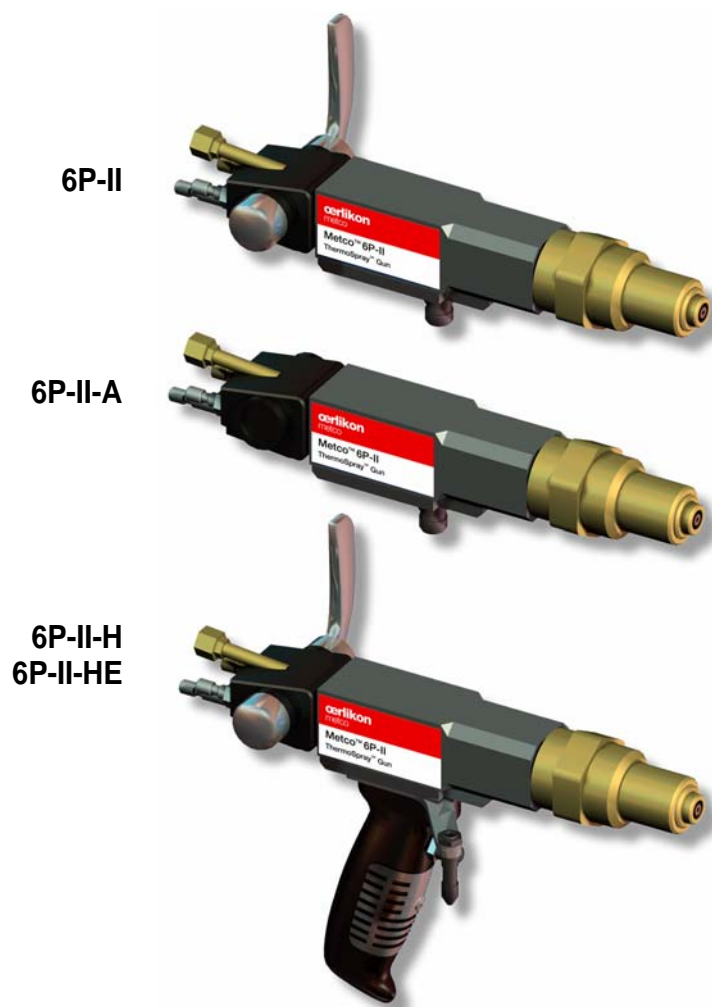


6P-II ThermoSpray™ Gun Combustion Powder Spraying


Parts List PL 40921 EN 05




Oerlikon Metco (US) Inc.

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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

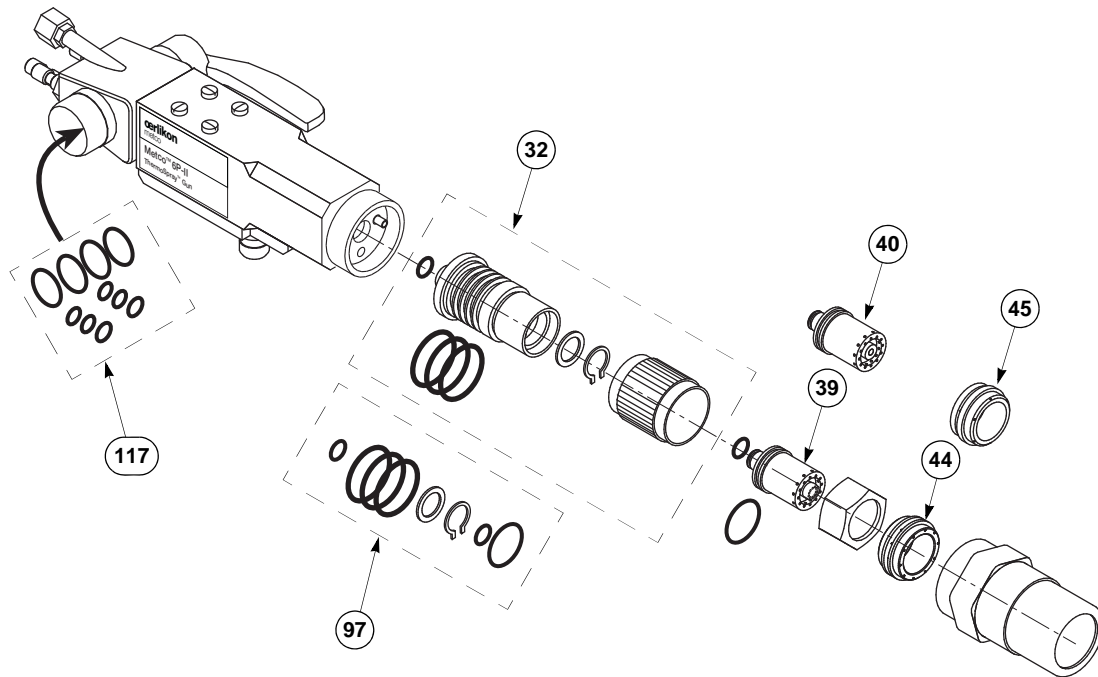
Parts recommended in order to guarantee maximum availability of component. This prevents downtime caused by delay in procurement.



Warranty Disclaimer

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

1 List of Recommended Spare Parts for 6P-II ThermoSpray™ Gun



6P-II_spare

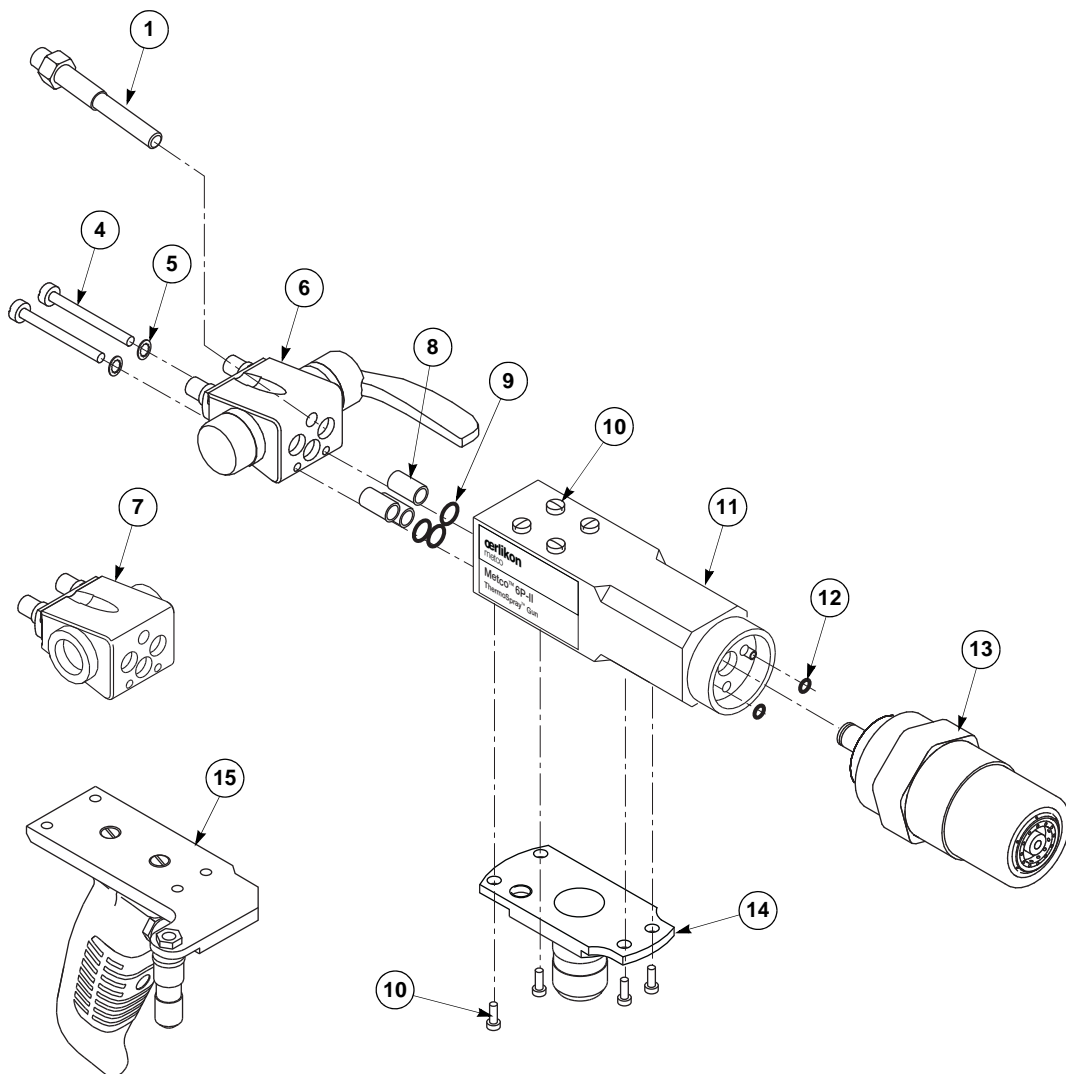
Item No.	Description	Qty.	Cat.	Catalog No.	Order No.
32 (1)	Siphon Plug Assembly (4 Jet)	1	C	6P605	1001352
39 (1)	Nozzle, "K"	1	C	6P7C-K	1001361
40 (1)	Nozzle, "M"	1	C	6P7C-M	1001362
44 (1)	Air Cap (Pinch-Cool; 10 holes)	1	C	6P3	1001343
45 (1)	Air Cap (Gun Cooling; 6 holes)	1	C	6P4	1001346
85	Lighter Flints (pkg. of 12)	1	C	5P183	1000823
89	Krytox®	1	C	16E97041	1070061
90	Powderlube	1	C	P119	1002137
97	Hardware Kit, Siphon Plug	1	C	6P855	1001367
117	Gas Valve Reseal O-Ring Package	1	W	5P280	1001161

1. Siphon plugs, nozzles and air caps kept as spares depend on usage and spraying application(s). See "Siphon Plug and Nozzle Assemblies" on page 8.

2 Parts List for 6P-II ThermoSpray™ Gun

Designation	Catalog No.	Order No.
6P-II ThermoSpray™ Gun	6P-II	1001371
6P-II-A Automatic ThermoSpray® Gun	6P-II-A	1001372
6P-II-H Hand Held ThermoSpray® Gun	6P-II-H	1001373
6P-II-HE Hand Held ThermoSpray® Gun (CE)	6P-II-HE	1036016

2.1 Complete Spray Gun Assembly



6P-II_complete

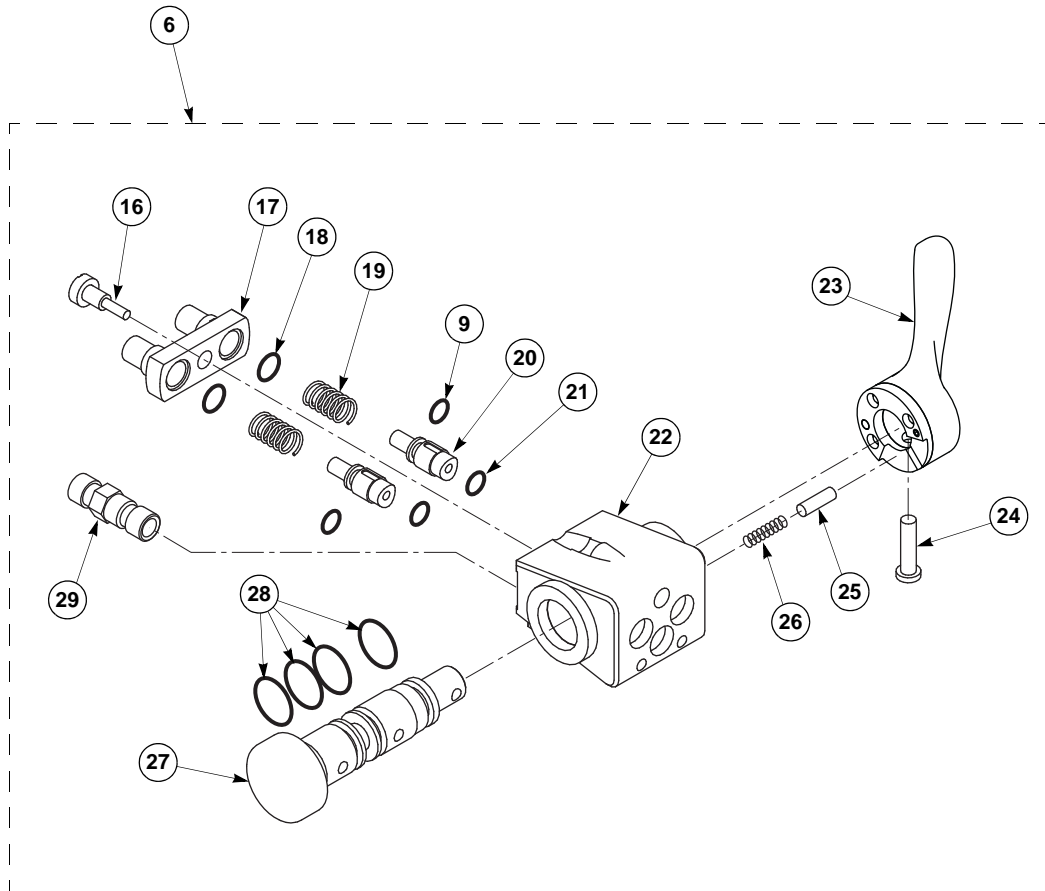


Item No.	Designation	Qty.	Catalog No.	Order No.
1	Powder Feed Tube	1	6P101	1001337
2	Powder Connection (optional; not shown)	—	825007-25	1004208
3	Powder Fitting (optional; not shown)	—	825007-26	1011010
4	Screw 8-32 X 1-7/8 <i>(pkg. of 5)</i>	2	5P103	1001142
5	Lock Washer <i>(pkg. of 5)</i>	3	5P59	1001182
6 (1)(2)(3)	Gas Valve Assembly	1	See page 6.	
7 (4)	Gas Feed Thru Block	1	See page 7.	
8	Gas Connection Tube <i>(pkg. of 2)</i>	3	P34	1002145
9	O-Ring, Buna, 0.239 x 0.07 in. <i>(pkg. of 2)</i>	3	4EFC56	1000861
10	Screw, 10-24 x 3/8 <i>(pkg. of 20)</i>	8	2W17	1000560
11	Gun Body <i>(includes item 12)</i>	1	6P40	1001347
12	O-Ring Si 0.145x0.07in <i>(pkg. of 5)</i>	2	5P184	1001152
13	Siphon Plug and Nozzle Assembly	1	See page 8.	
14 (1)(4)	Tool Post Mount	1	6P122	1001339
15 (2)(3)	Handle Assembly	1	See page 10.	

- 1. 6P-II
- 2. 6P-II-H
- 3. 6P-II-HE
- 4. 6P-II-A

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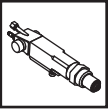
2.2 Gas Valve Assembly (6P-II, 6P-II-H & 6P-II-HE)



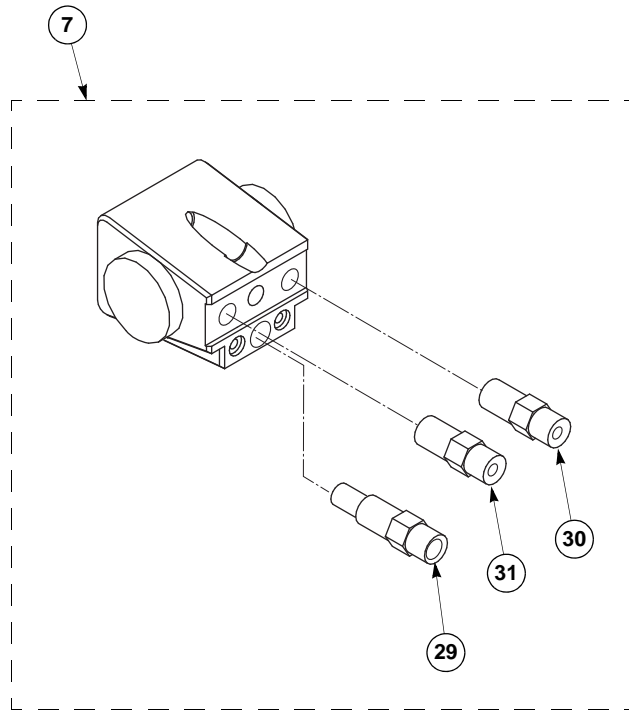
6P-II_gas_valve

Item No.	Designation	Qty.	Catalog No.	Order No.
6	Gas Valve Assembly <i>(includes items 9 & 22-26)</i>	1	6P5	1032141
9	O-Ring, Buna, 0.239 x 0.07 in. <i>(pkg. of 2)</i>	2	4EFC56	1000861
16	Screw, 1/4-20 X 0.802	1	5P199	1001159
17	Hose Connector Block	1	5P197	1001158
18	O-Ring, Buna, 0.364 x 0.07 in.	2	K137	1006359
19	Compression Spring <i>(pkg. of 2)</i>	2	5P194	1001157
20	Plunger	2	5P192	1001156
21	O-Ring, Viton, 0.176 x 0.07 in. <i>(pkg. of 2)</i>	2	3K306	1000657
22	Valve Block	1	6P92	1001368
23	Valve Handle Assembly	1	5P189	1001155
24	Screw, 10-24 X 3/4 <i>(pkg. of 5)</i>	1	4E31	1000829
25	Detent Pin	1	3K309	1000659
26	Compression Spring	1	3K317	1000660
27	Valve Core Assembly	1	5P187	1001154
28	O-Ring, Buna, 0.489 x 0.07 in. <i>(pkg. of 6)</i>	4	2M195	1000518
29	Air Hose Nipple Connector	1	5P98	1001197

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2.3 Gas Feed Thru Block (6P-II-A)



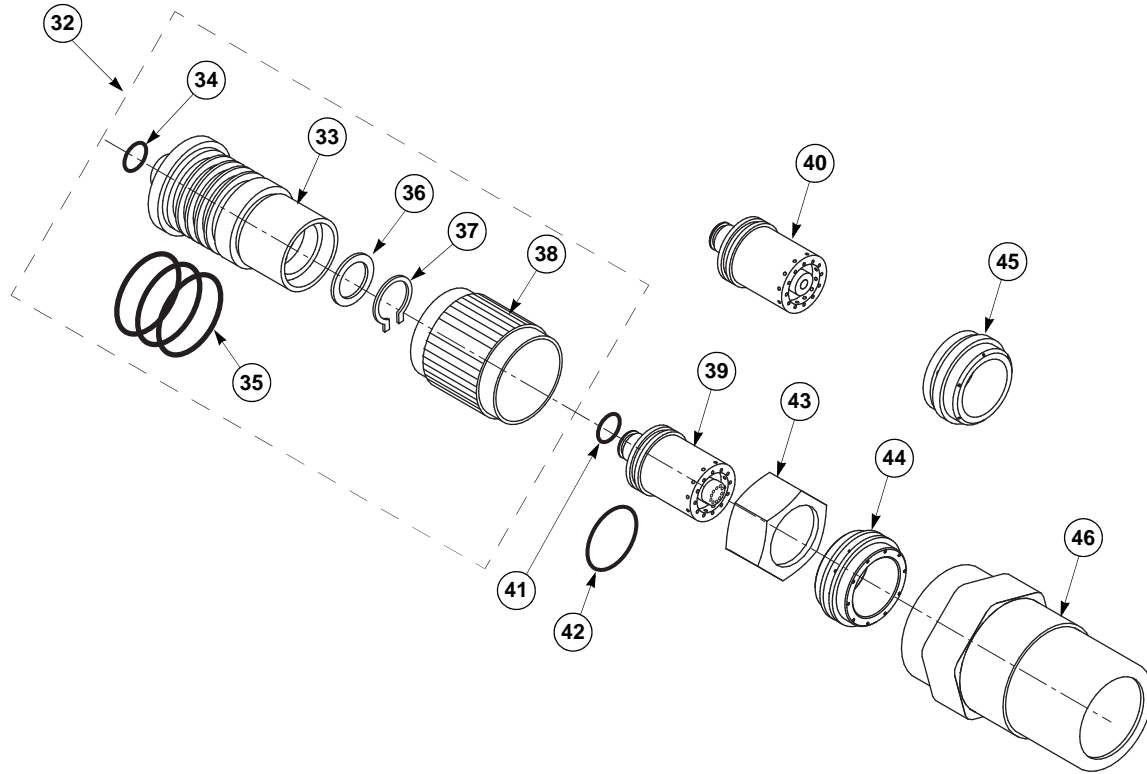
6P-II_gas_block

Item No.	Designation	Qty.	Catalog No.	Order No.
7	Gas Feed Thru Block <i>(includes items 29, 30 & 31)</i>	1	6P50	1005262
29	Air Hose Nipple Connector	1	5P98	1001197
30	Hex Nipple, 3/8-24 x 3/8-24	1	2E22	1000464
31	Hose Connector, 3/8-24UNF-2A-LH	1	4E21	1000825

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2.4 Siphon Plug and Nozzle Assemblies

2.4.1 Standard Parts



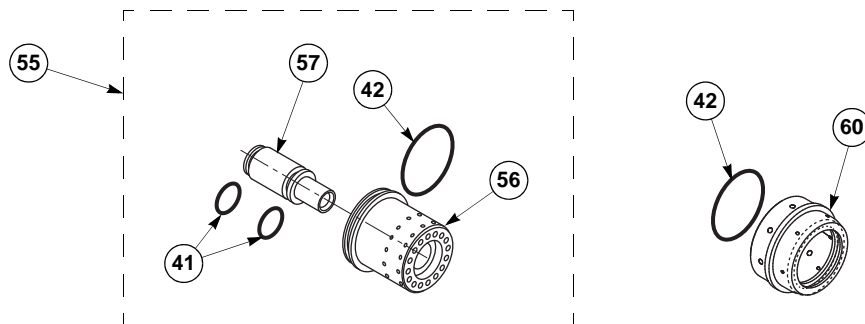
6P-II_front

Item No.	Designation	Qty.	Catalog No.	Order No.
32	Siphon Plug Assembly (4 Jet) <i>(includes items 34-38)</i>	1	6P605	1001352
33	Siphon Plug	1	—	—
34	O-Ring, Buna-N, 0.301 x 0.070 in. <i>(pkg. of 2)</i>	1	L186	1002023
35	O-Ring, Black Viton, 0.862 x 0.103 in.	3	2-118V	1019922
36	Baffle <i>(pkg. of 3)</i>	1	6P518	1001348
37	Retaining Ring <i>(pkg. of 5)</i>	1	N167	1002119
38	Sleeve	1	6P82	1001366
39	Nozzle, "K" <i>(acetylene, high spray rate; includes items 41&42)</i>	1	6P7C-K	1001361
40	Nozzle, "M" <i>(acetylene, standard; includes items 41&42)</i>	1	6P7C-M	1001362
41	O-Ring, Viton 0.239 x 0.07 in. <i>(pkg. of 2)</i>	1	3K217	1031639
42	O-Ring, Viton 0.739 x 0.07 in.	1	2-018V	1018375
43	Nozzle Nut	1	6P525	1001349
44	Air Cap <i>(Pinch-Cool; 10 holes)</i>	1	6P3	1001343
45	Air Cap <i>(Gun Cooling; 6 holes)</i>	1	6P4	1001346
46	Air Cap Body	1	6P117	1001338

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2.4.2 Optional Nozzles, Siphon Plugs and Packages

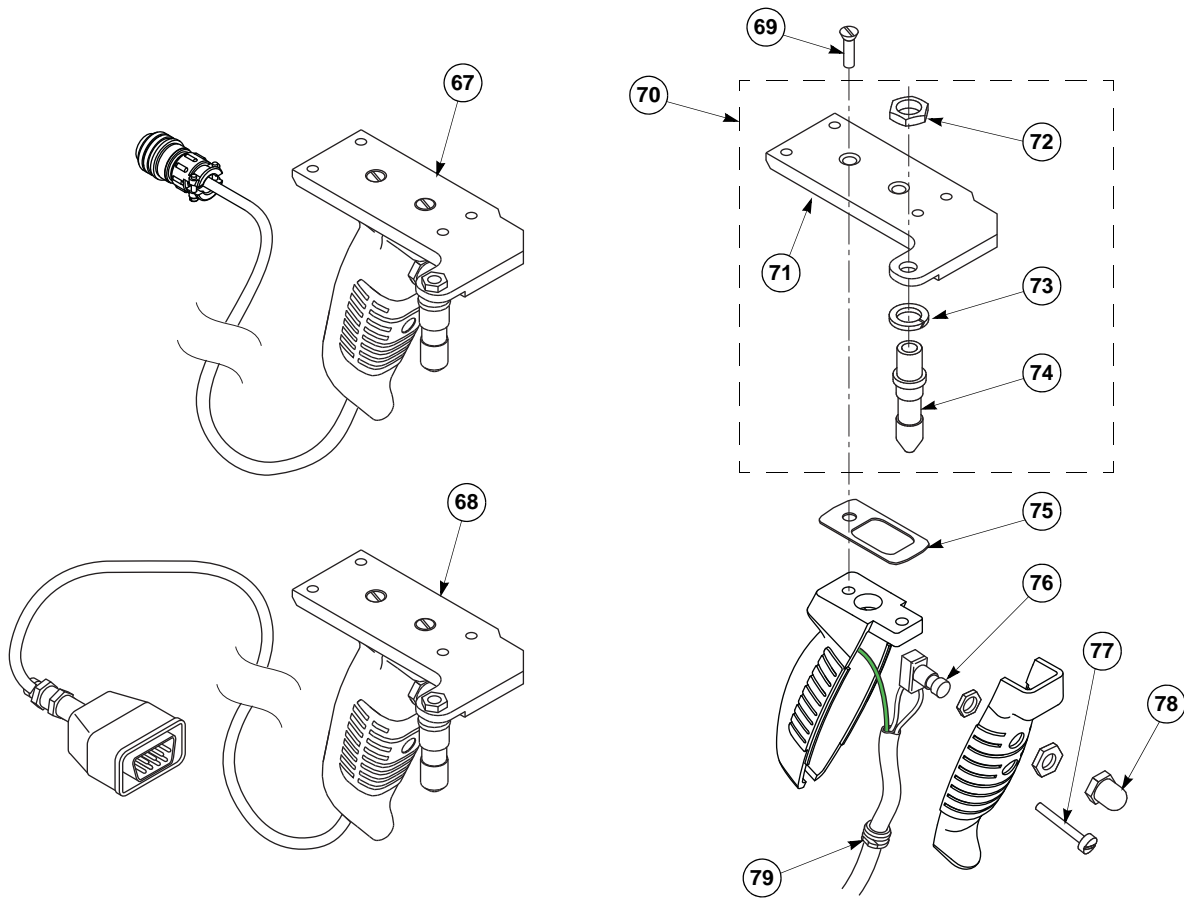


6P-II_nozzle_2pc

Item No.	Designation	Qty.	Catalog No.	Order No.
Nozzles				
47	Nozzle, No.1 (MPS) <i>(includes items 41 & 42)</i>	—	6P7C-1	1005264
48	Nozzle, "B" <i>(includes items 41 & 42)</i>	—	6P7C-B	1001358
49	Nozzle, "D" (acetylene) <i>(includes items 41 & 42)</i>	—	6P7C-D	1001359
50	Nozzle, "F" (hydrogen) <i>(includes items 41 & 42)</i>	—	6P7C-F	1001360
51	Nozzle, "H" (acetylene) <i>(includes items 41 & 42)</i>	—	6P7C-H	1005265
52	Nozzle, "MH" (hydrogen) <i>(includes items 41 & 42)</i>	—	6P7C-MH	1001363
53	Nozzle, "N" (Concentrating) <i>(includes items 41 & 42)</i>	—	6P7C-N	1001364
54	Nozzle, "P" (Propane) <i>(includes items 41 & 42)</i>	—	6P7C-P	1032145
55	Nozzle, "750" (Thermoplastics) <i>(includes items 56 & 57)</i>	—	6P750	1032149
56	Nozzle Body <i>(includes item 42)</i>	1	6P750A	1032150
57	Nozzle Insert <i>(includes item 41 x 2)</i>	1	6P750B	1032151
Siphon Plugs & Packages				
58	Siphon Plug Assembly (2 Jet) <i>(includes items 34-38)</i>	—	6P600	1001351
59	Siphon Plug Package (4 Jet; Acetylene) <i>(includes items 32, 43, 51, & 60)</i>	—	6P625	1018744
60	Air Cap (6 & 8 holes) <i>(includes item 42)</i>	1	6P36	1015333
61	Siphon Plug Package (2 Jet) <i>(includes items 40, 43 & 58)</i>	—	6P645	1001353
62	Siphon Plug Package (4 Jet) <i>(includes items 32, 40 & 43)</i>	—	6P655	1001354
63	Siphon Plug Package (4 Jet) <i>(includes items 32, 43 & 49)</i>	—	6P675	1001355
64	Siphon Plug Package (4 Jet) <i>(includes items 32, 39 & 43)</i>	—	6P690	1001356
65	Siphon Plug Assembly (2 Jet) <i>(includes items 34-38)</i>	—	6P800	1032154
66	Siphon Plug Package (2 Jet; Propane) <i>(includes items 43, 54, 60 & 65)</i>	—	6P825	1015335

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2.5 Handle Assembly



6P-II_handle_assy

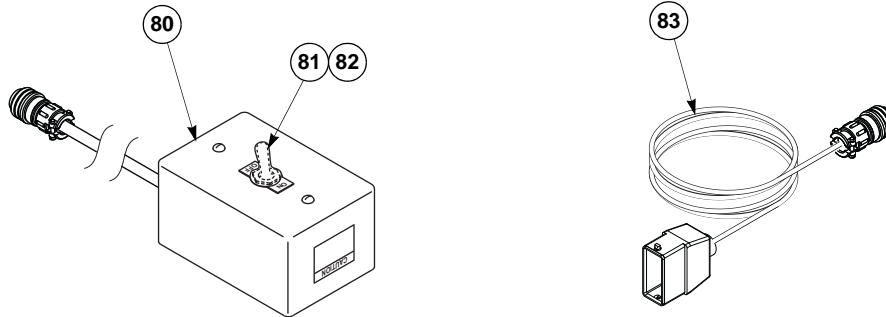
Item No.	Designation	Qty.	Catalog No.	Order No.
67 ⁽¹⁾	Control Handle Assembly (Non-CE) <i>(includes items 69–79)</i>	1	DJ125	1001800
68 ⁽²⁾	Control Handle Assembly (CE) <i>(includes items 69–79)</i>	1	MPHE	1049830
69	Screw, 1/4-20 X 5/8L	2	RG183	1006090
70	Tool Post Mounting Assembly <i>(includes items 71–74)</i>	1	DJ126	1006360
71	Tool Post Bracket	1	—	—
72	Jam Nut, 5/16-24	1	4E123	1000818
73	Lock Washer	1	4E124	1000819
74	Mounting Stud	1	5P122	1001146
75	Gasket	1	6P286	1032137
76	Pushbutton Switch	1	3M341	1000695
77	Screw, 10-32 X 1-1/4	1	7M27	1032348
78	Push Button Boot	1	3M670	1000713
79	Strain Relief Bushing	1	3K434	1004954

1. 6P-II-H
2. 6P-II-HE



3 Additional Equipment

3.1 Equipment Supplied with 6P-II ThermoSpray™ Gun



6P-II_accessories

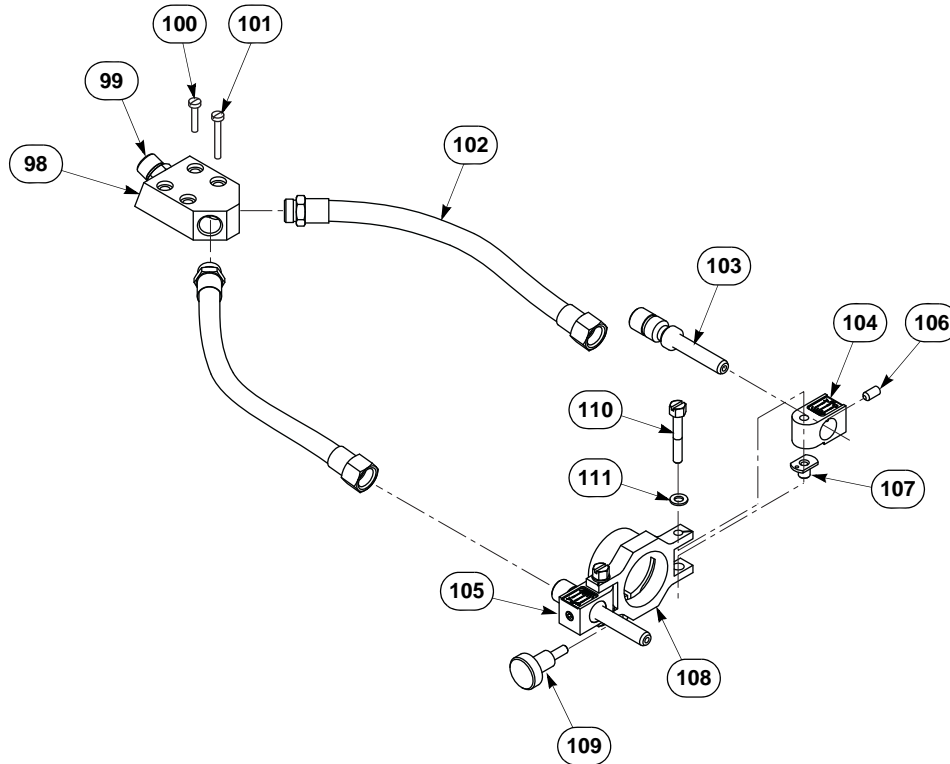
Item No.	Designation	Qty.	Catalog No.	Order No.
80 ⁽¹⁾	Remote Assembly	1	6P590	1001350
81	Toggle Switch	1	RG118	1028975
82	Toggle Switch Boot	1	RG19	1006091
83 ⁽¹⁾⁽²⁾⁽³⁾	Adapter Cable (for connection to CE powder feeders)	1	5MPE58365	1049831
Tools and Spares				
84	Spark Lighter, Round File	1	4E101	1000813
85	Lighter Flints	(not supplied; pkg. of 12)	5P183	1000823
86	Retaining Ring Pliers	1	5P164	1001148
87	Black Bristle Brush	1	P115	1002134
88	Universal Wire Cleaning Kit	1	4E114	1000817
89	Krytox®	1	16E97041	1070061
90	Powderlube	1	P119	1002137
91	Safety Package	(includes items 92–94)	DJ297	1015366
92	Ear Plug	(pkg. of 2)	DJ292	1001833
93	Earmuff Hearing Protectors	1	DJ294	1035521
94	Eye Protectors, Shade 5 Lens	1	10E193	1000097
95	Goggles, Lens Shade 5	(not supplied)	10E195	1000098
96	Protective Impact Cover Plate	(not supplied)	10E196	1000099
97	Hardware Kit, Siphon Plug	(includes following items)	6P855	1001367
34	O-Ring, Buna-N, 0.301 x 0.070 in.	1	L186	1002023
35	O-Ring, Black Viton, 0.862 x 0.103 in.	3	2-118V	1019922
36	Baffle	1	6P518	1001348
37	Retaining Ring	1	N167	1002119
41	O-Ring, Viton 0.239 x 0.07 in.	1	3K217	1031639
42	O-Ring, Viton 0.739 x 0.07 in.	1	2-018V	1018375

1. 6P-II
2. 6P-II-A
3. 6P-II-H

3.2 Options and Accessories

(Ordered separately.)

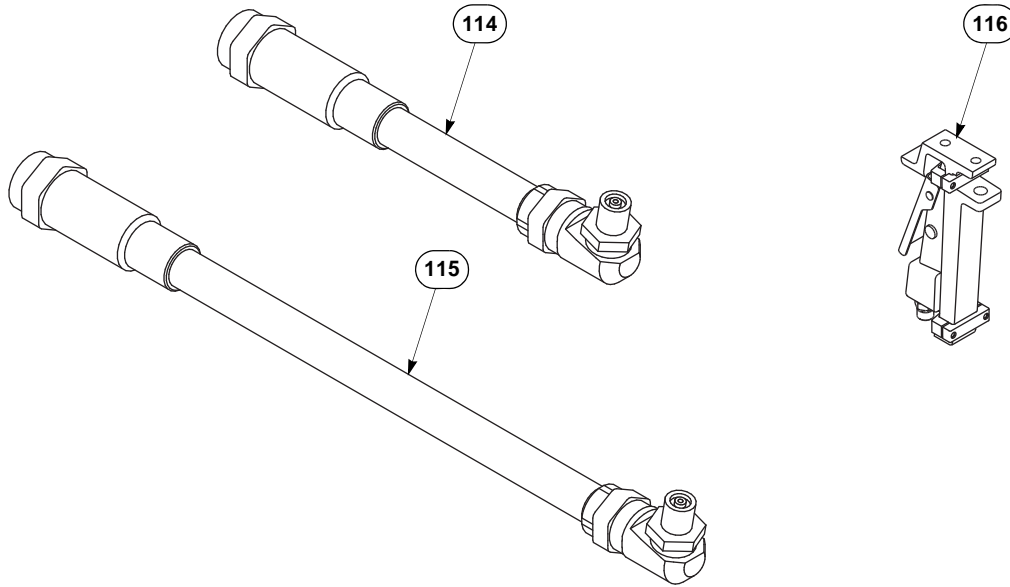
Air Jet Assembly (includes items 98-113)	—	6P330	1001344
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6P-II_6P330

Item No.	Designation	Qty.	Catalog No.	Order No.
98	Air Block	1	6P76	1032152
99	Hex Nipple	1	4E20	1000824
100	Screw, 10-24 x 1"	4	2M192	1000516
101	Screw, 10-24 x 1-3/8"	4	—	—
102	Jet Hose, 6-1/2"	2	6P251	1001341
103	Air Nozzle	2	6P335	1001345
104	Pivot Block, Left	1	2PSA26	1000537
105	Pivot Block, Right	1	2PSA24	1000535
106	Hex Set Screw (pkg. of 2)	2	2PSA37	1000542
107	Nut, Pivot Block	2	2PSA28	1000539
108	Air Cooler Head	1	2PSA25	1000536
109	Thumb Screw	1	PS32	1002326
110	Pivot Clamp Screw	2	2PSA27	1000538
111	Flat Washer	2	2E44	1000465
112	Air Hose Assembly, 4.6m (15')	1	6H50	1001319
113	Hex Key Wrench (3/32")	1	PS43	1002327

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5P-II_acc

Item No.	Designation	Qty.	Catalog No.	Order No.
114	1-Foot Gun Extension <i>(Refer to MAN 43620.)</i>	—	6PTII-1	1005270
115	2-Foot Gun Extension <i>(Refer to MAN 43620.)</i>	—	6PTII-2	1001379
116	Safety Handle Assembly <i>(Refer to MAN 42839.)</i>	—	SHA58511	1065886
117	Gas Valve Reseal O-Ring Package <i>(includes following items)</i>	—	5P280	1001161
9	O-Ring, Buna, 0.239 x 0.07 in.	2	4EFC56	1000861
28	O-Ring, Buna, 0.489 x 0.07 in.	4	2M195	1000518
21	O-Ring, Viton, 0.176 x 0.07 in.	2	3K306	1000657
18	O-Ring, Buna, 0.364 x 0.07 in.	2	K137	1006359

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3.2.1 Hoses

(Ordered separately.)

Item No.	Designation	Qty.	Catalog No.	Order No.
118	8H Hose Package (1.2 m / 4') (regulators to 4GF)	—	8H	1032414
119	Oxygen Hose	1	GF5	1022314
120	Fuel Gas Hose	1	GF6	1022315
121	8HEX Hose Package (1.2 m / 4') (regulators to 4GF)	—	8HEX	1001581
122	Oxygen Hose (Blue)	1	8HEX54992	1020473
123	Fuel Hose (Red)	2	8HEX54998	1032415
124	9H Hose Package (4.6 m / 15') (regulators to 4GF)	—	9H	1020786
125	Oxygen Hose	1	CP121	1005802
126	Fuel Hose	1	CP124	1022137
127	9HEX Hose Package (4.6 m / 15') (regulators to 4GF)	—	9HEX	1001617
128	Oxygen Hose (Blue)	1	9HEX54996	1018752
129	Fuel Hose (Red)	2	9HEX54999	1018753
130	12H Hose Package (4.6 m / 15') (4GF/4AF to gun)	—	12H	1031132
131	Twin Oxygen and Acetylene Hose (Green/Red)	1	6H40	1001318
132	Air Hose (Black)	1	AJ10	1001746
133	12HEX Hose Package (4.6 m / 15') (4GF/4AF to gun)	—	12HEX	1000297
134	Oxygen Hose (Blue)	1	6HEX54978	1001321
135	Acetylene Hose (Red)	2	6HEX55000	1001322
132	Air Hose (Black)	1	AJ10	1001746
136	14H Hose Package (10.7 m / 35') (4GF/4AF to gun)	—	14H	1031435
137	Twin Oxygen and Acetylene Hose (Green/Red)	1	7H40	1032254
138	Air Hose (Black)	1	5K935	1001129
139	14HEX Hose Package (10.7 m / 35') (4GF/4AF to gun)	—	14HEX	1004757
140	Oxygen Hose (Blue)	1	7HEX54984	1001454
141	Fuel Hose (Red)	2	7HEX55001	1001455
138	Air Hose (Black)	1	5K935	1001129

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