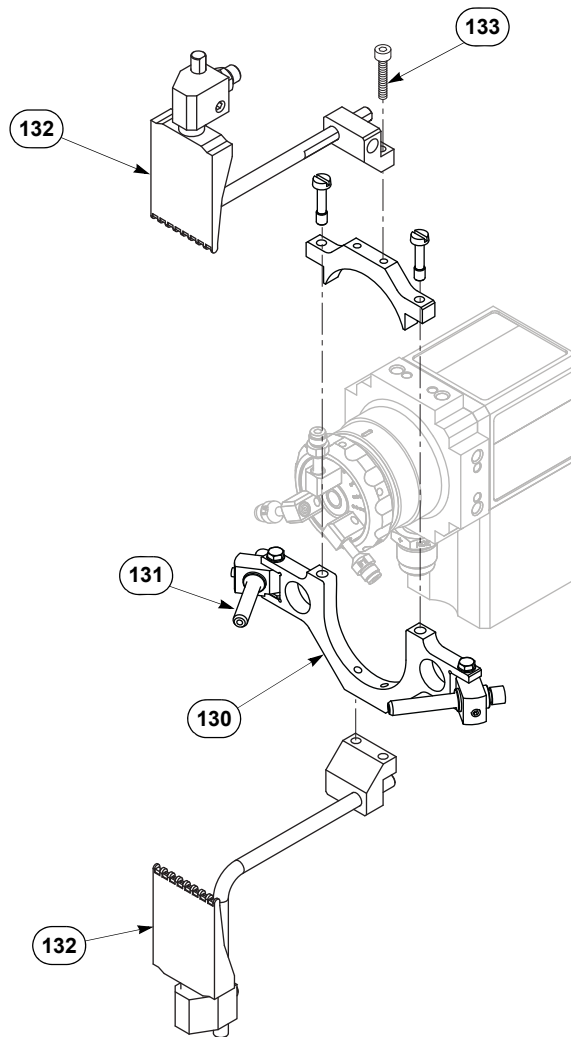
2.6.3 Mounting Equipment



triplexpro_mount

Item No.	Designation	Qty.	Order No.
122	Robot Mounting Bracket Assembly (includes items 123 - 126)	—	1064196
123	Robot Insulator Plate	1	1064198
124	Screw, M8 X 25 mm (pkg. of 2)	18	1030603
125	Washer, M8	6	—
126	Lock Washer, M8	6	—
127	Heat Shield (includes item 128)	—	1063405
128	Button Head Screw, M8 X 12 mm (pkg. of 4)	2	1030554
129	Hose & Cable Strain Relief Assembly	—	1071474

2.6.4 Work Piece Cooling Equipment



triplexpro_cooling

Item No.	Designation	Qty.	Order No.
130	Air Jet Assembly	1	1064200
131	Air Nozzle	2	1000540
132	Silvent Air Jet Assembly	1	1064201
133	Cap Screw, M5 X 20 mm, Stainless Steel	4	—
134 ⁽¹⁾	2PSA40 Air Nozzle Hose Assembly, 38 cm (15")	2	1000543
135 ⁽¹⁾	2PSA35 Wye Assembly	1	1000541
136	2E22 Hex Nipple	2	1000464
137	4E20 Hex Nipple	1	1000824
138 ⁽¹⁾	7M150 Air Supply Hose Assembly, 5.8 m (19')	1	1001473
139	PS43 Hex Key Wrench (3/32")	1	1002327

1. Required (but not supplied) with Air Jet Assembly (130) and Silvent Air Jet Assembly(132).