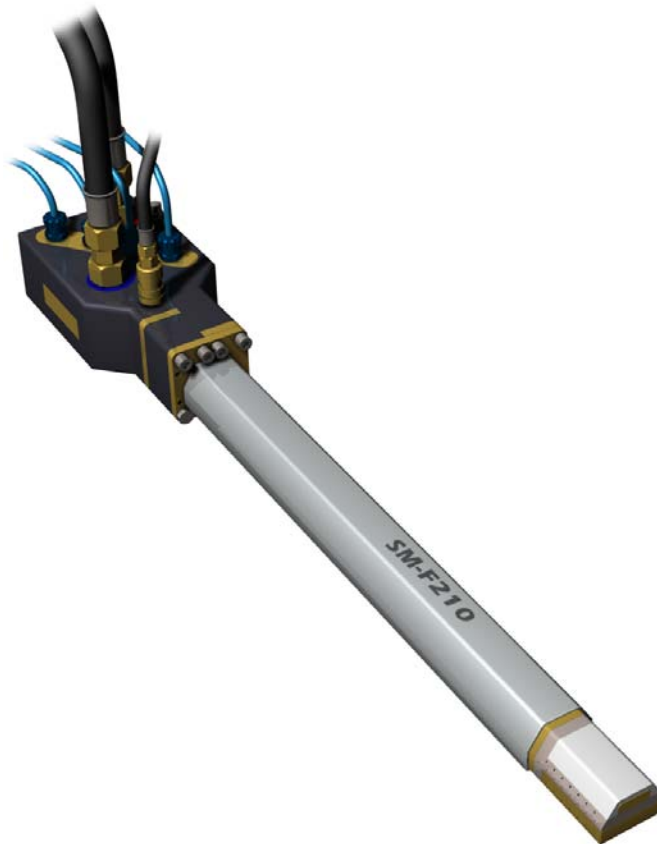


SM-F210 Spray Gun

Plasma Spraying


Parts List
PL 40871 EN 13




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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

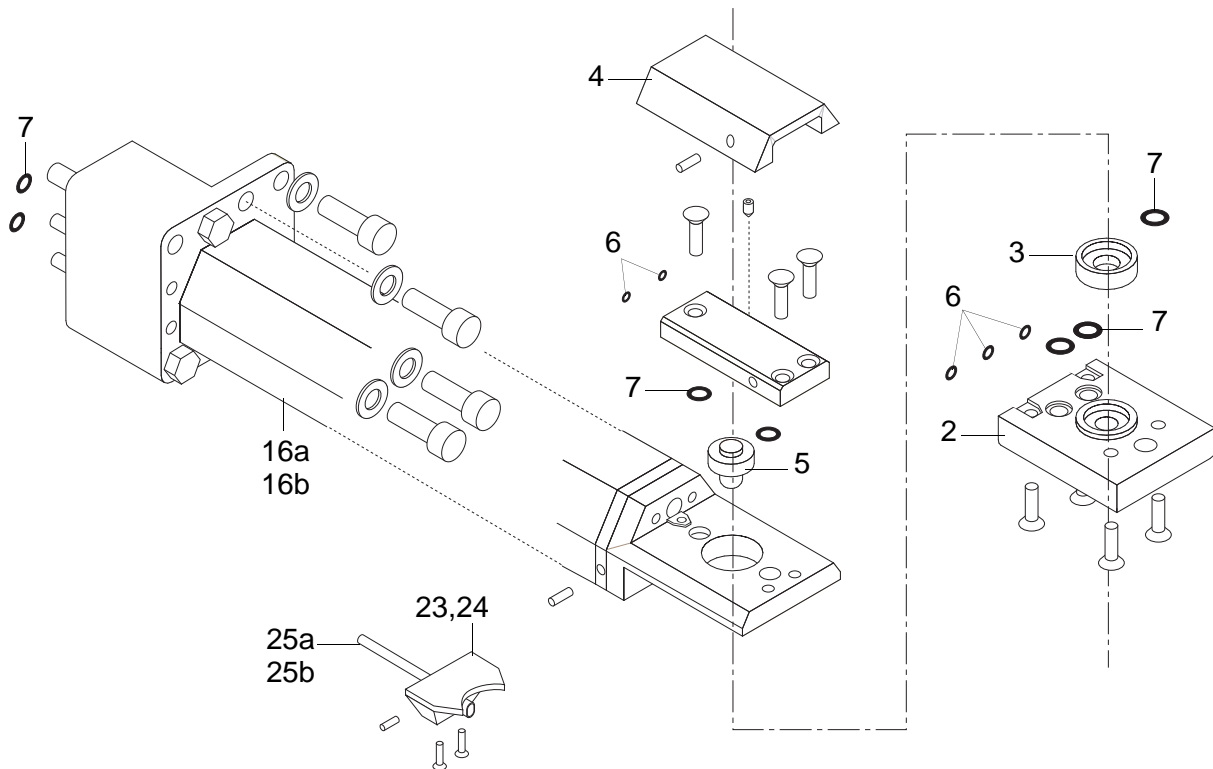
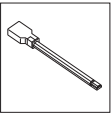
Parts recommended in order to guarantee maximum availability of component. This prevents downtime caused by delay in procurement.



Warranty Disclaimer

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

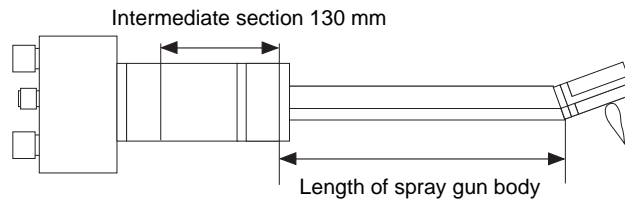
1 List of recommended spare parts



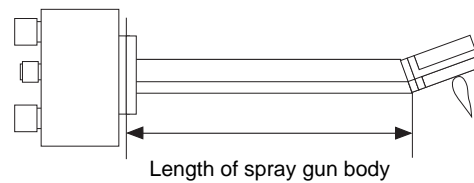
Pos.	Description		Qty.	Cat.	Art. no.
2	Nozzle body		1	C	see page 5
3	Insulating ring		1	C	1003721
4	Protective cover		1	K	1003719
5	Electrode		1	C	1003714
	Electrode (replacement for 1003714)		1	C	1091854
6	O-Ring 3x1		10	W	1003398
7	O-Ring 6x1.5		8	W	1003397
16a 16b	Spray gun body	(according to spray gun type)	1	K	see page 6
23 24	Powder injector holder	(according to spray gun type)	1	K	see page 6
25a 25b	Powder injector	(according to spray gun type)	1	C	see page 6

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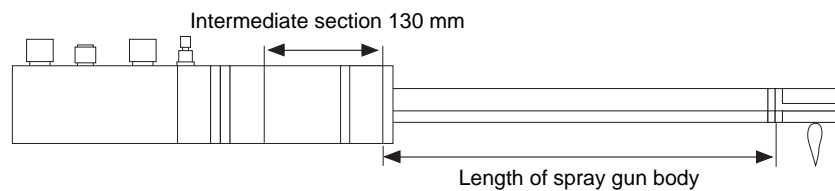
2 Overview of available spray guns



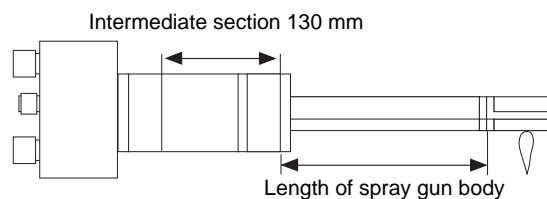
SM-F210 Spray Gun 250 mm, 20°, with intermediate section, 180° connection piece	1037985
SM-F210 Spray Gun 450 mm, 20°, with intermediate section, 180° connection piece	1038052
SM-F210 Spray Gun 650 mm, 20°, with intermediate section, 180° connection piece	1038053



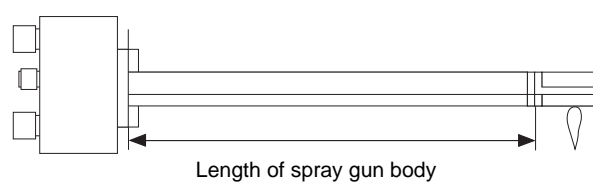
SM-F210 Spray Gun 250 mm, 20°, 180° connection piece	--	1051529
SM-F210 Spray Gun 450 mm, 20°, 180° connection piece	--	1051530
SM-F210 Spray Gun 650 mm, 20°, 180° connection piece	--	1051531



SM-F210 Spray Gun 650 mm 90° with intermediate section	1003711
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SM-F210 Spray Gun 250 mm with intermediate section, 180° connection piece	1009076
SM-F210 Spray Gun 450 mm with intermediate section, 180° connection piece	1036069

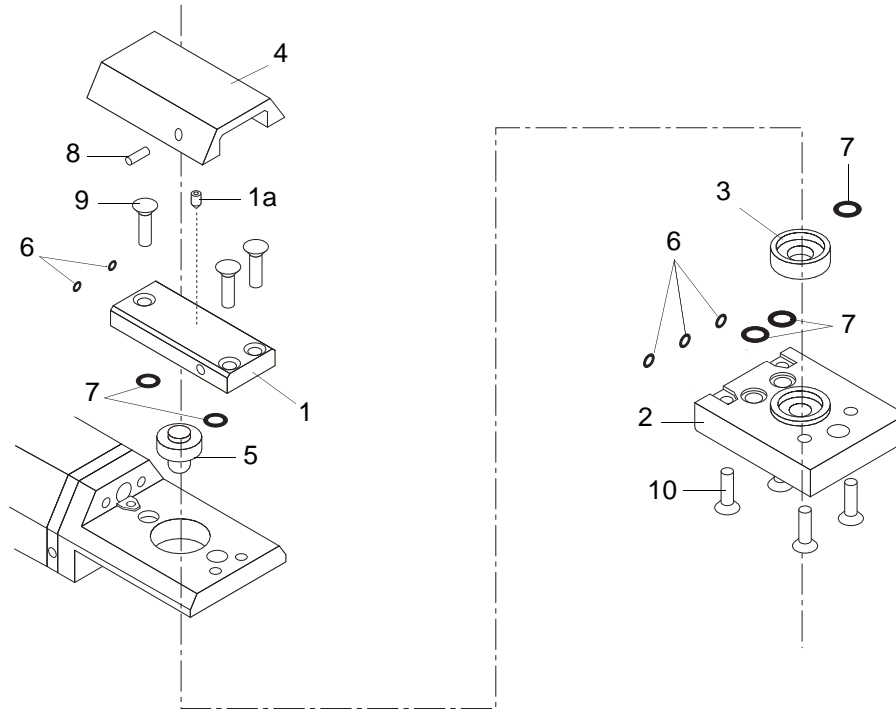


SM-F210 Spray Gun 650 mm, 90°, 180° connection piece	1036021
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3 Parts list



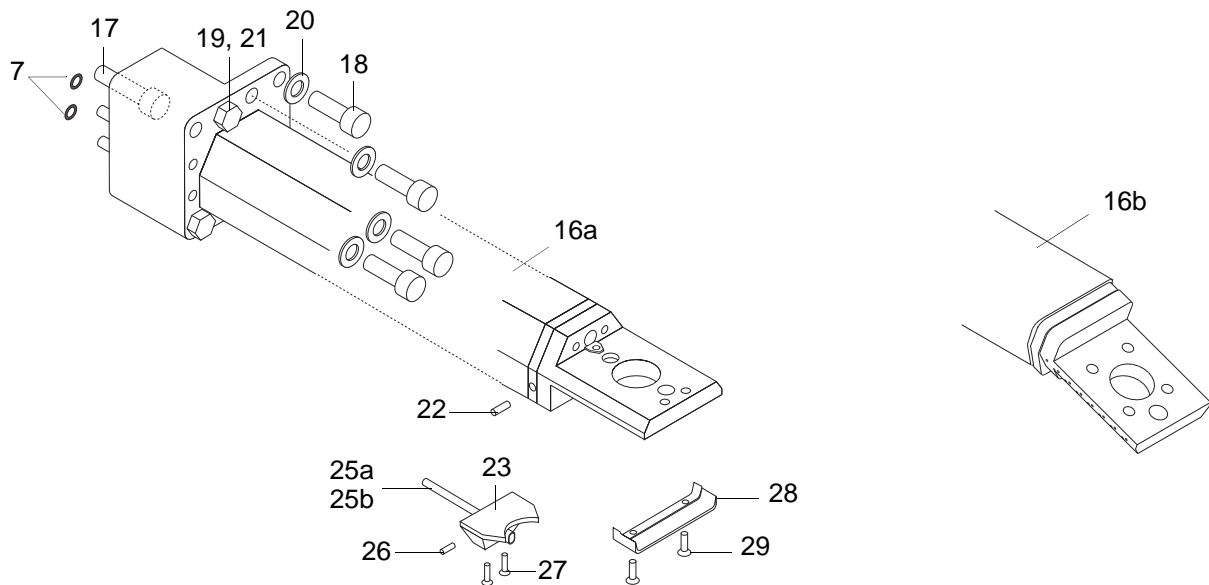
3.1 Spray gun head



Pos.	Description		Qty.	Art. no.
1	Electrode holder	incl. Pos. 1a	1	1305962
1a	Stud bolt M3x4		1	1003528
2	Nozzle body (standard)		1	1003715
2a	Nozzle body (shroud gas)	(not shown)	1	1040842
3	Insulating ring		1	1003721
4	Protective cover		1	1003719
5	Electrode		1	1003714
	Electrode (replacement for 1003714)		1	1091854
6	O-ring 3x1		5	1003398
7	O-ring 6x1.5		5	1003397
8	Stud bolt M3x6		2	1008746
9	Countersunk head screw M3x10		3	1003527
10	Countersunk head screw M3x14		4	1003544

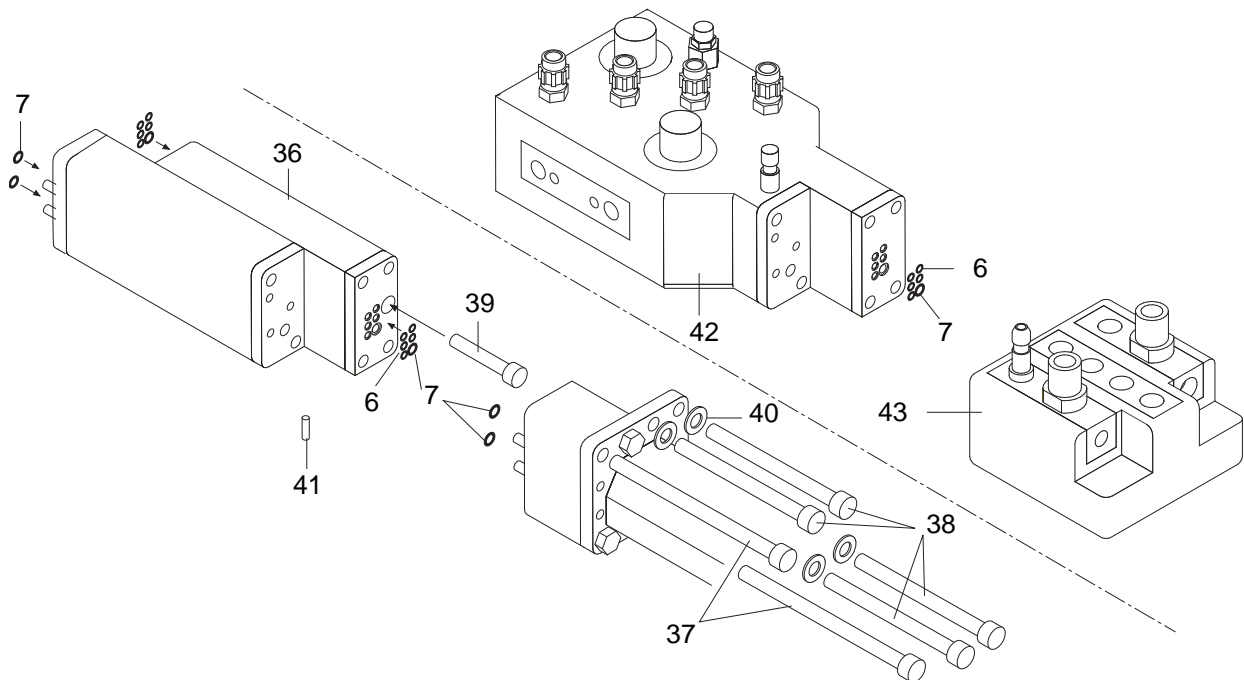
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3.2 Spray gun shaft, powder injector and holder



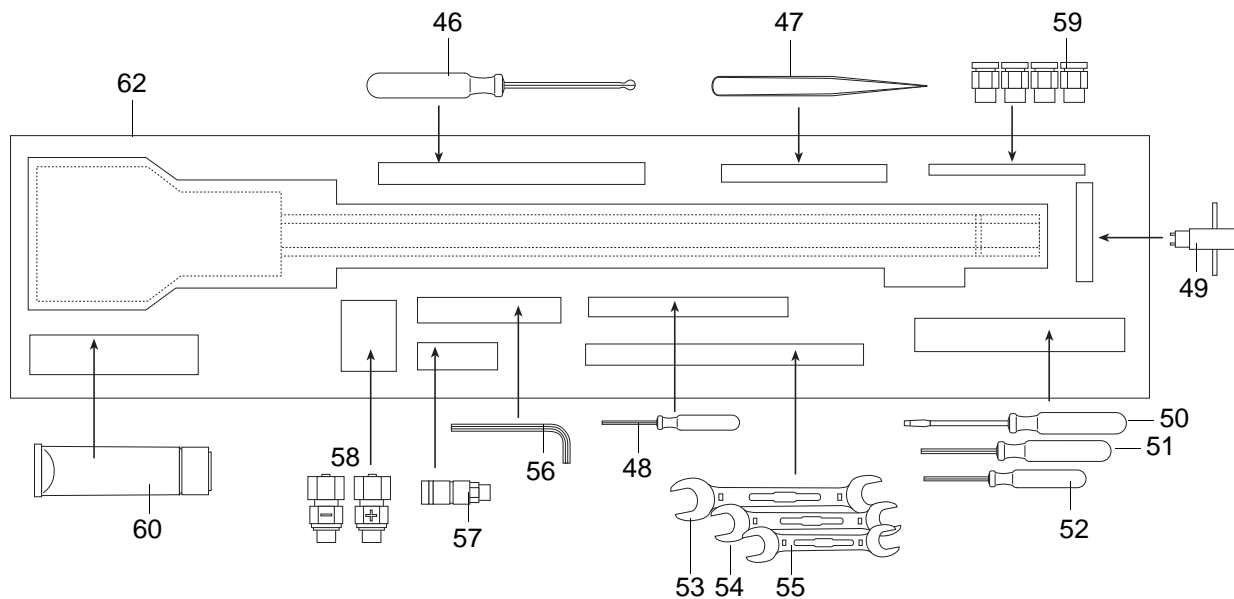
Pos.	Description	Qty.	Art. no.	
16a	Spray gun body 250-90°	1	1003718	
	Spray gun body 450-90°	1	1009092	
	Spray gun body 650-90°	1	1009094	
	Spray gun body 250-20°	1	1037986	
16b	Spray gun body 450-20°	1	1038050	
	Spray gun body 650-20°	1	1038051	
7	O-ring 6x1.5	3	1003397	
17	Hexagon socket screw M 6x20	2	1008741	
18	Hexagon socket screw M 6x12	4	1008726	
19	Hexagon head cap screw M 6x20	2	1008767	
20	Washer for M6	4	1003545	
21	Spring washers M6	2	1013882	
22	Stud bolt M 3x5	2	1003525	
23	Powder injector holder 3.5 mm	1	1003722	
24	Powder injector holder 5.5 mm	1	1009099	
25a	Powder injector 1.5 mm 90°	1	1003724	
	Powder injector 1.8 mm 90°	1	1003725	
	Powder injector 2.0 mm 90°	1	1009100	
	Powder injector 3x1 mm 90°	1	1009101	
25b	Powder injector 1.5 mm 20°	(not shown)	1	1038298
	Powder injector 1.8 mm 20°	(not shown)	1	1038299
	Powder injector 2.0 mm 20°	(not shown)	1	1038300
	Powder injector 3x1 mm 20°	(not shown)	1	1038297
26	Stud bolt M 3x5	1	1003543	
27	Hexagon socket screw M 3x12	2	1003542	
28	Protective plate	1	1003720	
29	Countersunk screw M 2.5x6	2	1003524	

3.3 Connection piece and intermediate section



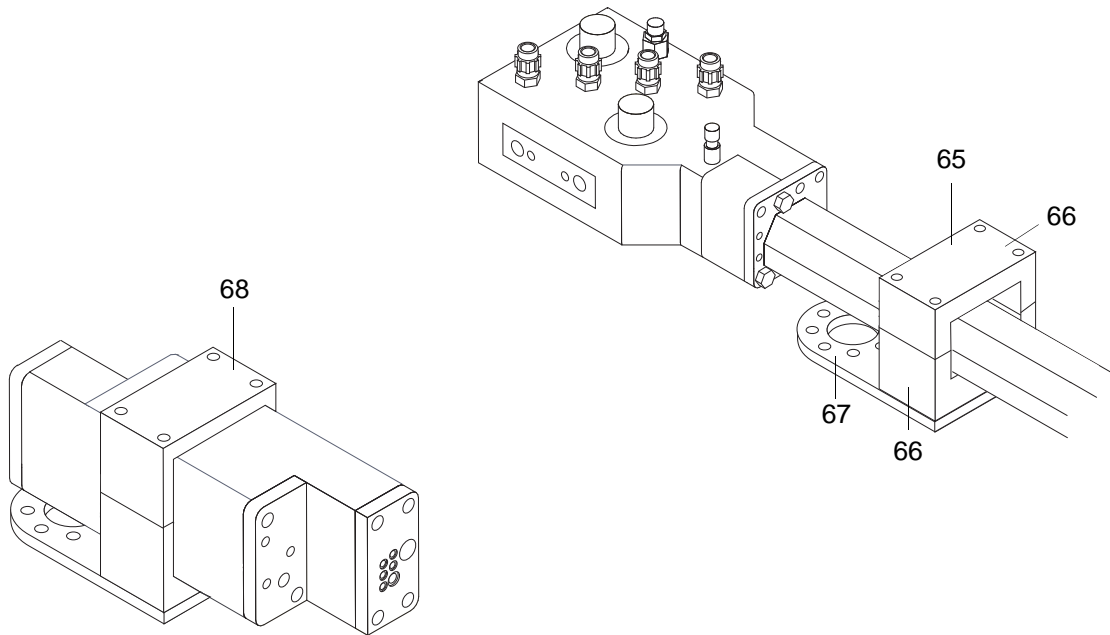
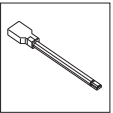
Pos.	Description		Qty.	Art. no.
36	Intermediate section 130 mm	incl. Pos. 6,7, 37-41	1	1006790
6	O-ring 3x1		10	1003398
7	O-ring 6x1.5		6	1003397
37	Hexagon socket screw M 6x150		2	1008723
38	Hexagon socket screw M 6x143.5		4	1008728
39	Hexagon socket screw M 6x35		1	1008731
40	Washer for M6		4	1003545
41	Centering pin D4-20		2	1009259
42	Connection piece 90°	incl. Pos. 6,7	1	1006791
43	Connection piece 180° (for RotaPlasma®)	incl. Pos. 6,7	1	1009096
6	O-ring 3x1		5	1003398
7	O-ring 6x1.5		3	1003397

3.4 Wooden case and tools



Pos.	Description	Qty.	Art. no.
46	Hexagonal pin spanner with ball 5.0	1	1009398
47	Tweezers	1	1009416
48	Hexagonal pin spanner with handle 1.5	1	1009391
49	Electrode wrench	1	1009424
50	Screw driver size 2	1	1009399
51	Hexagonal pin spanner with handle 2.5	1	1009393
52	Hexagonal pin spanner with handle 2.0	1	1009392
53	Open-end wrench 21x23	1	1009372
54	Open-end wrench 17x19	1	1009373
55	Open-end wrench 14x17	1	1009378
56	Allen wrench size 5.0	1	1009412
57	Sealing coupling 1/4"	1	1004354
58	Adapter APS hose to VPS spray gun	1	1003465
59	Fitting QS-1/4-8	4	1011179
60	O-ring grease	1	1003770
61	Wooden case	1	1009359
62	Foam rubber insert	1	1009363
—	Silver paste (optional; not shown)	—	1087532

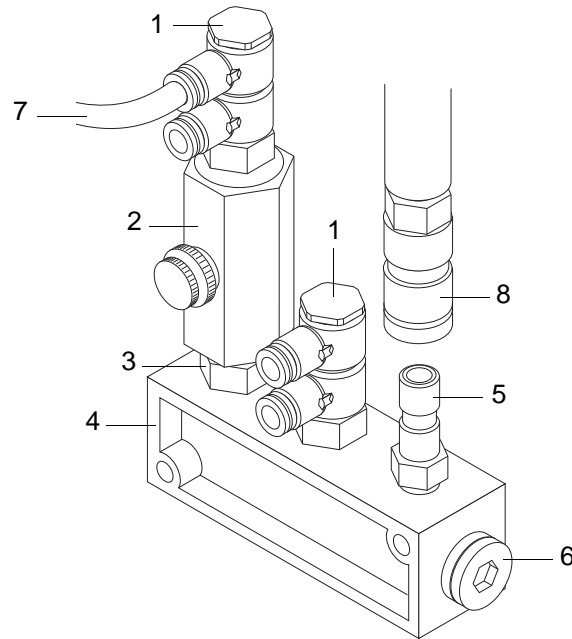
3.5 Mounting unit for robot



Pos.	Description	Qty.	Art. no.
65	Complete mounting unit for gun body	1	1011396
66	Holder for shaft	2	1011397
67	Mounting plate roboter	1	1004246
68	Mounting plate for intermediate section	1	1011400

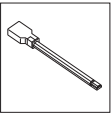
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4 Option cooling air distributor SM-F210

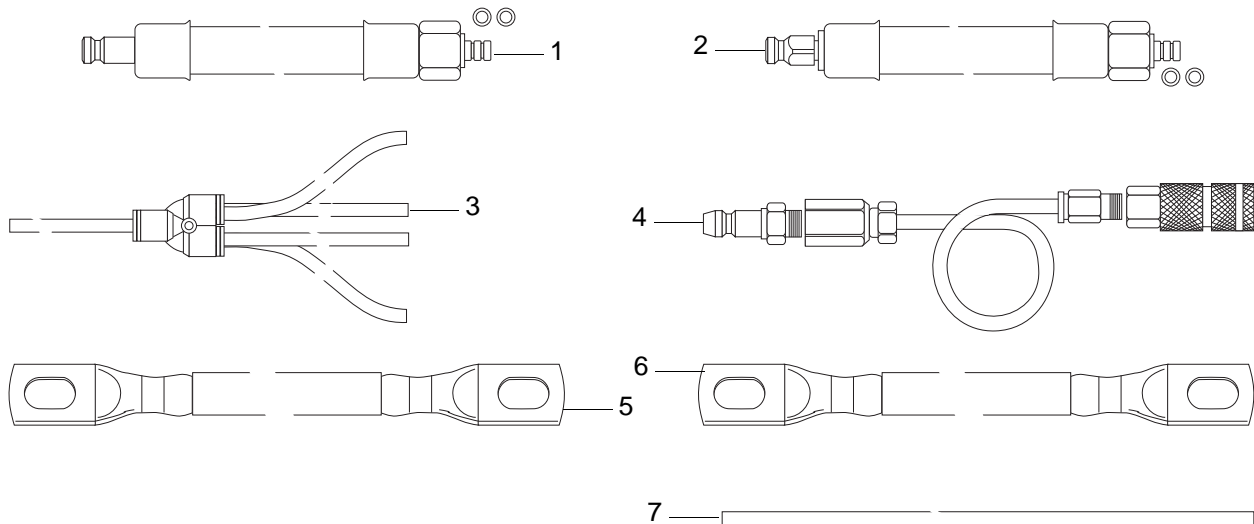


Pos.	Description	Qty.	Art. no.
--	Cooling air distribution complete includes:	--	1009089
1	Connection	2	1011241
2	Choke 0 - 10 bar	1	1011129
3	Nipple 1/4"x1/4"	1	1010685
4	Distribution block	1	1011243
5	Nipple	1	1003392
6	Blind plug B 1/4"	1	1011177
7	Pneumatic hose PUN 8x1.25 10m	1	1011207
Cooling air distribution does not include:			
8	Inlet plug	1	1003391

5 Hose sets



5.1 Hose sets for RotaPlasma®

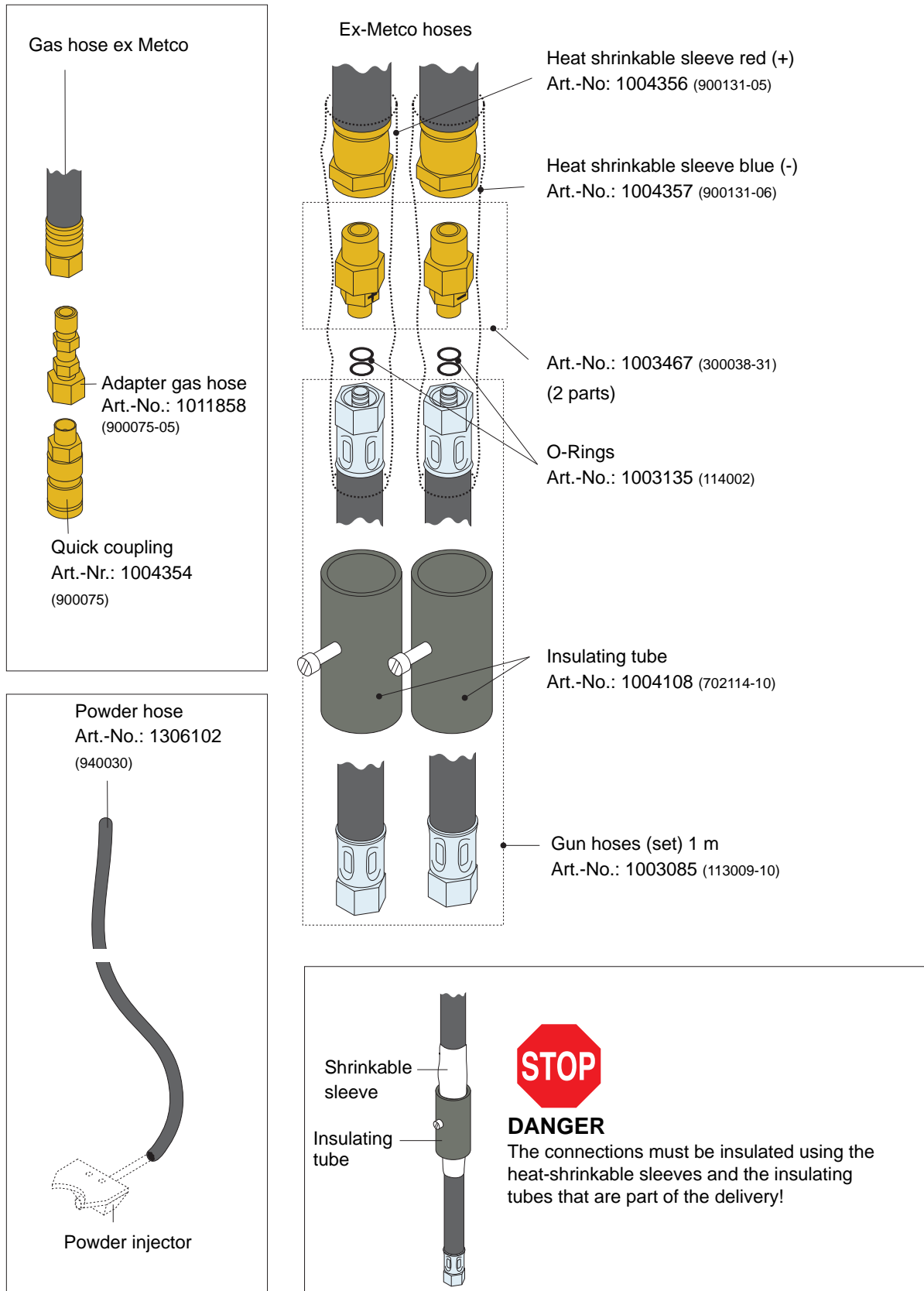


Pos.	Description		Qty.	Art. No.
--	Complete hose set	includes:	1	1011724
1	Positive spray gun hose		1	1004322
2	Negative spray gun hose		1	1004323
3	Air cooling pipe		1	1011726
4	Plasma gas hose		1	1011725
5	Positive power cable		1	1011729
6	Negative power cable		1	1011728
7	Pipe shroudgas		1	1011727

Not shown				
--	Complete hose set 30°	includes:	1	1021059
8	Positive spray gun hose		1	1033649
9	Negative spray gun hose		1	1033650
10	Air cooling pipe		1	1033652
11	Plasma gas hose		1	1033651
12	Positive power cable		1	1033653
13	Negative power cable		1	1033655
14	Pipe shroudgas		1	1021359

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5.2 Hose set for mounting on ex-Metco plasma system



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