


LD/U2 Spraying device


Arc spraying

Parts List
PL 96802 EN 06



Oerlikon Metco Switzerland
Rigackerstrasse 16
CH-5610 Wohlen

 +41 56 618 81 81

 +41 56 618 81 00

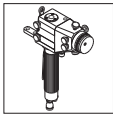
www.oerlikon.com/metco



Warranty Disclaimer

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

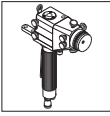
1 List of recommended spare parts



Pos.	Designation	Article No.
2.2 Hose package		
6	Insulated Wire Guide Hose 4 m	FLEXI ARC 300 1056654
	Insulated Wire Guide Hose 6 m	FLEXI ARC 300 1056664
	Insulated Wire Guide Hose 8 m	FLEXI ARC 300 1056669
	Insulated Wire Guide Hose 10 m	FLEXI ARC 300 1056625
7	Insulated Wire Guide Hose 4 m	FLEXI ARC 200 1056648
	Insulated Wire Guide Hose 6 m	FLEXI ARC 200 1056661
Optional for Al 99+, Ni, Ni alloys, cored wires		
8	Wire Guide Tube PTFE 4 m	1056779
	Wire Guide Tube PTFE 6 m	1056782
	Wire Guide Tube PTFE 8 m	1056784
	Wire Guide Tube PTFE 10 m	1081593
2.4.1 Closed nozzle system (adjustable)		
1	Radial Nozzle Size 2 Ø 1.6 mm	1056153
	Radial Nozzle Size 3 Ø 2.0 mm	1056154
	Radial Nozzle Size 4 Ø 2.5 mm	1056155
5	Nozzle Plate Size 2 Ø 1.6 mm	1056144
	Nozzle Plate Size 3 Ø 2.0 mm	1056145
	Nozzle Plate Size 4 Ø 2.5 mm	1056146
7	O-Ring NBR 36x2 mm	1066183
8	Contact Nozzle Ø 1.6 mm	1056118
	Contact Nozzle Ø 1.6 mm for Al 99+	1056129
	Contact Nozzle Ø 2.0 mm	1056120
	Contact Nozzle Ø 2.0 mm for Al 99+	1056130
	Contact Nozzle Ø 2.5 mm	1056122
	Contact Nozzle Ø 2.5 mm for Al 99+	1056131
9	O-Ring NBR 10x1.5 mm	1066172

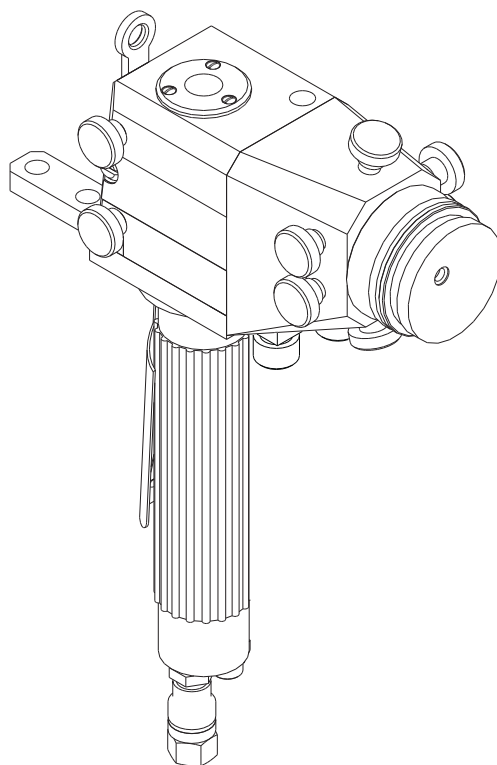
Pos.	Designation	Article No.	
2.4.2 Open nozzle system			
3	Contact Nozzle	Ø 1.6 mm	1056118
	Contact Nozzle	Ø 1.6 mm for Al 99+	1056129
	Contact Nozzle	Ø 2.0 mm	1056120
	Contact Nozzle	Ø 2.0 mm for Al 99+	1056130
	Contact Nozzle	Ø 2.5 mm	1056122
	Contact Nozzle	Ø 2.5 mm for Al 99+	1056131
4	Atomizer Nozzle (1-Hole) Size 9	Ø 1.6 - 2.5 mm	1056137
	Atomizer Nozzle (2-Hole) Size 1	Ø 1.6 - 2.0 mm	1056133
	Atomizer Nozzle (2-Hole) Size 2	Ø 2.5 mm	1056136
5	O-Ring NBR 10x1.5 mm	1066172	
2.4.3 Closed nozzle system			
1	Radial Nozzle Nut	1053738	
2	Fan Spray Nozzle Nut	1053684	
3	Fan Spray Nozzle	1053683	
4	Gas Nozzle Size 3	Ø 1.6 - 2.0 mm	1056259
	Gas Nozzle Size 4	Ø 2.5 mm	1056257
5	Cover Ring	1053736	
6	Contact Nozzle	Ø 1.6 mm	1056118
	Contact Nozzle	Ø 1.6 mm for Al 99+	1056129
	Contact Nozzle	Ø 2.0 mm	1056120
	Contact Nozzle	Ø 2.0 mm for Al 99+	1056130
	Slot Contact Nozzle	Ø 2.0 mm	1056251
	Contact Nozzle	Ø 2.5 mm	1056122
	Contact Nozzle	Ø 2.5 mm for Al 99+	1056131
	Slot Contact Nozzle	Ø 2.5 mm	1056252
7	Atomizer Nozzle (2-Hole)	1056134	

Pos.	Designation			Article No.
2.6 Wire feed unit				
29	Drive Roll	Knurled Profile	Ø 1.6 mm	1056412
	Drive Roll	Spline Profile	Ø 1.6 mm	1056405
	Drive Roll	Spline Profile (polished)	Ø 1.6 mm	1056418
	Drive Roll	Knurled Profile	Ø 2.0 mm	1056413
	Drive Roll	Spline Profile	Ø 2.0 mm	1056407
	Drive Roll	Spline Profile (polished)	Ø 2.0 mm	1056419
	Drive Roll	Knurled Profile	Ø 2.5 mm	1056414
	Drive Roll	Spline Profile	Ø 2.5 mm	1056409
	Drive Roll	Spline Profile (polished)	Ø 2.5 mm	1056420
	2.7 Wire contact pressure unit			
26	Deep Groove Ball Bearing 627-2RS			1055414
2.8 Air motor with drive shaft				
	Drive complete with Air Motor 150	FLEXI ARC 300		1056430
	Drive complete with Air Motor 100	FLEXI ARC 200		1056429
Operating Resources				
	PTFE-Spray			1016617
	Air Motor Oil			1055104
	Contact Grease			1051843
	Graphite Powder			1051844
	Nozzle Cleaner			1051845
	Wire cleaning pads	(1 set = 6 pc)		1002029

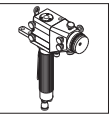
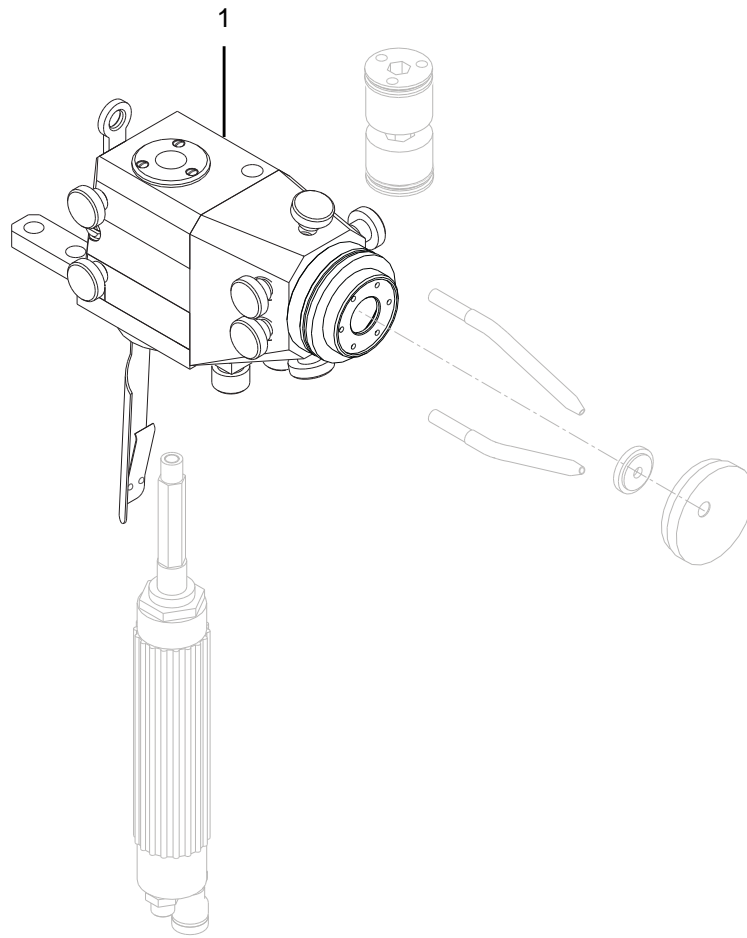


2 Parts list

2.1 Spraying device LD/U2 complete (without hose package)

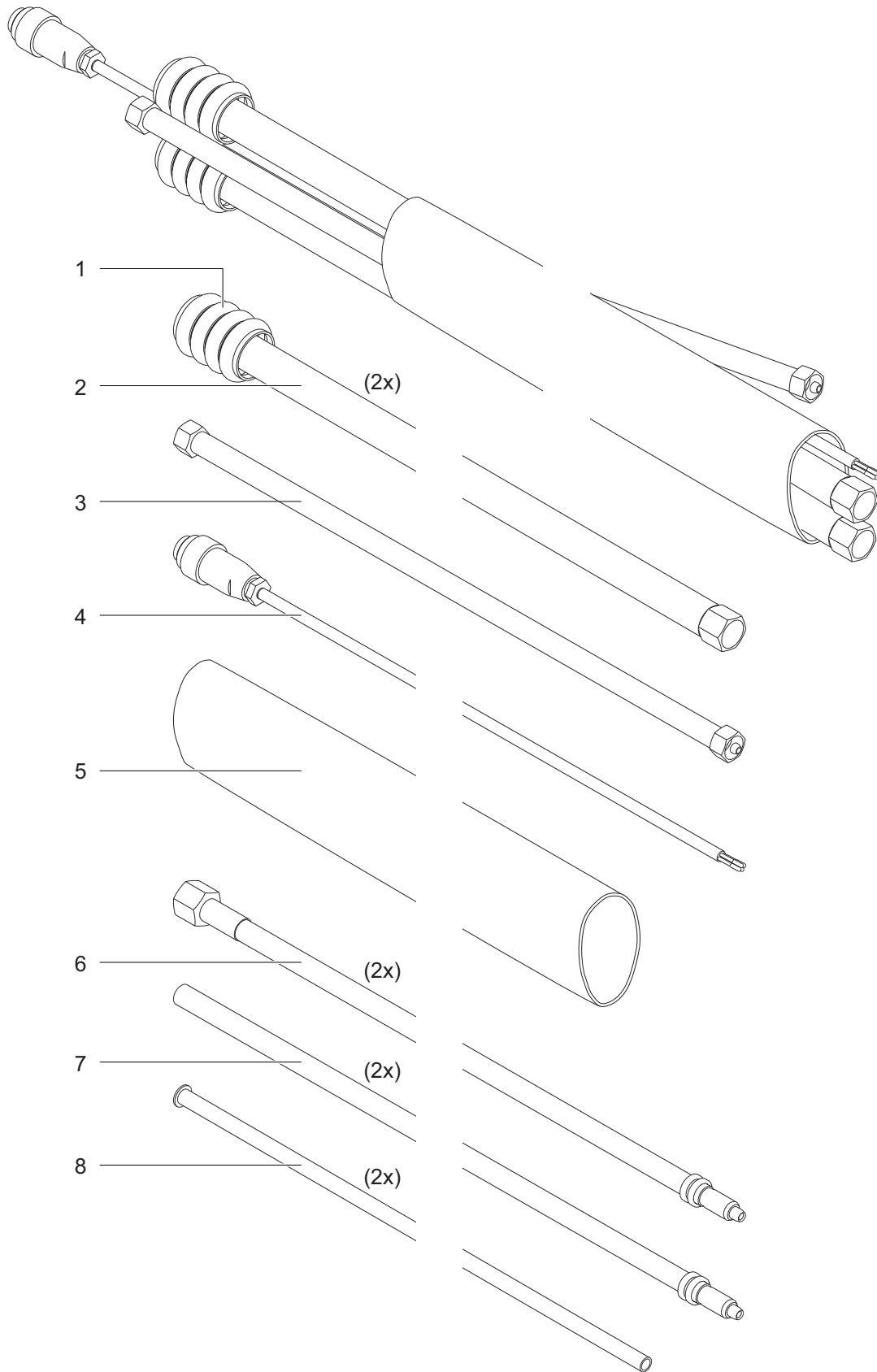


Designation			used wires	Article No.
LD/U2 Hard wires	Kit 1	FLEXI ARC 200	Cu, Fe, Ni, Ti (1.6 mm)	1062708
LD/U2 Soft wires	Kit 1	FLEXI ARC 200	Zn, ZnAl, AlMg, Sn (1.6 mm)	1062709
LD/U2 Soft wires	Kit 2	FLEXI ARC 200	Zn (2.0 mm)	1062710
LD/U2 Soft wires	Kit 3	FLEXI ARC 200	Zn, ZnAl, AlMg (2.5 mm)	1062711
LD/U2 Hard wires	Kit 1	FLEXI ARC 300	Cu, Fe, Ni, Ti (1.6 mm)	1062733
LD/U2 Soft wires	Kit 1	FLEXI ARC 300	Zn, ZnAl, AlMg, Sn (1.6 mm)	1062734
LD/U2 Cored wires	Kit 1	FLEXI ARC 300	Cored wires (1.6 mm)	1062735
LD/U2 Soft wires	Kit 2	FLEXI ARC 300	Zn (2.0 mm)	1062736
LD/U2 Soft wires	Kit 3	FLEXI ARC 300	Zn, ZnAl, AlMg (2.5 mm)	1062737

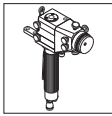


	Designation	Article No.
1	LD/U2 without spray kit	1063241

2.2 Hose package



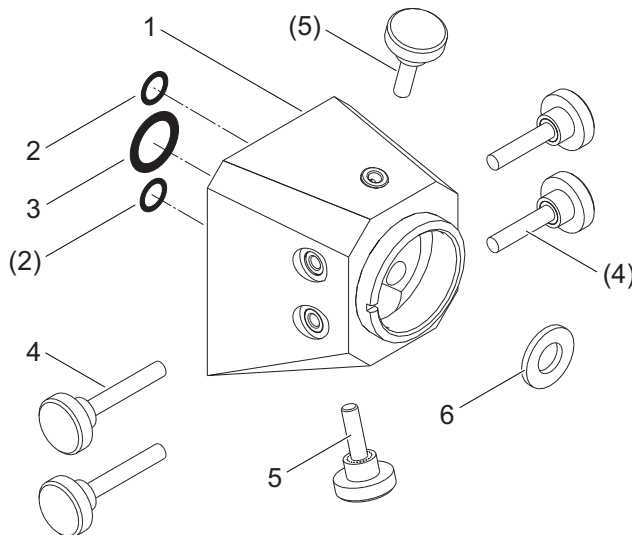
PL 96802 EN 06 Released on: 02.06.2015



Pos.	Designation		Article No.
	Hose Package complete 4 m	<i>incl. Pos. 1 - 5</i>	1057143
	Hose Package complete 6 m	<i>incl. Pos. 1-5,</i>	1057149
	Hose Package complete 8 m	<i>incl. Pos. 1-5, only FLEXI ARC 300</i>	1057151
	Hose Package complete 10 m	<i>incl. Pos. 1-5, only FLEXI ARC 300</i>	1057137
1	Bellows Current-Air Connection		1052392
	Current-Air Hose 4 m		1056647
2	Current-Air Hose 6 m		1056660
	Current-Air Hose 8 m		1056697
	Current-Air Hose 10 m		1056683
3	Air Motor Hose 4 m		1056649
	Air Motor Hose 6 m		1056662
	Air Motor Hose 8 m		1056667
	Air Motor Hose 10 m		1056630
4	Control Cable 4 m		1056650
	Control Cable 6 m		1056663
	Control Cable 8 m		1056668
	Control Cable 10 m		1056624
5	External Hose 45x1.5 mm (material sold by the meter)		1053518
6	Insulated Wire Guide Hose 4 m	FLEXI ARC 300	1056654
	Insulated Wire Guide Hose 6 m	FLEXI ARC 300	1056664
	Insulated Wire Guide Hose 8 m	FLEXI ARC 300	1056669
	Insulated Wire Guide Hose 10 m	FLEXI ARC 300	1056625
7	Insulated Wire Guide Hose 4 m	FLEXI ARC 200	1056648
	Insulated Wire Guide Hose 6 m	FLEXI ARC 200	1056661
	Optional for Al 99+, Ni, Ni alloys, cored wires		
	Use wire guide tube in the insulated wire guide hoses (Pos. 6, 7)		
8	Wire Guide Tube PTFE 4 m		1056779
	Wire Guide Tube PTFE 6 m		1056782
	Wire Guide Tube PTFE 8 m		1056784
	Wire Guide Tube PTFE 10 m		1081593

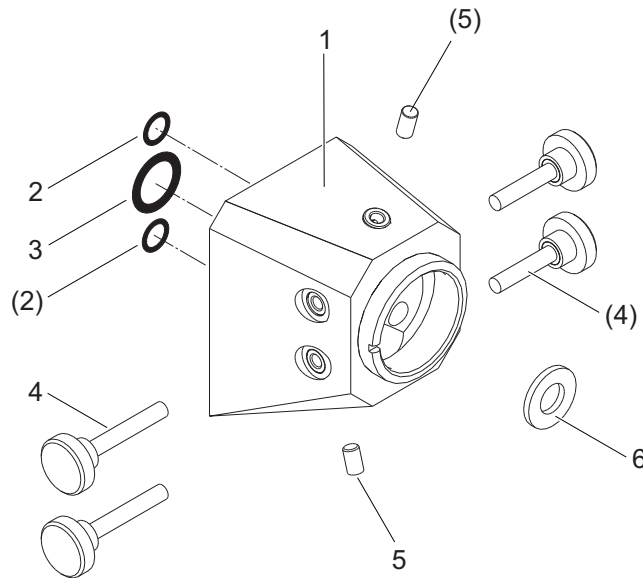
2.3 Spray head

2.3.1 Spray head for closed (adjustable) and open nozzle system



Pos.	Designation	Article No.
1	Spray Head LD/U2	<i>incl. Pos. 2, 3</i> 1052774
2	O-Ring NBR 9x1.5 mm	1066169
3	O-Ring NBR 22x2 mm	1066181
4	Knurled Screw M6x30 120 degrees	1056110
5	Knurled Screw M6x20	1054978
6	Washer for Air Nozzle Tube	1053250

2.3.2 Spray head for closed nozzle system (not adjustable)



Pos.	Designation	Article No.
1	Spray Head LD/U2	1052774
	<i>incl. Pos. 2, 3</i>	
2	O-Ring NBR 9x1.5 mm	1066169
3	O-Ring NBR 22x2 mm	1066181
4	Knurled Screw M6x30	1054980
5	Set screw M6x10 DIN913 45H	1074465
6	Washer for Air Nozzle Tube	1053250

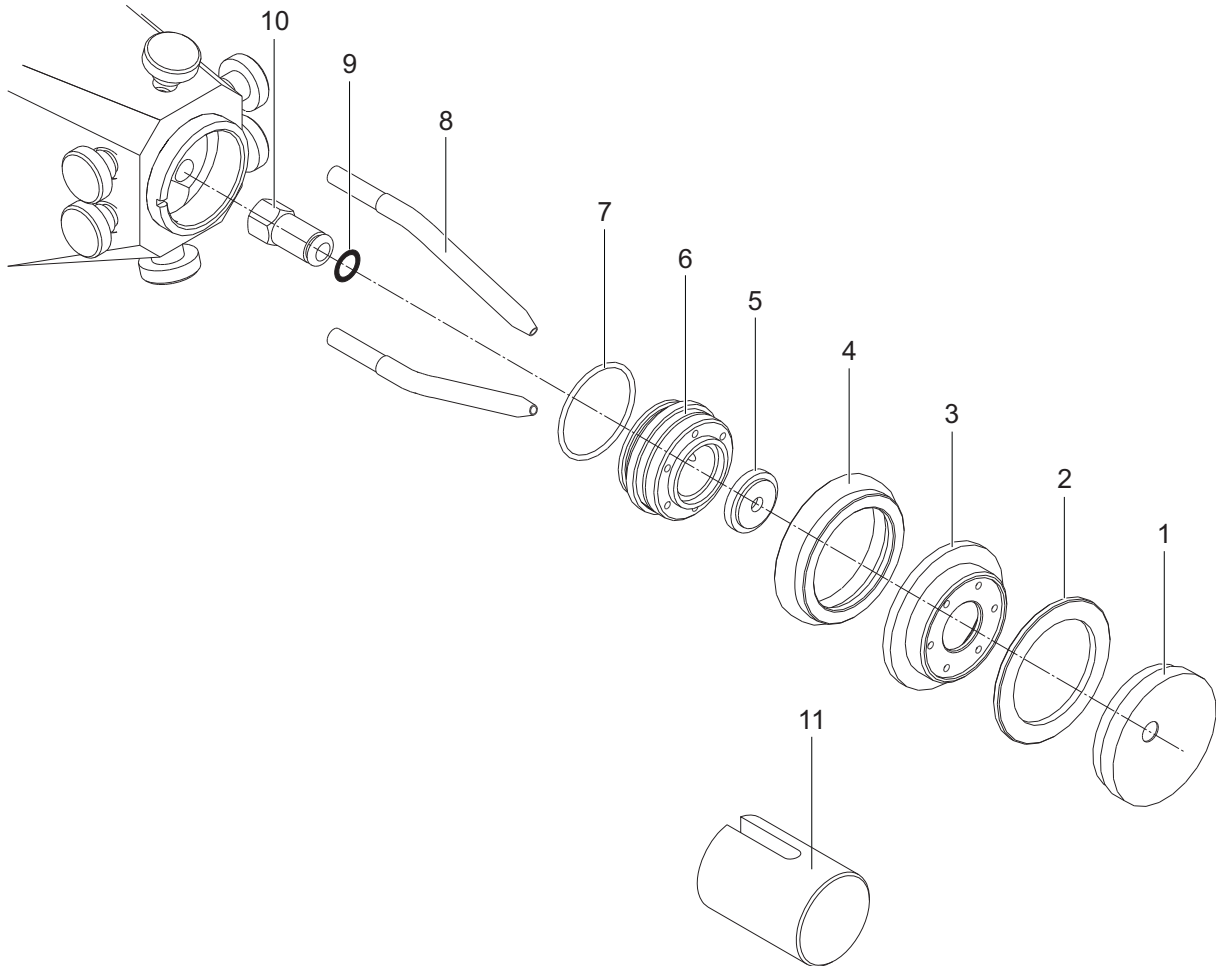


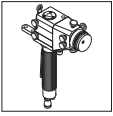
INFO

Pos. 5: Apply Loctite 222 on thread for tight fitting

2.4 Nozzle systems

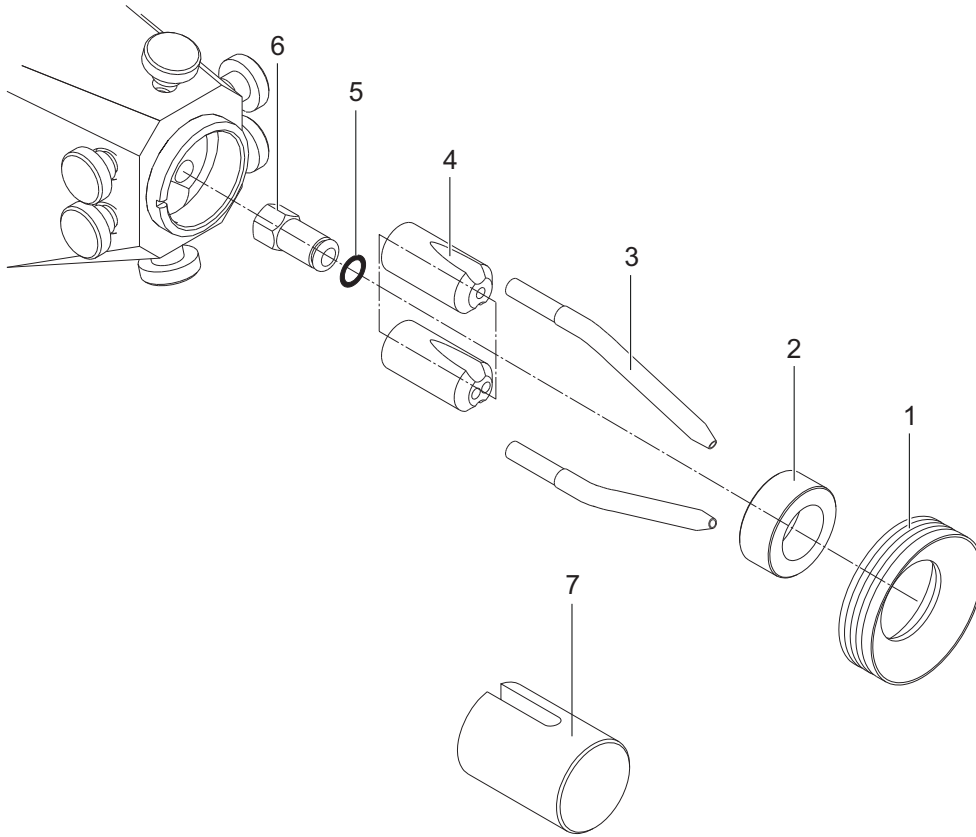
2.4.1 Closed nozzle system (adjustable)

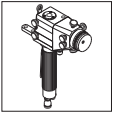




Pos.	Designation	Article No.
1	Radial Nozzle Size 2 Ø 1.6 mm	1056153
	Radial Nozzle Size 3 Ø 2.0 mm	1056154
	Radial Nozzle Size 4 Ø 2.5 mm	1056155
2	Counter Ring	1053242
3	Nozzle Nut	1053241
4	Union Nut	1053240
5	Nozzle Plate Size 2 Ø 1.6 mm	1056144
	Nozzle Plate Size 3 Ø 2.0 mm	1056145
	Nozzle Plate Size 4 Ø 2.5 mm	1056146
6	Receptacle	1052775
7	O-Ring NBR 36x2 mm	1066183
8	Contact Nozzle Ø 1.6 mm	1056118
	Contact Nozzle Ø 1.6 mm for AI 99+	1056129
	Contact Nozzle Ø 2.0 mm	1056120
	Contact Nozzle Ø 2.0 mm for AI 99+	1056130
	Contact Nozzle Ø 2.5 mm	1056122
	Contact Nozzle Ø 2.5 mm for AI 99+	1056131
9	O-Ring NBR 10x1.5 mm	1066172
10	Air Nozzle Tube	1056396
11	Nozzle Adjusting Device	1053252

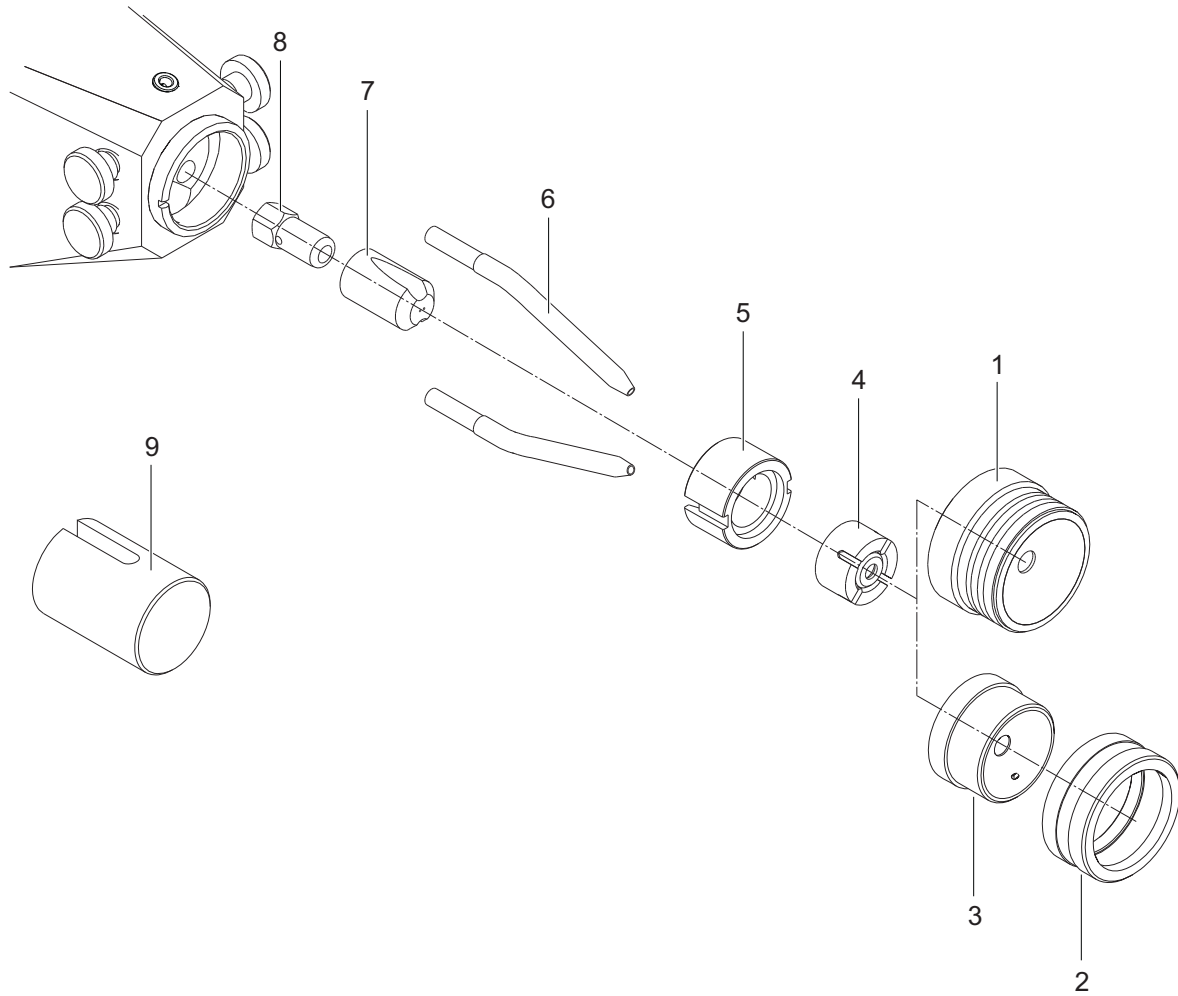
2.4.2 Open nozzle system



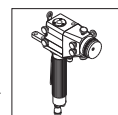


Pos.	Designation	Article No.	
1	Arc Shield	1053239	
2	Cover Ring	1060918	
3	Contact Nozzle	Ø 1.6 mm	1056118
	Contact Nozzle	Ø 1.6 mm for Al 99+	1056129
	Contact Nozzle	Ø 2.0 mm	1056120
	Contact Nozzle	Ø 2.0 mm for Al 99+	1056130
	Contact Nozzle	Ø 2.5 mm	1056122
	Contact Nozzle	Ø 2.5 mm for Al 99+	1056131
	4	Atomizer Nozzle (1-Hole) Size 9	Ø 1.6 - 2.5 mm
Atomizer Nozzle (2-Hole) Size 1		Ø 1.6 - 2.0 mm	1056133
Atomizer Nozzle (2-Hole) Size 2		Ø 2.5 mm	1056136
5	O-Ring NBR 10x1.5 mm	1066172	
6	Air Nozzle Tube	1056396	
7	Nozzle Adjusting Device	1053252	

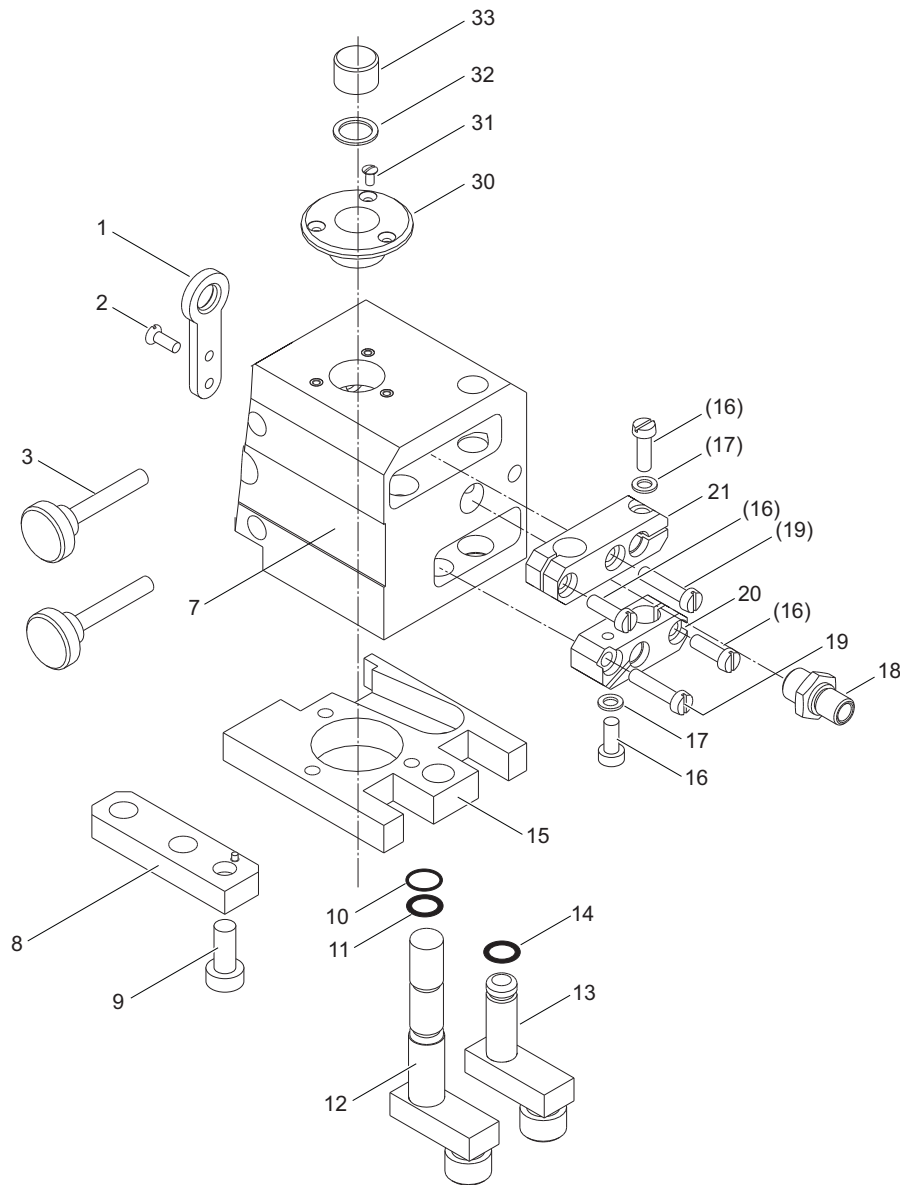
2.4.3 Closed nozzle system



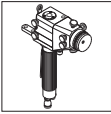
Pos.	Designation	Article No.
1	Radial Nozzle Nut	1053738
2	Fan Spray Nozzle Nut	1053684
3	Fan Spray Nozzle	1053683
4	Gas Nozzle Size 3 Ø 1.6 - 2.0 mm	1056259
	Gas Nozzle Size 4 Ø 2.5 mm	1056257
5	Cover Ring	1053736
6	Contact Nozzle Ø 1.6 mm	1056118
	Contact Nozzle Ø 1.6 mm for Al 99+	1056129
	Contact Nozzle Ø 2.0 mm	1056120
	Contact Nozzle Ø 2.0 mm for Al 99+	1056130
	Slot Contact Nozzle Ø 2.0 mm	1056251
	Contact Nozzle Ø 2.5 mm	1056122
	Contact Nozzle Ø 2.5 mm for Al 99+	1056131
	Slot Contact Nozzle Ø 2.5 mm	1056252
7	Atomizer Nozzle (2-Hole)	1056134
8	Air Nozzle Tube	1056108
9	Nozzle Adjusting Device	1053252



2.5 Components of the gear housing

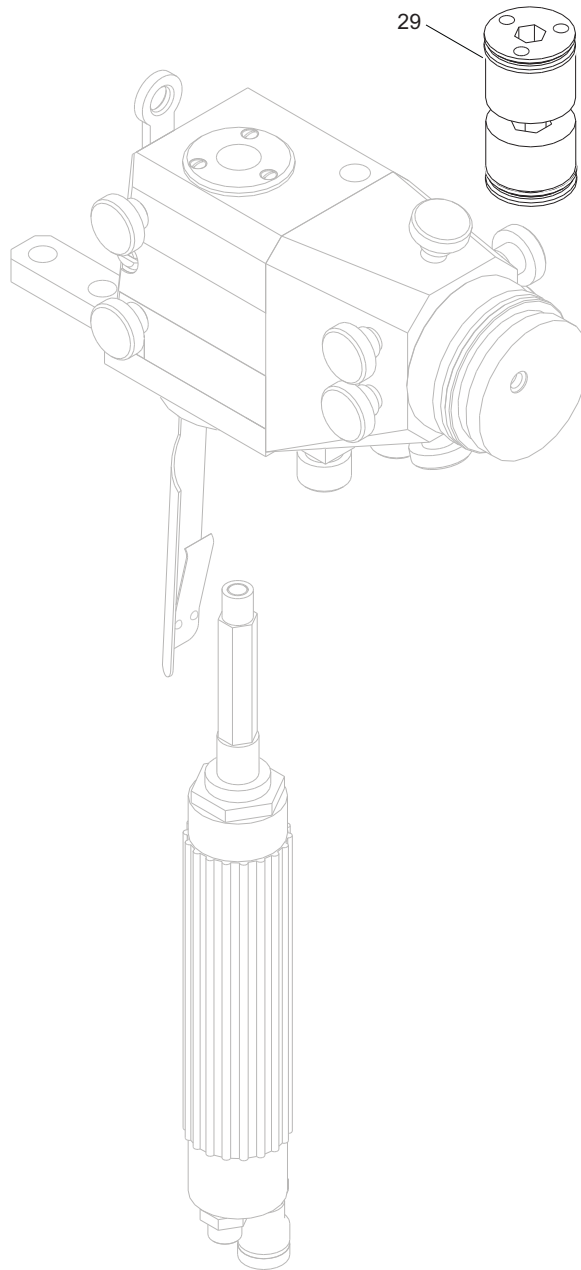


PL 96802 EN 06 Released on: 02.06.2015



Pos.	Designation	Article No.
1	Suspension	1052737
2	Countersunk Head Screw M4x12 DIN963 Zn	1074472
3	Knurled Screw M6x40 120 degrees	1056112
7	Gear Housing	1052770
8	Fixing Device	1052736
9	Fastening Screw	1056157
10	O-Ring NBR 10x1 mm	1066171
11	O-Ring NBR 10x1.5 mm	1066172
12	By-Pass (long)	1052772
13	By-Pass (short)	1052771
14	O-Ring NBR 8.5x1.5 mm	1066157
15	Base Plate	1053229
16	Fillister Head Screw M5x16 DIN84 Zn	1066040
17	Washer	1052740
18	Extension Insert Compressed Air	1052738
19	Fillister Head Screw M5x20 DIN84 Zn	1066041
20	Contact Plate (lower)	1052739
21	Contact Plate (upper)	1053228
30	Bearing Housing	1052733
31	Raised Countersunk Head Screw M3x8 DIN964 Ni	1066131
32	Seal Ring	1052735
33	Needle Bearing BK1210	1052851

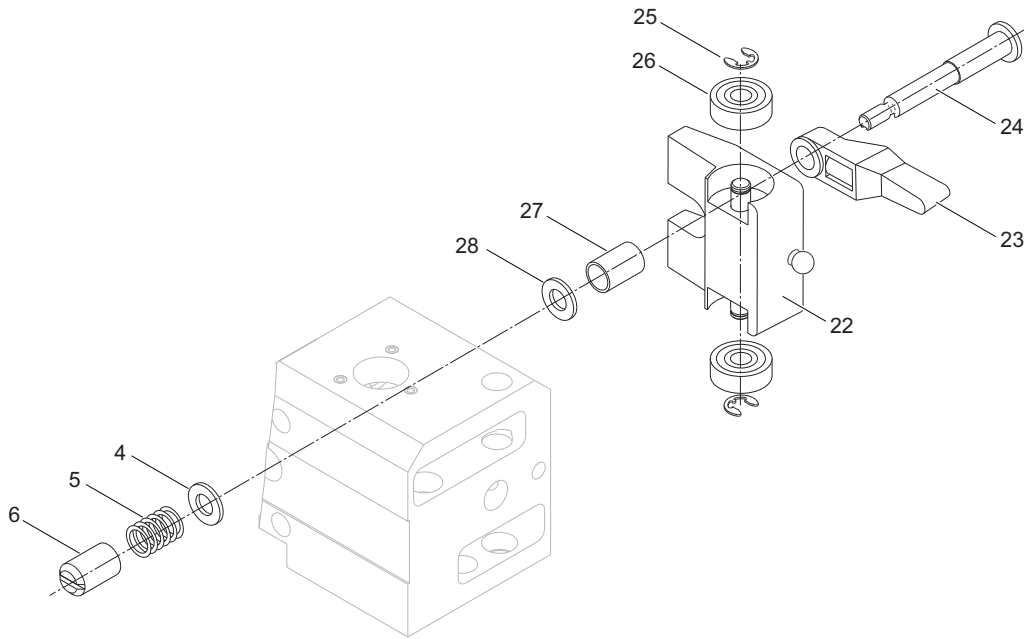
2.6 Wire feed unit





Pos.	Designation			Article No.
29	Drive Roll	Knurled Profile	Ø 1.6 mm	1056412
	Drive Roll	Spline Profile	Ø 1.6 mm	1056405
	Drive Roll	Spline Profile (polished)	Ø 1.6 mm	1056418
	Drive Roll	Knurled Profile	Ø 2.0 mm	1056413
	Drive Roll	Spline Profile	Ø 2.0 mm	1056407
	Drive Roll	Spline Profile (polished)	Ø 2.0 mm	1056419
	Drive Roll	Knurled Profile	Ø 2.5 mm	1056414
	Drive Roll	Spline Profile	Ø 2.5 mm	1056409
	Drive Roll	Spline Profile (polished)	Ø 2.5 mm	1056420

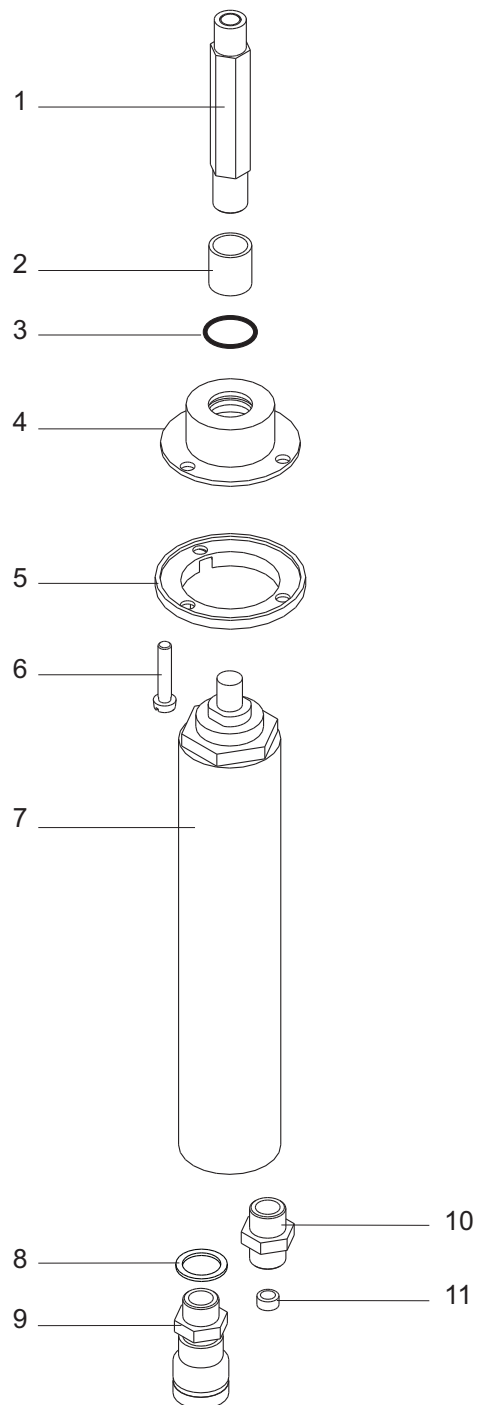
2.7 Wire contact pressure unit





Pos.	Designation	Article No.
4	Washer	1053235
5	Pressure Spring 2x10.2x22.5x4.5	1066188
6	Adjusting Nut	1053236
22	Pressure Plate <i>incl. Pos. 25 - 26</i>	1052773
23	Pressure Lever	1056428
24	Adjusting Shaft	1053233
25	Circlip A7x0.8 DIN471	1066153
26	Deep Groove Ball Bearing 627-2RS	1055414
27	Distance Sleeve	1053234
28	Washer M8 DIN125 Zn	1070267

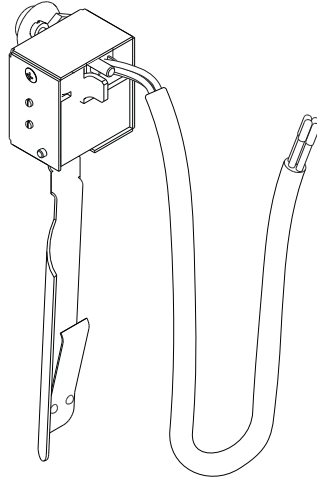
2.8 Air motor with drive shaft





Pos.	Designation	Article No.
	Drive complete with Air Motor 150	FLEXI ARC 300 1056430
	Drive complete with Air Motor 100	FLEXI ARC 200 1056429
1	Drive Shaft	1053360
2	H-Sleeve	1053243
3	O-Ring Viton 16x1.5 mm	1066177
4	Motor Flange	1053230
5	Collar	1053231
6	Fillister Head Screw M5x25 DIN84 Zn	1066042
7	Air Motor MD-Z-R-150	FLEXI ARC 300 1053225
	Air Motor O-Z-04-R-100	FLEXI ARC 200 1056091
8	Fiber Ring 13x18x1.5	1068376
9	Control Valve	1054145
10	Double Nipple	1053740
11	Screen	1052412

2.9 Switch elements



Pos.	Designation	Article No.
	Switch Housing with Dead Man's Switch	1066944