

5P-II ThermoSpray™ Gun Combustion Powder Spraying


Parts List
PL 75838 EN 09




Oerlikon Metco (US) Inc.

1101 Prospect Avenue

Westbury NY 11590

 +1 516 334 1300

 +1 516 338 2414

www.oerlikon.com/metco

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

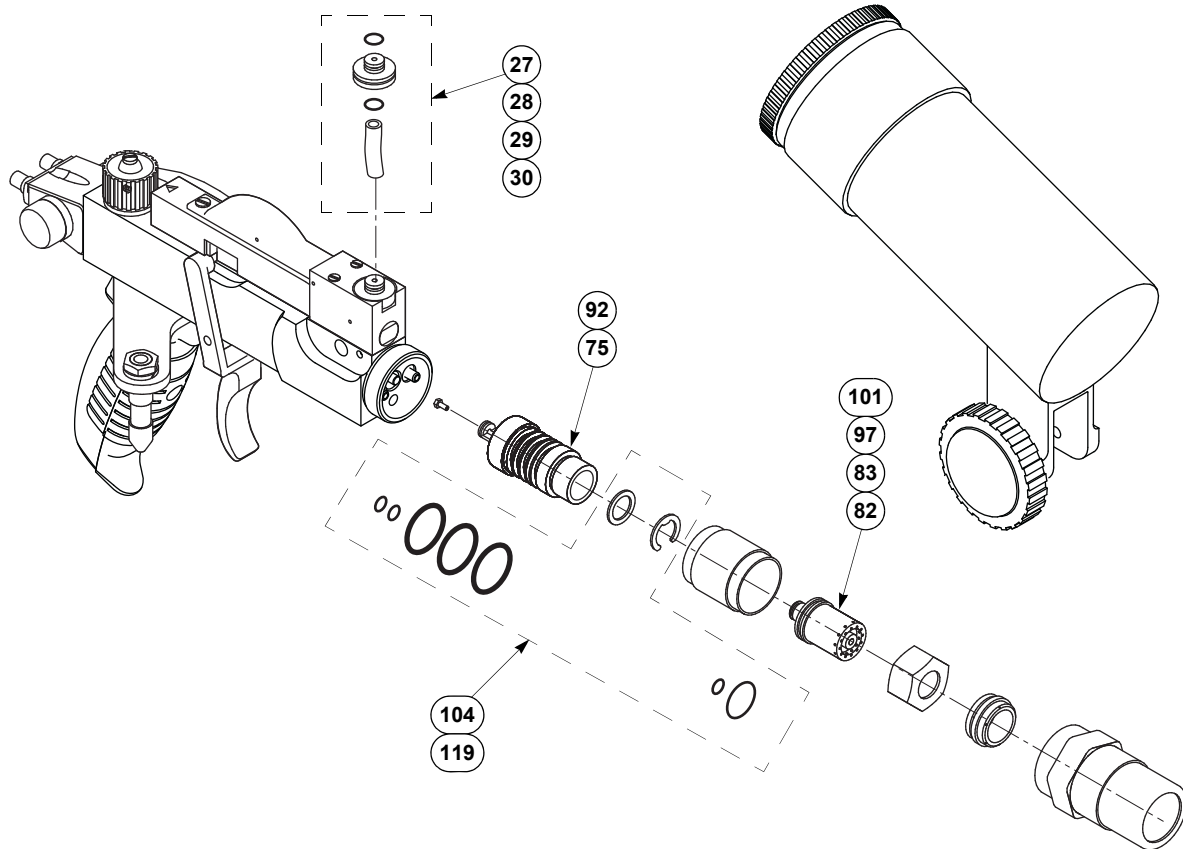
Parts recommended in order to guarantee maximum availability of component. This prevents downtime caused by delay in procurement.



Warranty Disclaimer

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

1 List of Recommended Spare Parts for 5P-II ThermoSpray™ Gun



5P-II_spare

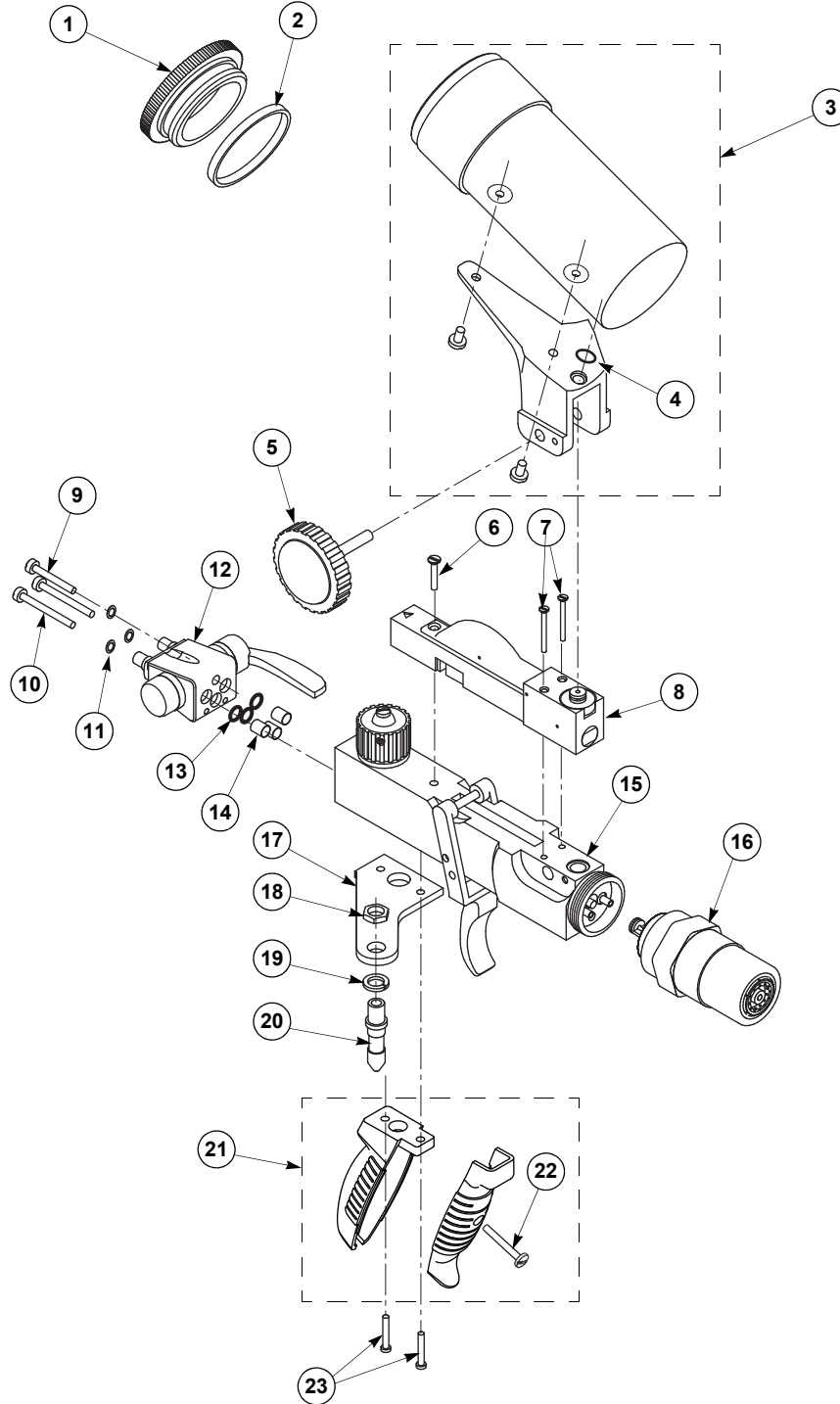
Item No.	Description	Qty.	Cat.	Catalog No.	Order No.
27	Metering Valve Assembly #11	1	C	5P8-11	1001194
28	Metering Valve Assembly #12	1	C	5P8-12	1001195
29	Metering Valve Assembly #15	1	C	N8-15	1002120
30	Metering Valve Assembly #16 (optional)	1	C	5P8-16	1020352
75	Siphon Plug Assembly (standard)	1	C	5P585	1001181
82	"F" Nozzle	1	C	5P7B-F	1001190
83	"G" Nozzle	1	C	5P7B-G	1001191
92	Siphon Plug Assembly (high spray rate)	1	C	5P510	1001170
97	"K" Nozzle	1	C	6P7C-K	1001361
101	"M" Nozzle	1	C	6P7C-M	1001362
104	Spare Parts Package (high spray rate)	1	C	5P514	1001171
119	Spare Parts Package (standard)	1	C	5P595	1001184

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2 Parts List for 5P-II ThermoSpray™ Gun

Designation	Catalog No.	Order No.
5P-II ThermoSpray™ Gun	5P-II	1001200

2.1 Complete Spray Gun Assembly



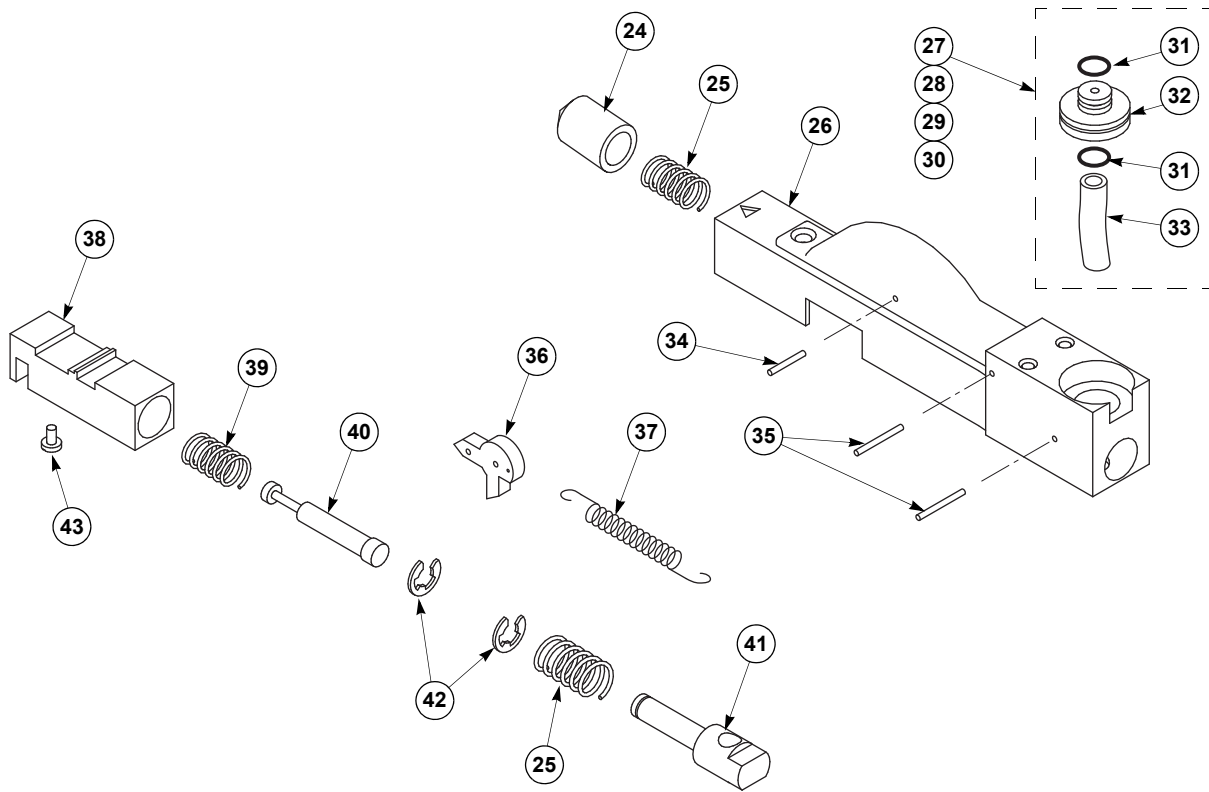
5P-II_complete

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Item No.	Designation	Qty.	Catalog No.	Order No.
1	Canister Cover	1	5P590	1001183
2	U-Cup, 2.360 X 1.765 X 5/16, Buna-N	1	5P91	1001196
3	Canister Assembly (includes item 4)	1	5P581	1001180
4	O-Ring, Buna, 0.364 x 0.07 in. (pkg. of 3)	1	K137	1006359
5	Handle	1	5P66	1001187
6	Screw, 8-32 X 7/8 (pkg. of 5)	1	P49	1006024
7	Screw, 6-32 X 1-1/4 (pkg. of 5)	2	P64	1002157
8	Valve Bolt Housing Assembly	1	See page 6.	
9	Screw, 8-32 X 1-3/8 (pkg. of 5)	1	5P102	1001141
10	Screw 8-32 X 1-7/8 (pkg. of 5)	2	5P103	1001142
11	Lock Washer (pkg. of 5)	3	5P59	1001182
12	Gas Valve Assembly	1	See page 7.	
13	O-Ring, Buna, 0.239 x 0.07 in. (pkg. of 2)	3	4EFC56	1000861
14	Gas Connection Tube (pkg. of 2)	3	P34	1002145
15	Gun Body Assembly	1	See page 8.	
16	Siphon Plug Assembly	1	See page 9.	
17	Tool Post Bracket	1	5P121	1001145
18	Jam Nut (pkg. of 5)	1	4E123	1000818
19	Lock Washer (pkg. of 5)	1	4E124	1000819
20	Mounting Stud	1	5P122	1001146
21	Handle Assembly (includes item 22)	1	5P627	1001186
22	Screw, 10-32 X 1-1/4 (pkg. of 4)	1	7M27	1032348
23	Screw, 10-24 X 5/8 (pkg. of 5)	2	4E96	1000860



2.2 Valve Bolt Housing Assembly

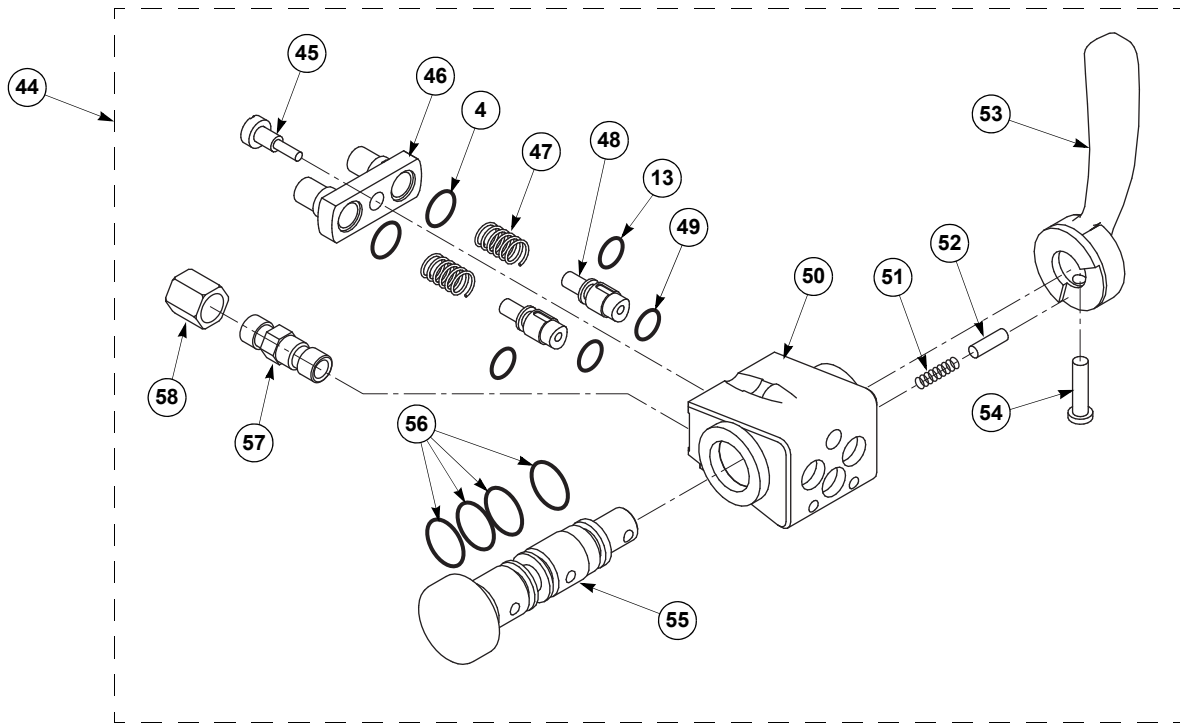


5P-II_valvebolt

Item No.	Designation	Qty.	Catalog No.	Order No.	
24	Detent Pin	1	P36	1002146	
25	Compression Spring	2	P37	1002147	
26	Bolt Housing	1	5P46	1001167	
27	Metering Valve Assembly #11	(includes items 31–33)	1	5P8-11	1001194
28	Metering Valve Assembly #12	(includes items 31–33)	1	5P8-12	1001195
29	Metering Valve Assembly #15	(includes items 31–33)	1	N8-15	1002120
30	Metering Valve Assembly #16 (optional; includes items 31–33)	—	5P8-16	1020352	
31	O-Ring, Buna 0.176 x 0.07 in.	(pkg. of 3)	2	K180	1028632
32	Meter Plug	1	—	—	
33	Valve Tube	1	5P141	1001147	
34	Pawl Pin	(pkg. of 5)	1	P45	1018704
35	Pin	(pkg. of 5)	2	P47	1006023
36	Pawl	1	P43	1002150	
37	Pawl Extension Spring	1	P44	1002151	
38	Ratchet	1	P53	1002154	
39	Override Spring	1	P51	1002153	
40	Override Bar	1	P50	1002152	
41	Valve Shaft Bolt	1	5P40	1001166	
42	Snap Ring	(pkg. of 5)	1	P42	1002149
43	Screw, 4-40 X 3/16	(pkg. of 5)	1	4E89	1005041



2.3 Gas Valve Assembly

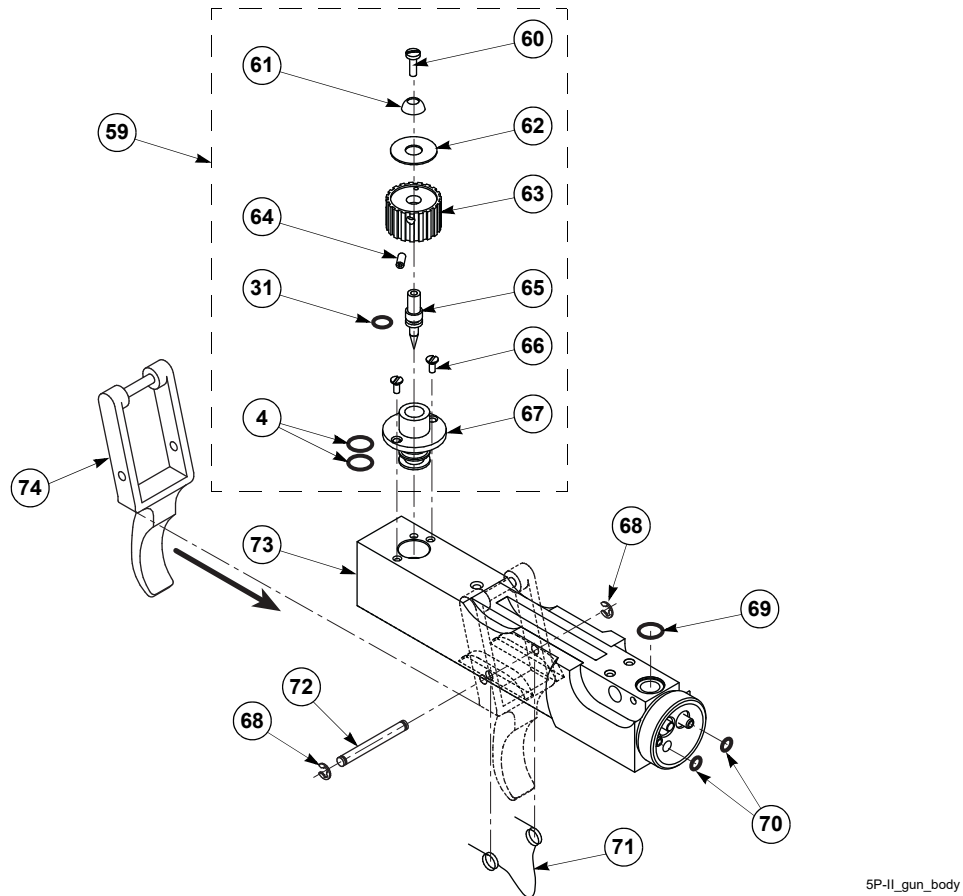


5P-II_gas_valve

Item No.	Designation	Qty.	Catalog No.	Order No.
4	O-Ring, Buna, 0.364 x 0.07 in. (pkg. of 3)	2	K137	1006359
13	O-Ring, Buna, 0.239 x 0.07 in. (pkg. of 2)	2	4EFC56	1000861
44	Gas Valve Assembly (includes items 4, 13 & 45–58)	1	5P5	1001168
45	Screw, 1/4-20 X 0.802	1	5P199	1001159
46	Hose Connector Block	1	5P197	1001158
47	Compression Spring (pkg. of 2)	2	5P194	1001157
48	Plunger	2	5P192	1001156
49	O-Ring, Black Viton, 0.176 x 0.07 in. (pkg. of 2)	2	3K306	1000657
50	Valve Block Assembly	1	5P186	1001153
51	Compression Spring	1	3K317	1000660
52	Detent Pin	1	3K309	1000659
53	Valve Handle Assembly	1	5P189	1001155
54	Screw, 10-24 X 3/4 (pkg. of 5)	1	4E31	1000829
55	Valve Core Assembly	1	5P187	1001154
56	O-Ring, Buna, 0.489 x 0.07 in. (pkg. of 6)	4	2M195	1000518
57	Air Hose Nipple Connector	1	5P98	1001197
58	Air Hose Connection Cap	1	5P99	1001198

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2.4 Gun Body Assembly

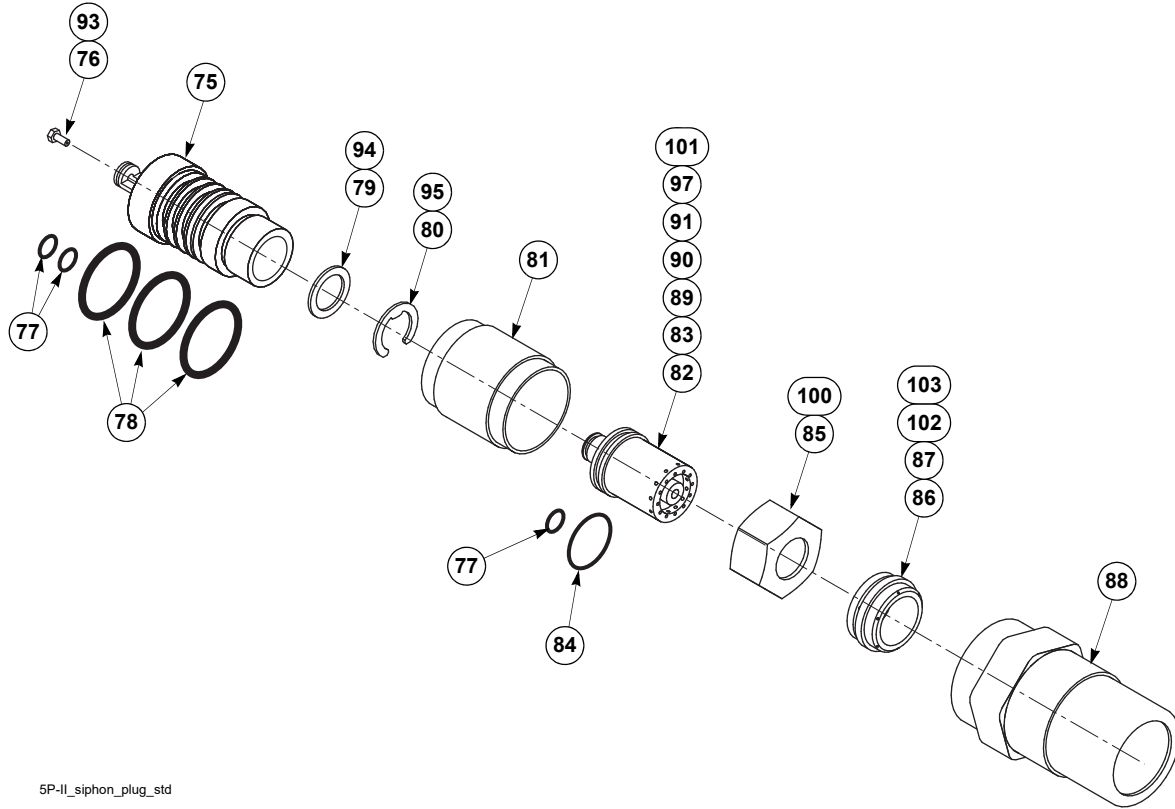


Item No.	Designation	Qty.	Catalog No.	Order No.
4	O-Ring, Buna, 0.364 x 0.07 in. (pkg. of 3)	2	K137	1006359
31	O-Ring, Buna 0.176 x 0.07 in. (pkg. of 3)	1	K180	1028632
59	Flow Control Valve Assembly (includes items 4, 31 & 60–67)	1	5P526	1001176
60	Screw, 6-32 X 1/4 (pkg. of 5)	1	P41	1028881
61	Retainer	1	5P39	1031894
62	Dial Plate	1	P38	1002148
63	Valve Knob (includes item 64)	1	5P552	1031900
64	Set Screw, 8-32 X 1/4 (pkg. of 2)	2	4E41	1000837
65	Valve Stem	1	—	—
66	Screw, 4-40 X 1/4	2	4E26	1000827
67	Valve Body	1	—	—
68	Retainer Ring (pkg. of 5)	2	5P32	1001163
69	O-Ring, 0.301 X 0.070, Buna-N (pkg. of 2)	1	L186	1002023
70	O-Ring Si 0.145x0.07in (pkg. of 5)	2	5P184	1001152
71	Trigger Spring	1	5P33	1001164
72	Trigger Pin	1	5P31	1018705
73	Gun Body Assembly	1	5P625	1018725
74	Trigger	1	5P30	1005217



2.5 Siphon Plug Assembly

2.5.1 Standard Siphon Plug Assembly



5P-II_siphon_plug_std

Item No.	Designation	Qty.	Catalog No.	Order No.
75	Siphon Plug Assembly (includes items 76–81)	1	5P585	1001181
76	Aspirator Jet, 4-40 X 0.212	1	P1	1002122
77	O-Ring, Black Viton, 0.176 x 0.07 in. (pkg. of 3)	3	5P515	1001172
78	O-Ring, Black Viton, 0.799 x 0.103 in. (pkg. of 3)	3	5P516	1001173
79	Baffle	1	6PT266	1001375
80	Retaining Ring (pkg. of 3)	1	5P167	1001151
81	Sleeve	1	5P519	1001174
82	"F" Nozzle (includes items 77 & 84)	1	5P7B-F	1001190
83	"G" Nozzle (includes items 77 & 84)	1	5P7B-G	1001191
84	O-Ring, Black Viton, 0.551 x 0.07 in.	1	2-015V	1006226
	O-Ring, Black Viton, 0.551 x 0.07 in. (pkg. of 2)		11E108	1000138
85	Nozzle Nut	1	5P575	1001177
86	Air Cap (Pinch-Cool; marked "P" & "C")	1	5P576	1001178
87	Air Cap (Gun Cooling; marked "B")	1	5P577	1001179
88	Air Cap Body	1	5P501	1001169
Optional Nozzles				
89	"B" Nozzle (includes items 77 & 84)	—	5P7B-B	1001188
90	"D" Nozzle (includes items 77 & 84)	—	5P7B-D	1001189
91	"N" Nozzle (Concentrating) (includes items 77 & 84)	—	5P7B-N	1001192

2.5.2 High Spray Rate Siphon Plug Components (Optional)

Item No.	Designation	Qty.	Catalog No.	Order No.
92	Siphon Plug (includes items 77, 78, 81 & 93–95)	—	5P510	1001170
93	Jet Screw, 4-40 X 0.212	1	5P520	1001175
94	Baffle (pkg. of 3)	1	6P518	1001348
95	Retaining Ring (pkg. of 5)	1	N167	1002119
96	“K” Nozzle & Siphon Plug (includes items 92, 97–100)	—	5P54707	1031898
97	“K” Nozzle (includes items 98 & 99)	1	6P7C-K	1001361
98	O-Ring, Black Viton, 0.239 x 0.07 in. (pkg. of 2)	1	3K217	1031639
99	O-Ring, Black Viton, 0.739 x 0.07 in.	1	2-018V	1018375
	O-Ring, Black Viton, 0.739 x 0.07 in. (pkg. of 2)		3K218	1000646
100	Nozzle Nut	1	6P525	1001349
101	“M” Nozzle (includes items 98 & 99)	—	6P7C-M	1001362
102	Air Cap (Pinch-Cool; 10 holes; marked “P” & “C”)	—	6P3	1001343
103	Air Cap (Gun Cooling; 6 holes)	—	6P4	1001346
104	Siphon Plug & Nozzle Spare Parts Package (includes items 77, 78, 94, 95, 98 & 99)	—	5P514	1001171
105	High Spray Rate Retrofit Kit (includes items 27, 28, 88, 92–104)	—	5P500	1031895
106	High Spray Rate Hardware Package (includes items 96–104)	—	5P54712	1031899

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3 Additional Equipment

3.1 Tools and Spares

Item No.	Designation	Qty.	Catalog No.	Order No.
Supplied with 5P-II ThermoSpray™ Gun				
107	Spark Lighter, Round File	1	4E101	1000813
108	Lighter Flints (pkg. of 10)	—	4E183	1000823
109	Retaining Ring Pliers	1	5P164	1001148
110	Hex Wrench, #6	1	4E102	1005028
111	Black Bristle Brush	1	P115	1002134
112	Universal Wire Cleaning Kit	1	4E114	1000817
113	Krytox®	1	16E97041	1070061
114	Powderlube	1	P119	1002137
115	Safety Package (Refer to AI 43566.) (includes items 116–118)	1	DJ297	1015366
116	Ear Plug (pkg. of 2)	6	DJ292	1001833
117	Earmuff Hearing Protectors	1	DJ294	1035521
118	Eye Protectors, Shade 5 Lens	1	10E193	1000097
119	Spare Parts Kit (includes following items)	1	5P595	1001184
31	O-Ring, Buna 0.176 x 0.07 in.	3	K180	1028632
33	Valve Tube	1	5P141	1001147
77	O-Ring, Black Viton 0.176 x 0.07 in.	6	5P515	1001172
78	O-Ring, Black Viton 0.799 x 0.103 in.	3	5P516	1001173
79	Baffle	3	6PT266	1001375
80	Retaining Ring	3	5P167	1001151
84	O-Ring, Black Viton 0.551 x 0.07 in.	2	11E108	1000138
Optional				
120	Goggles, Lens Shade 5 (spare)	—	10E195	1000098
121	Protective Impact Cover Plate (spare)	—	10E196	1000099
122	Gas Valve Reseal O-Ring Package (includes following items)	—	5P280	1001161
4	O-Ring, Buna, 0.364 x 0.07 in.	2	K137	1006359
13	O-Ring, Buna, 0.239 x 0.07 in.	2	4EFC56	1000861
49	O-Ring, Black Viton, 0.176 x 0.07 in.	2	3K306	1000657
56	O-Ring, Buna, 0.489 x 0.07 in.	4	2M195	1000518

3.2 Hoses

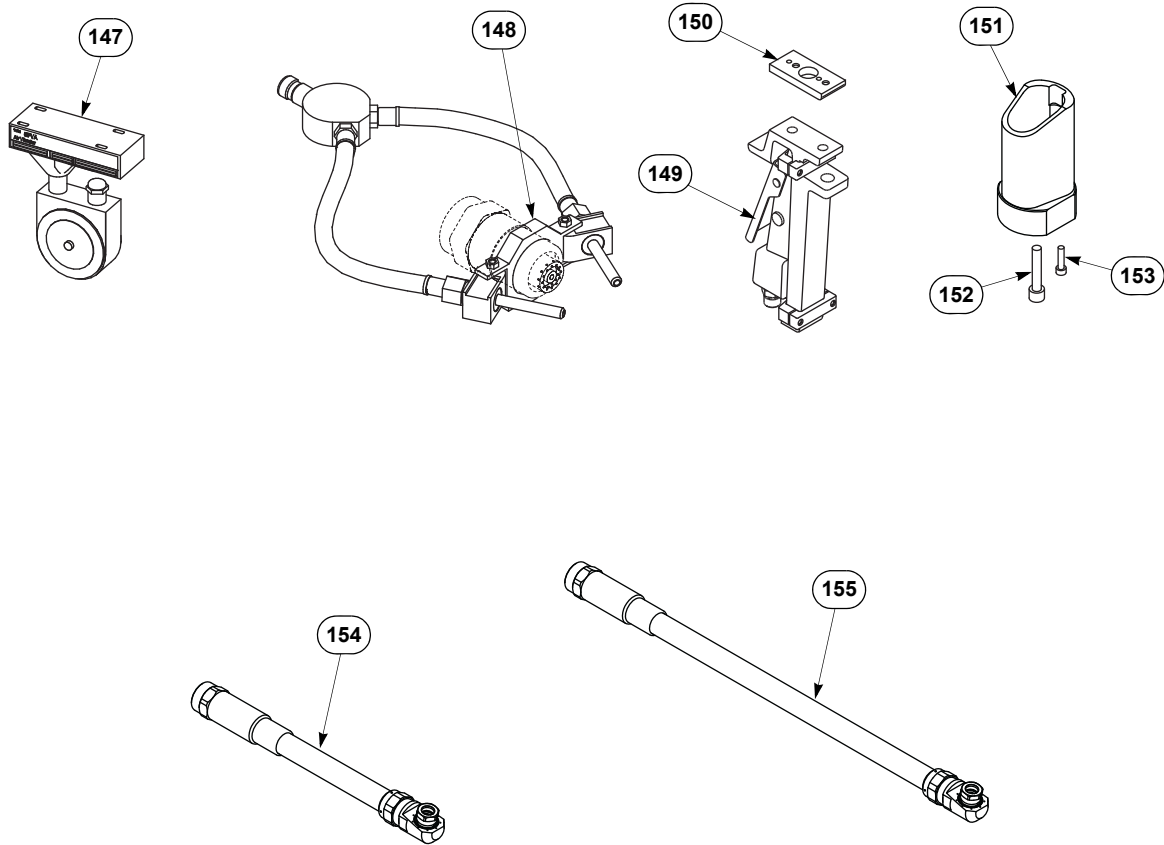
(Ordered Separately)

Item No.	Designation	Qty.	Catalog No.	Order No.
123	8H Hose Package (1.2 m / 4') (regulators to 4GF)	—	8H	1032414
124	Oxygen Hose	1	GF5	1022314
125	Fuel Gas Hose	1	GF6	1022315
126	8HEX Hose Package (1.2 m / 4') (regulators to 4GF)	—	8HEX	1001581
127	Oxygen Hose (Blue)	1	8HEX54992	1020473
128	Fuel Hose (Red)	2	8HEX54998	1032415
129	9H Hose Package (4.6 m / 15') (regulators to 4GF)	—	9H	1020786
130	Oxygen Hose	1	CP121	1005802
131	Fuel Hose	1	CP124	1022137
132	9HEX Hose Package (4.6 m / 15') (regulators to 4GF)	—	9HEX	1001617
133	Oxygen Hose (Blue)	1	9HEX54996	1018752
134	Fuel Hose (Red)	2	9HEX54999	1018753
135	12H Hose Package (4.6 m / 15') (4GF/4AF to gun)	—	12H	1031132
136	Twin Oxygen and Acetylene Hose (Green/Red)	1	6H40	1001318
137	Air Hose (Black)	1	AJ10	1001746
138	12HEX Hose Package (4.6 m / 15') (4GF/4AF to gun)	—	12HEX	1000297
139	Oxygen Hose (Blue)	1	6HEX54978	1001321
140	Fuel Hose (Red)	2	6HEX55000	1001322
137	Air Hose (Black)	1	AJ10	1001746
141	14H Hose Package (10.7 m / 35') (4GF/4AF to gun)	—	14H	1031435
142	Twin Oxygen and Acetylene Hose (Green/Red)	1	7H40	1032254
143	Air Hose (Black)	1	5K935	1001129
144	14HEX Hose Package (10.7 m / 35') (4GF/4AF to gun)	—	14HEX	1004757
145	Oxygen Hose (Blue)	1	7HEX54984	1001454
146	Fuel Hose (Red)	2	7HEX55001	1001455
143	Air Hose (Black)	1	5K935	1001129

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3.3 Accessories

(Ordered Separately)



5P-II_acc

Item No.	Designation	Qty.	Catalog No.	Order No.
147	5PVA Vibrator Unit (Refer to AI 43589.)	—	5PVA	1001206
148	2PSA Air Jet Unit (Refer to AI 92395.)	—	2PSA	1000534
149	Safety Handle Assembly (Refer to MAN 42839.)	—	SHA58511	1065886
150	Safety Handle Adapter Plate, 5P-II (Required with item 149.)	—	SHA89764	1058330
151	Gun Holder (includes items 152 & 153)	—	16E99163	1072072
152	Screw, M10 X 40 mm	1	02002001040	1054774
153	Screw, M6 X 16 mm (pkg. 4)	4	10MB73	1030553
154	1-Foot Extension (Refer to MAN 43638.)	—	5PT-II-1	1001203
155	2-Foot Extension (Refer to MAN 43638.)	—	5PT-II-2	1001204

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