

9MBH Spray Gun Plasma Spraying


Parts List
PL 98018 EN 06




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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

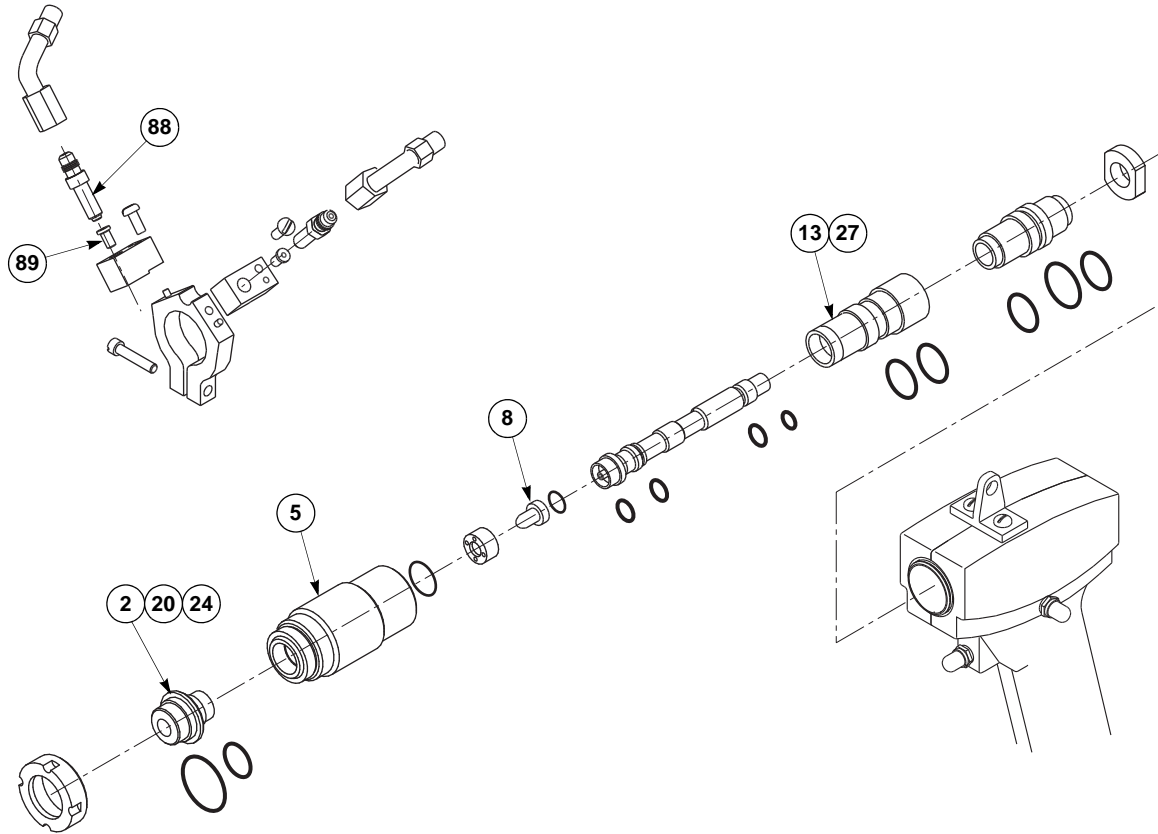
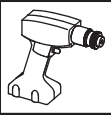
Parts recommended in order to guarantee maximum availability of component. This prevents downtime caused by delay in procurement.



Warranty Disclaimer

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

1 List of Recommended Spare Parts for 9MBH Spray Gun



9mbh_spare

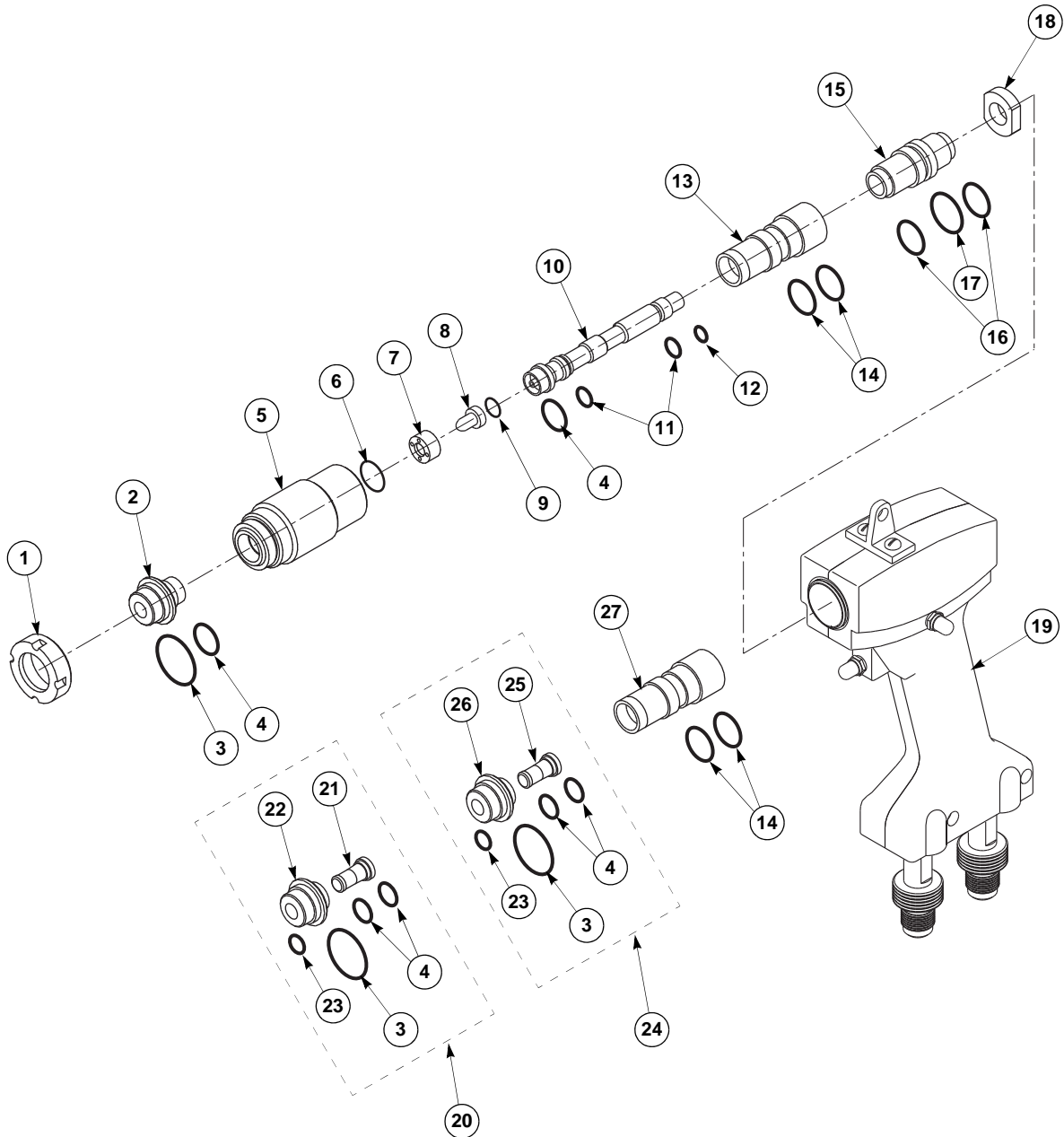
Item No.	Description	Qty.	Cat.	Catalog No.	Order No.
2	Nozzle, GP	2	C	3M7-GP	1000724
5	Water Channeling Head	1	C	9MB15	1001619
8	Electrode	2	C	9M119198	1084120
13	Front Insulator, Argon	1	W	9MB50	1001630
20	Nozzle	2	C	9MB730A	1001648
24	Nozzle	2	C	9MB732A	1001654
27	Front Insulator, Nitrogen	1	W	9MB55	1001631
88	Powder Stem	2	W	3M331	1000694
89	No. 2 Powder Port	2	C	9MB972	1001668
123	Ringlube	1	C	2M182	1000508
125	Reseal Kit	1	W	9MB54127	1016455
126	Hardware Kit	1	K	9MB54128	1035444

2 Parts List for 9MBH Spray Gun

9MBH Spray Gun

(9MBH) 1001677

2.1 Plasma Gun Assembly



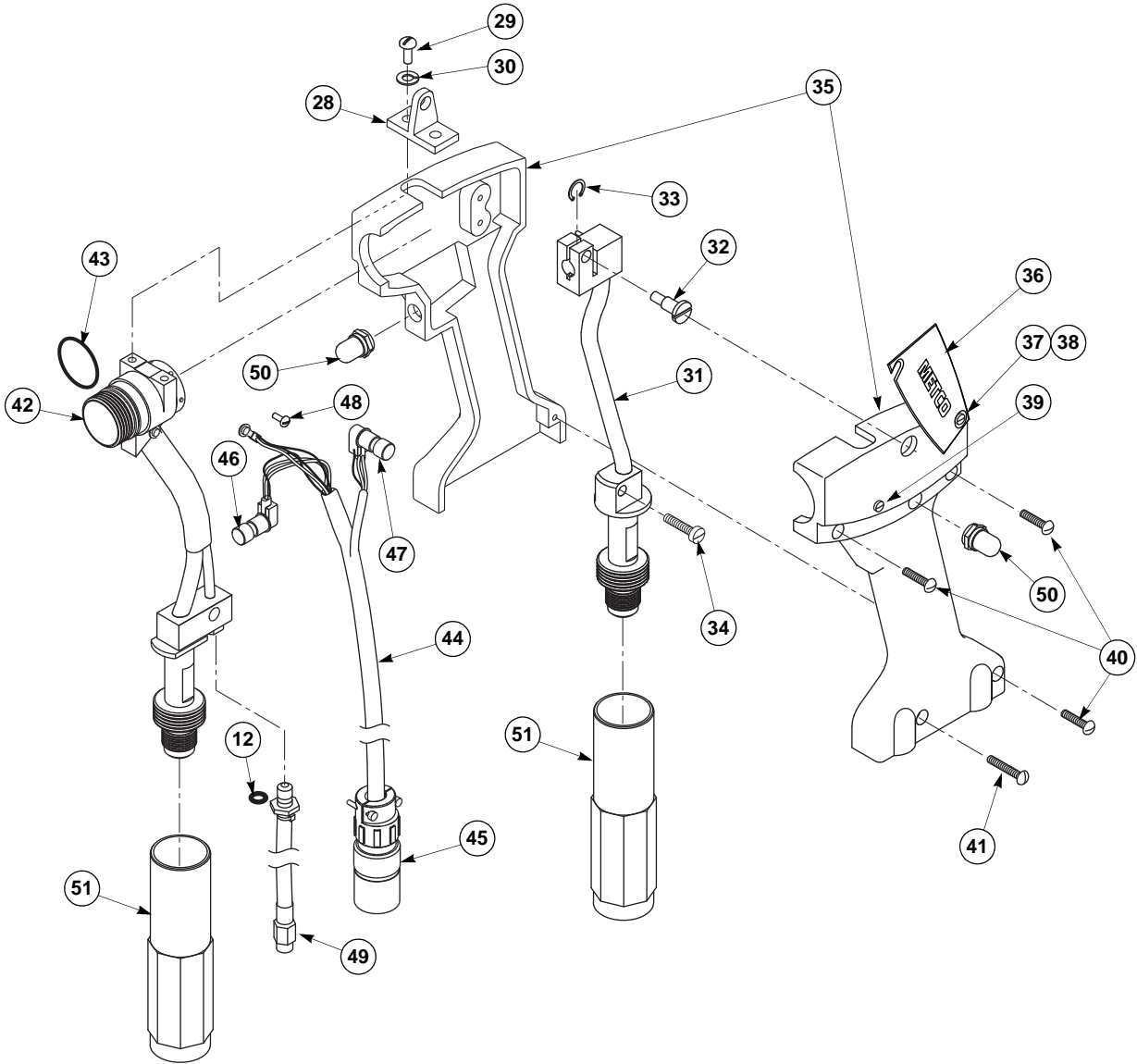
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Item No.	Description	Qty.	Catalog No.	Order No.
1	Nozzle Nut	1	9MB8	1001660
2	Nozzle, GP (See also, page 8.)	1	3M7-GP	1000724
3	O-Ring, Black Viton, 1.114x0.07 in.	1	7M57	1001495
4	O-Ring, Black Viton, 0.614x0.07 in.	2	7M111	1001462
5	Water Channeling Head	1	9MB15	1001619
6	O-Ring, Black Viton, 0.850x0.045 in.	1	9MB297	1001625
7	Electrode Lock Nut	1	7M14	1001469
8	Electrode (See also, page 12.)	1	9M119198	1084120
9	O-Ring, Black Viton, 0.426x0.07 in.	1	7M51	1001493
10	Electrode Holder	1	9MB18	1001622
11	O-Ring, Buna, 0.426x0.07 in.	2	2M199	1000521
12	O-Ring, Buna, 0.239x0.07 in.	1	4EFC56	1000861
13	Front Insulator, Argon (See also, page 12.)	1	9MB50	1001630
14	O-Ring, Buna, 0.926x0.07 in.	2	9MB296	1001624
15	Rear Insulator	1	9MB166	1001621
16	O-Ring, Buna, 0.739x0.07 in.	2	5PT21	1001202
17	O-Ring, Buna, 0.864x0.07 in.	1	10E46	1000100
18	Electrode Holder Nut	1	7M17	1001475
19	Handle Assembly (See page 6.)	1	9MB550	1001632
Alternative Parts (Supplied with spray gun.)				
20	Nozzle Assembly	1	9MB730A	1001648
21	Nozzle Body, 11/16-24	1	9MB730B	1001649
22	Nozzle Shell	1	9MB730C	1001650
23	O-Ring, Black Viton, 0.489x0.07 in.	1	2-014V	1000359
24	Nozzle Assembly	1	9MB732A	1001654
25	Nozzle Body, 11/16-24	1	9MB732B	1001655
26	Nozzle Shell	1	732C	1025077
27	Front Insulator, Nitrogen	1	9MB55	1001631

2.2 Handle Assembly



9mbh_handle_assy

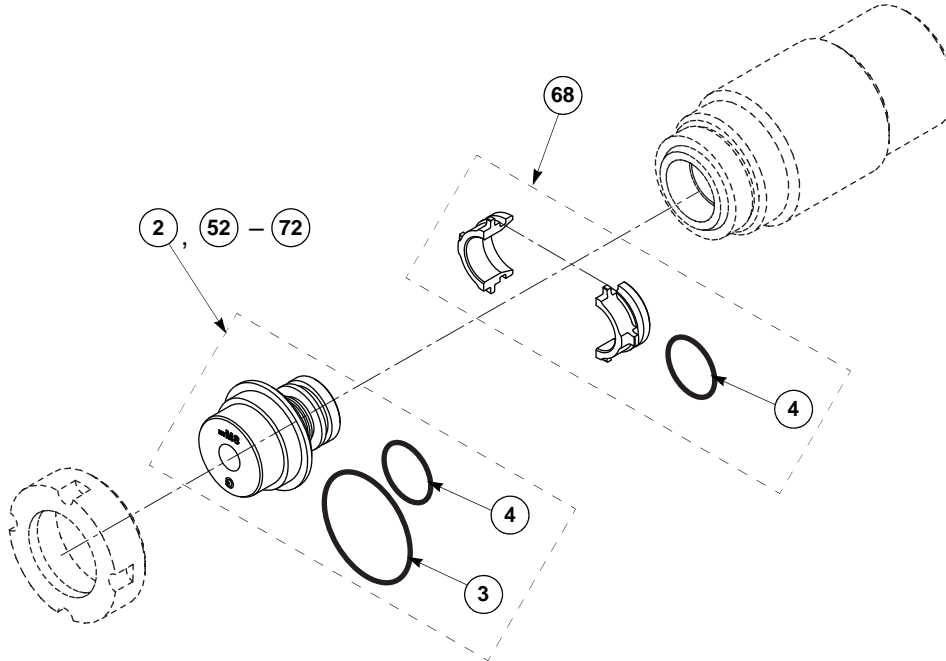
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Item No.	Description	Qty.	Catalog No.	Order No.
28	Support Bracket	1	9MB95	1019864
29	Screw, 1/4-20 X 7/8	2	2M115	1000507
30	Lock Washer	2	PH21	1002189
31	Rear Gun Body <i>(incl. items 32 & 33)</i>	1	7M30	1001486
32	Clamp Screw, 1/4-20 X 9/16 <i>(incl. item 33)</i>	1	7M670	1001504
33	Retaining Ring	1	7M671	1032359
34	Screw, 10-32 X 3/4	1	7M122	1001466
35	Handle <i>(incl. items 36-41)</i>	1	9MB575	1001633
36	Cover Plate	1	—	—
37	Screw, 8-32 X 5/32	1	7M68	1032360
38	Spring Washer	1	—	—
39	Screw, 8-32 X 1/4	1	6P29	1032138
40	Screw, 10-32 X 11/16	3	—	—
41	Screw, 10-32 X 1-1/8	1	7M577	1032357
42	Front Gun Body	1	7M25	1001483
43	O-Ring, Buna, 1.239x0.07 in. <i>(pkg. of 2)</i>	1	2AF29	1000457
44	Switch & Cable Assembly <i>(incl. items 45-47)</i>	1	7M40	1001490
45	Connector	1	7M23	1032346
46	Pushbutton Switch	1	3M341	1000695
47	Momentary Switch	1	—	—
48	Screw, 6-32 X 3/8	1	—	—
49	Plasma Gas Hose <i>(incl. item 12)</i>	1	7M58	1001497
50	Push Button Boot	2	3M670	1000713
51	Hose Insulator	2	7M32	1001487

2.3 Nozzle Assemblies

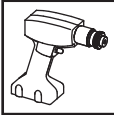
2.3.1 One-Piece Nozzle Assemblies



9mb_nozzle1

Item No.	Description	Qty.	Catalog No.	Order No.
Standard Nozzle (Supplied with spray gun.)				
2	Nozzle Assembly GP (Ar, Ar/H ₂ , Ar/He)	1	3M7-GP	1000724
3	O-Ring, Black Viton, 1.114x0.07 in. (pkg. of 6)	1	7M57	1001495
4	O-Ring, Black Viton, 0.614x0.07 in. (pkg. of 6)	1	7M111	1001462
Optional Nozzles (Each includes O-Rings, items 3 & 4.)				
52	Nozzle Assembly G (N ₂ , N ₂ /H ₂ , Ar/H ₂)	—	3M7-G	1000721
53	Nozzle Assembly GE (N ₂ , N ₂ /H ₂ , Ar/N ₂ , Ar/H ₂ , Ar/He)	—	3M7-GE	1000722
54	Nozzle Assembly GH (Ar/H ₂ , Ar/He)	—	3M7-GH	1000723
55	Nozzle Assembly 700 (Ar, Ar/H ₂ , N ₂)	—	7M700	1001507
56	Nozzle Assembly 703 (Ar, Ar/H ₂)	—	7M703	1001508
57	Nozzle Assembly 704 (Ar, Ar/H ₂ , Ar/He)	—	7M704	1001509
58	Nozzle Assembly 705 (Ar/N ₂ , Ar/He)	—	7M705	1001510
59	Nozzle Assembly 706 (Ar, Ar/He, Ar/N ₂)	—	7M706	1005298
60	Nozzle Assembly 707 (Ar, N ₂ , N ₂ /H ₂ , Ar/H ₂ , Ar/He)	—	7M707	1005299

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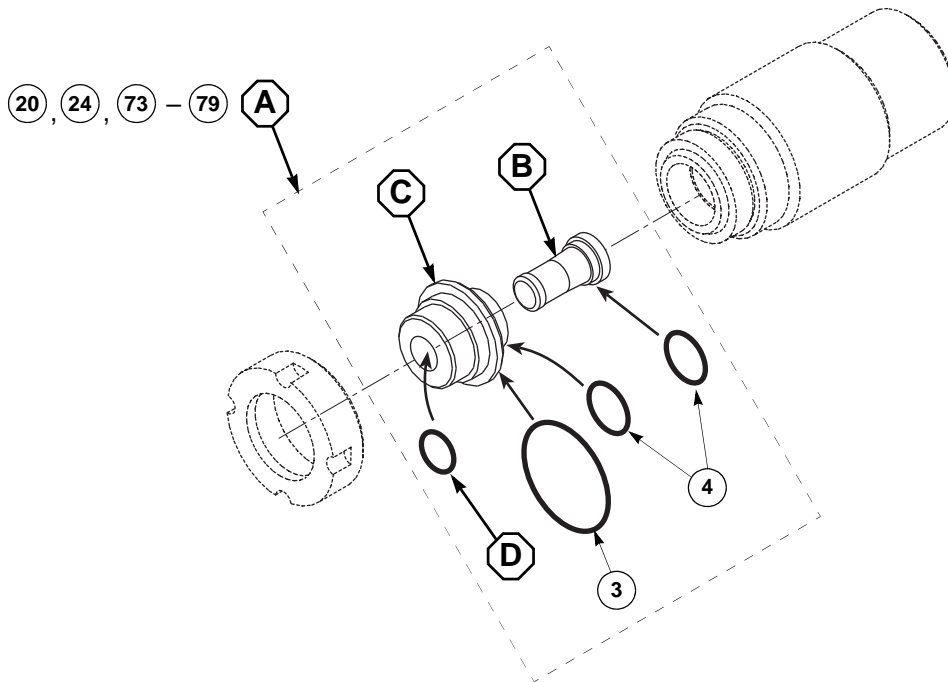


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Item No.	Description	Qty.	Catalog No.	Order No.
Tungsten-Lined Nozzles (Each includes O-Rings, items 3 & 4.)				
61 (1)	Nozzle, 930W (Tungsten Lined) (N_2 , N_2/H_2)	—	9MB57850(TF)	1088071
62 (1)	Nozzle, 932W (Tungsten Lined) (Ar , Ar/H_2)	—	9MB57851(TF)	1088072
63 (1)	Nozzle, 933W (Tungsten Lined) (Ar , Ar/H_2 , Ar/He)	—	9MB57852(TF)	1088077
64 (1)	Nozzle, 927W (Tungsten Lined) (N_2 , N_2/H_2 , Ar/H_2 , Ar/He)	—	9MB57889(TF)	1088078
65 (1)	Nozzle, 931W (Tungsten Lined) (N_2 , N_2/H_2 , Ar/N_2)	—	9MB58244(TF)	1088079
66	Nozzle, G-W (Tungsten Lined) (N_2 , N_2/H_2)	—	9MB58395(TF)	1088073
67	Nozzle, GH-W (Tungsten Lined) (Ar , Ar/H_2 , Ar/He)	—	9MB58396(TF)	1088074
68	Water Jacket (Includes both halves & item 4.)	—	9MB54809	1040838
Commercial-Grade Nozzle Packages (Each includes O-Rings, items 3 & 4. Quantity 10 each.)				
69	Nozzle, G (Commercial Grade, pkg. of 10)	—	3M7-G-CG	1063176
70	Nozzle, GE (Commercial Grade, pkg. of 10)	—	3M7-GE-CG	1063179
71	Nozzle, GH (Commercial Grade, pkg. of 10)	—	3M7-GH-CG	1063178
72	Nozzle, GP (Commercial Grade, pkg. of 10)	—	3M7-GP-CG	1063182

1. Oerlikon Metco recommends Water Jacket, item 68, ordered separately.

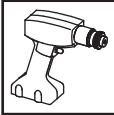
2.3.2 High-Performance Two-Piece Nozzle Assemblies



9mb_nozzle2

Item No.	Description	Qty.	Catalog No.	Order No.
3	O-Ring, Black Viton, 1.114x0.07 in. (pkg. of 6)	1	7M57	1001495
4	O-Ring, Black Viton, 0.614x0.07 in. (pkg. of 6)	2	7M111	1001462
Standard Nozzles (Supplied with spray gun. Each includes O-Rings, items 3 & 4.)				
20	A Nozzle Assembly 730A (N ₂ , N ₂ /H ₂ , Ar/H ₂)	1	9MB730A	1001648
	B Nozzle Body 730B	1	9MB730B	1001649
	C Nozzle Shell 730C	1	9MB730C	1001650
	D O-Ring, Black Viton, 0.489x0.07 in.	1	2-014V	1000359
24	A Nozzle Assembly 732A (Ar/H ₂ , Ar/He; equivalent to nozzle assembly GH)	1	9MB732A	1001654
	B Nozzle Body 732B	1	9MB732B	1001655
	C Nozzle Shell 732C	1	9MB732C	1001656
	D O-Ring, Black Viton, 0.489x0.07 in.	1	2-014V	1000359
Optional Nozzles (Each includes O-Rings, items 3 & 4.)				
73	A Nozzle Assembly 720A (Ar, Ar/H ₂ , N ₂ ; equivalent to nozzle assembly 700)	—	9MB720A	1001640
	B Nozzle Body 720B	1	9MB720B	1001641
	C Nozzle Shell 720C	1	9MB720C	1005510
	D O-Ring, Black Viton, 0.489x0.07 in.	1	2-014V	1000359

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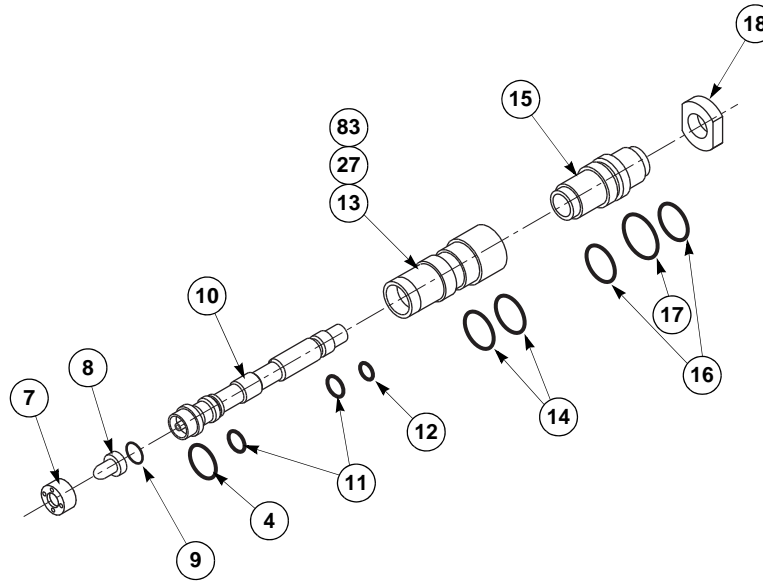


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Item No.	Description	Qty.	Catalog No.	Order No.
74	A Nozzle Assembly 724A <i>(Ar, Ar/H₂, Ar/He; equivalent to nozzle assembly 704)</i>	—	9MB724A	1001642
	B Nozzle Body 724B	1	9MB724B	1001643
	C Nozzle Shell 724C	1	9MB724C	1001644
	D O-Ring, Black Viton, 0.426x0.07 in. <i>(pkg. of 2)</i>	1	7M51	1001493
75	A Nozzle Assembly 727A <i>(Ar, N₂, N₂/H₂, Ar/H₂, Ar/He; equivalent to nozzle assembly 707)</i>	—	9MB727A	1001645
	B Nozzle Body 727B	1	9MB727B	1005512
	C Nozzle Shell 727C	1	9MB727C	1001646
	D O-Ring, Black Viton, 0.489x0.07 in.	1	2-014V	1000359
76	A Nozzle assembly 728A <i>(Ar/He)</i>	—	9MB728A	1001647
	B Nozzle Body 728B	1	9MB728B	1005513
	C Nozzle Shell 728C	1	9MB728C	1032444
	D O-Ring, Black Viton, 0.426x0.07 in. <i>(pkg. of 2)</i>	1	7M51	1001493
77	A Nozzle assembly 731A <i>(N₂, N₂/H₂, Ar/N₂, Ar/H₂, Ar/He; equivalent to nozzle assembly GE)</i>	—	9MB731A	1001651
	B Nozzle Body 731B	1	9MB731B	1001652
	C Nozzle Shell 731C	1	9MB731C	1001653
	D O-Ring, Black Viton, 0.426x0.07 in. <i>(pkg. of 2)</i>	1	7M51	1001493
78	A Nozzle assembly 733A <i>(Ar, Ar/H₂, Ar/He; equivalent to nozzle assembly GP)</i>	—	9MB733A	1001657
	B Nozzle Body 733B	1	9MB733B	1001658
	C Nozzle Shell 733C	1	9MB733C	1001659
	D O-Ring, Black Viton, 0.426x0.07 in. <i>(pkg. of 2)</i>	1	7M51	1001493
79	A Nozzle assembly 738A <i>(Ar/He)</i>	—	9MB738A	1032445
	B Nozzle Body 738B	1	9MB728B	1005513
	C Nozzle Shell 738C	1	9MB738C	1032446
	D O-Ring, Black Viton, 0.426x0.07 in. <i>(pkg. of 2)</i>	1	7M51	1001493

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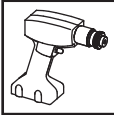
2.4 Electrode and Insulator Packages



9mb_electrode

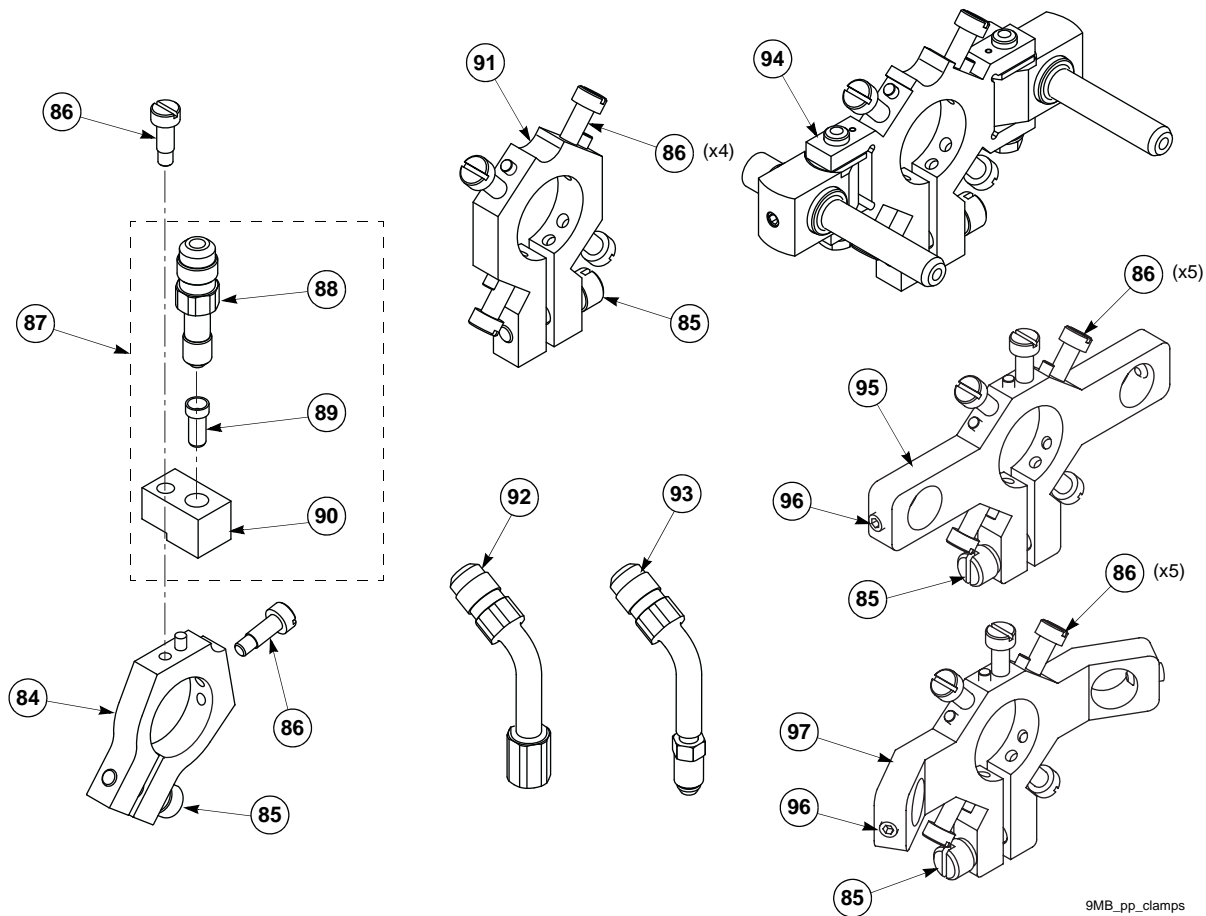
Item No.	Description	Qty.	Catalog No.	Order No.
Standard Electrode (Supplied with spray gun.)				
8	Electrode (includes item 9)	1	9M119198	1084120
9	O-Ring, Black Viton, 0.426x0.07 in. (pkg. of 2)	1	7M51	1001493
Optional Packages				
80	Electrode Package (Contains quantity 50, item 8.)	—	9MB63-50	1089198
81	Electrode & Insulator (Argon) (includes items 4, 7-18)	—	9MB693	1001636
4	O-Ring, Black Viton, 0.614x0.07 in. (pkg. of 6)	2	7M111	1001462
7	Electrode Lock Nut	1	7M14	1001469
8	Electrode (thorium-free) (includes item 9)	1	9M119198	1084120
9	O-Ring, Black Viton, 0.426x0.07 in. (pkg. of 2)	1	7M51	1001493
10	Electrode Holder	1	9MB18	1001622
11	O-Ring, Buna, 0.426x0.07 in. (pkg. of 6)	1	2M199	1000521
12	O-Ring, Buna, 0.239x0.07 in. (pkg. of 2)	1	4EFC56	1000861
13	Front Insulator, Argon	1	9MB50	1001630
14	O-Ring, Buna, 0.926x0.07 in. (pkg. of 3)	2	9MB296	1001624
15	Rear Insulator	1	9MB166	1001621
16	O-Ring, Buna, 0.739x0.07 in. (pkg. of 3)	2	5PT21	1001202
17	O-Ring, Buna, 0.864x0.07 in. (pkg. of 3)	1	10E46	1000100
18	Electrode Holder Nut	1	7M17	1001475
82	Electrode & Insulator (Nitrogen) (incl. items 4, 7-12, 14-18, & 27)	—	9MB694	1001637
27	Front Insulator, Nitrogen	1	9MB55	1001631
83	Front Insulator, Argon, 6-hole (includes item 14)	1	9MB60	1001634

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2.5 Powder Port Hardware

2.5.1 Powder Port and Air Jet Clamps

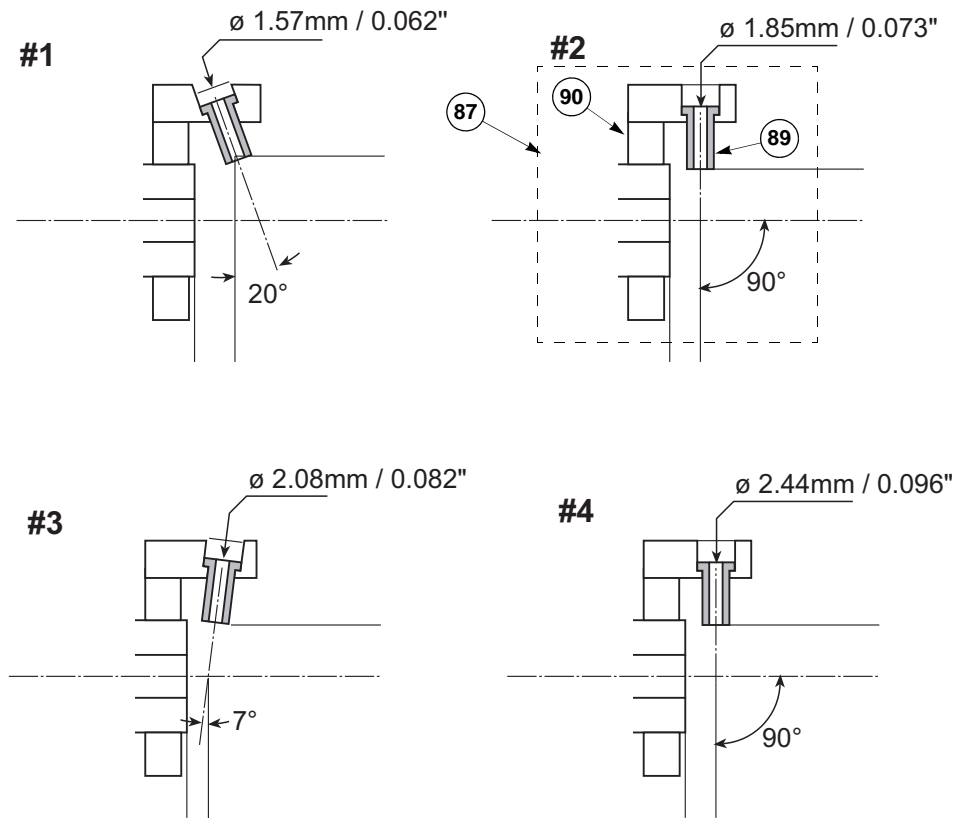


9MB_pp_clamps

Item No.	Description	Qty.	Catalog. No.	Order No.
Supplied with 9MBH Spray Gun				
84	Dual Powder Port Mounting Bracket <i>(includes items 85 & 86)</i>	1	9MB961	1001664
85	Screw, 10-24X1-13/64	1	3M327	1000692
86	Screw, 8-32 X 3/16	2	9MB962	1001665
87	No. 2 Powder Port Assembly <i>(includes items 88 - 90)</i>	2	9MB972	1001668
88	Powder Stem	1	3M202	1000679
89	No. 2 Powder Port	1	3M210	1000681
90	No. 2 Mounting Block	1	9MB982	1001674
Optional				
91	Quad Powder Port Clamp <i>(includes items 85 & 86)</i>	—	9MB964	1001666
92	Stem Assembly	—	3M331	1000694
93	Swivel Powder Port Stem	—	9MB963	1016440
94	Quad Powder Port Air Jet Assembly <i>(Refer to AI 43579.)</i>	—	9MB950	1001662
95	Powder Clamp, Straight <i>(includes items 85, 86, 96)</i>	—	3MB79557	1062575
96	Hex Set Screw, 10-24 X 3/8 <i>(pkg. of 2)</i>	2	2PSA37	1000542
97	Powder Clamp, 30° <i>(includes items 85, 86, 96)</i>	—	3MB79590	1062578

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2.5.2 Powder Injectors

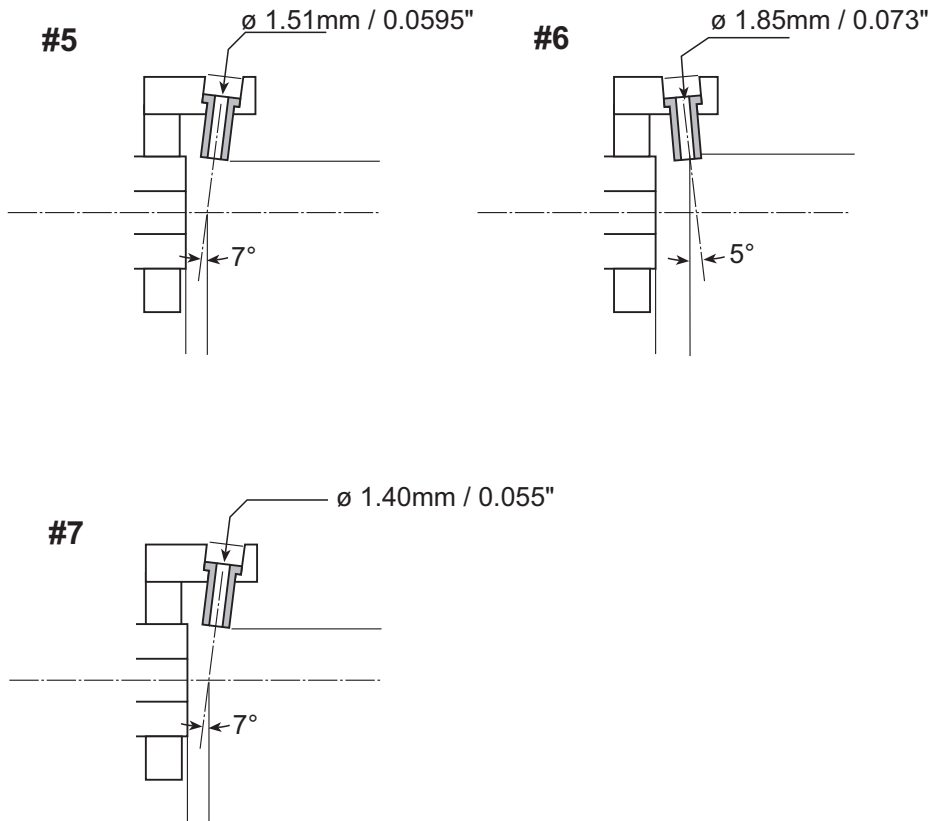
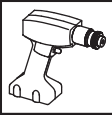


9mb_injectors_1-4

Item No.	Description	Qty.	Catalog. No.	Order No.
Standard Powder Port (Supplied with spray gun.)				
87	No. 2 Powder Port Assembly	2	9MB972	1001668
88	Powder Stem	2	3M202	1000679
89	No. 2 Powder Port	2	3M210	1000681
90	No. 2 Mounting Block	2	9MB982	1001674
Optional Powder Ports				
98	No. 1 Powder Port Assembly		9MB971	1001667
99	Powder Feed Tube	1	—	—
100	No. 1 Powder Port	1	—	—
101	No. 1 Mounting Block	1	—	—
102	No. 3 Powder Port Assembly		9MB973	1001669
103	No. 3 Powder Port	1	3M203	1000680
104	No. 3 Mounting Block		9MB983	1001675
105	No. 4 Powder Port Assembly		9MB974	1001670
106	No. 4 Powder Port	1	3M215	1000683
107	No. 4 Mounting Block	1	9MB984	1006428

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2.5.2 Powder Injectors (continued)



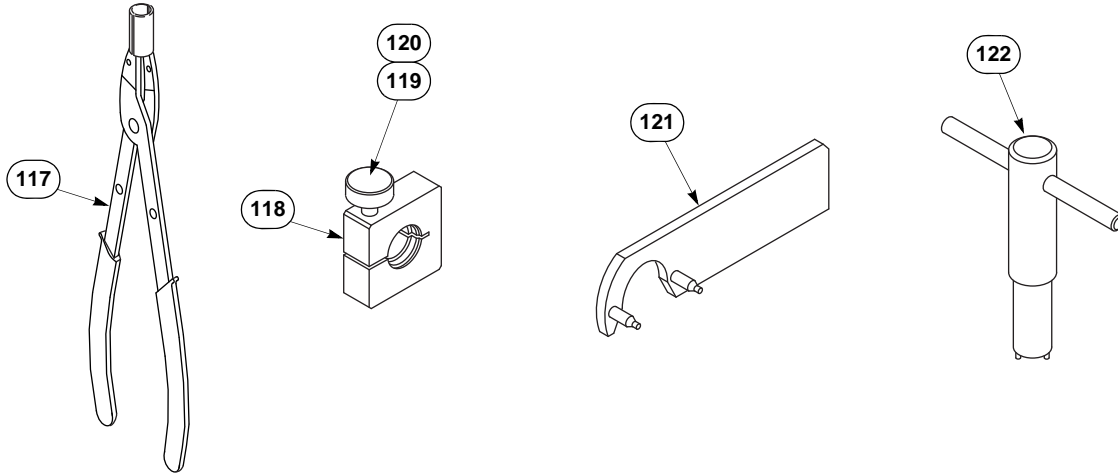
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Item No.	Description	Qty.	Catalog. No.	Order No.
Optional Powder Ports (continued)				
108	No. 5 Powder Port Assembly <i>(incl. item 88)</i>		9MB975	1001671
109	No. 5 Powder Port	1	3M246	1000685
110	No. 5 Mounting Block	1	9MB985	1001676
111	No. 6 Powder Port Assembly <i>(incl. item 88)</i>		9MB976	1001672
112	No. 6 Powder Port	1	7M288	1001485
113	No. 6 Mounting Block	1	9MB986	1032449
114	No. 7 Powder Port Assembly <i>(incl. item 88)</i>		9MB977	1001673
115	No. 7 Powder Port		9MB997	1032451
116	No. 7 Mounting Block		9MB987	1032450

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3 Additional Equipment

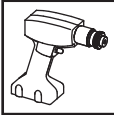
3.1 Tools and Spares



9mbh_tools

Item No.	Description	Qty.	Catalog. No.	Order No.
Standard Equipment (Supplied with spray gun.)				
117	Electrode Puller Pliers	1	7M108	1001461
118	Nozzle Wrench	1	9MB852	1005514
119	Flat Washer	1	2RG217	1000553
	(pkg. of 4)			
120	Thumb Screw, 10-24 X 1-5/8L X 3/4	1	9MB445	1001628
121	Nozzle Nut & Locking Ring Wrench	1	7M98	1001519
122	Electrode Spanner Wrench	1	10MB104	1000102
123	Ringlube	1	2M182	1000508
124	Control Cable (5.5 m / 18')	1	7M195	1001480
125	Reseal Kit	1	9MB54127	1016455
3	O-Ring, Black Viton, 1.114x0.07 in.	4	7M57	1001495
4	O-Ring, Black Viton, 0.614x0.07 in.	4	7M111	1001462
6	O-Ring, Black Viton, 0.850x0.045 in.	2	9MB297	1001625
9	O-Ring, Black Viton, 0.426x0.07 in.	4	7M51	1001493
11	O-Ring, Buna, 0.426x0.07 in.	4	2M199	1000521
12	O-Ring, Buna, 0.239x0.07 in.	4	4EFC56	1000861
14	O-Ring, Buna, 0.926x0.07 in.	4	9MB296	1001624
16	O-Ring, Buna, 0.739x0.07 in.	4	5PT21	1001202
17	O-Ring, Buna, 0.864x0.07 in.	2	10E46	1000100
23	O-Ring, Black Viton, 0.489x0.07 in.	2	2-014V	1000359
43	O-Ring, Buna, 1.239x0.07 in.	2	2AF29	1000457

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Item No.	Description	Qty.	Catalog. No.	Order No.
Optional				
126	Hardware Kit	—	9MB54128	1035444
29	Screw, 1/4-20 X 7/8	4	2M115	1000507
30	Lock Washer	4	PH21	1002189
34	Screw, 10-32 X 3/4	1	7M122	1001466
37	Screw, 8-32 X 5/32	2	7M68	1032360
38	Spring Washer	2	—	—
39	Screw, 8-32 X 1/4	2	6P29	1032138
40	Screw, 10-32 X 11/16	6	—	—
41	Screw, 10-32 X 1-1/8	2	7M577	1032357
85	Screw, 10-24X1-13/64	1	3M327	1000692
86	Screw, 8-32 X 3/16	4	9MB962	1001665

3.2 Hoses and Cables

Water-cooled power cables and plasma gas hoses are listed below. Plasma gas hoses may also be supplied with the plasma control unit. Powder hoses are supplied with the powder feeder or selected based on the spraying application.

Item No.	Description	Qty.	Catalog. No.	Order No.
127	Control Cable (8.5 m / 28')	—	7M199	1032340
128	Control Cable (made to order, 1.5-15 m / 5-15')	—	7M199CTO	1075639
129	Hose & Cable Package, 5 m (16.4') <i>(includes items 130-133)</i>	—	8MH	1034011
130	Plasma Gas Hose	1	7MH50	1001561
131	Electric Cable, Water Cooled (Red) 5 m (16.4')	1	8MH57586	1034012
132	Electric Cable, Water Cooled (Blue) 5 m (16.4')	1	8MH57587	1034013
133	T-Clip Fastener <i>(pkg. of 3)</i>	3	8MH58390	1093447
134	Hose & Cable Package, 8 m (26') <i>(includes 133, 135-137)</i>	—	8MH-8	1034014
135	Plasma Gas Hose, 9.1 m (30')	1	7MH116	1001553
136	Electric Cable, Water Cooled (Red) 8 m (26')	1	8MH57568	1034470
137	Electric Cable, Water Cooled (Blue) 8 m (26')	1	8MH57567	1034471
138	Hose & Cable Package, 3.5 m (11.5') <i>(includes 133, 139-142)</i>	—	8MH-3.5	1058503
139	Electric Cable, Water Cooled (Red) 3.5 m (11.5')	1	8MH58592	1058539
140	Electric Cable, Water Cooled (Blue) 3.5 m (11.5')	1	8MH58593	1058540
141	Plasma Gas Hose, 3.5 m (11.5')	1	8MH58594	1058541
142	Air Hose 3.5 m (11.5')	1	8MH58595	1058543
143	Hose & Cable Package, 1.5 m (5') <i>(includes 133, 144-147)</i>	—	8MH-1.5	1058504
144	Electric Cable, Water Cooled (Red) 1.5 m (5')	1	8MH58586	1058550
145	Electric Cable, Water Cooled (Blue) 1.5 m (5')	1	8MH58588	1058551
146	Plasma Gas Hose, 1.5 m (5')	1	MH58589	1058552
147	Air Hose 1.5 m (4.9')	1	8MH58590	1058553
Made-to-Order Lengths <i>(Minimum 1.5 m / 5' to maximum 10.5 m / 35')</i>				
148	Hose & Cable Package <i>(includes 133, 149-151)</i>	—	8MHCTO	1034390
149	Plasma Gas Hose	1	7MH50MTO	1034352
150	Electric Cable, Water Cooled (Red)	1	8MH20CTO	1034543
151	Electric Cable, Water Cooled (Blue)	1	8MH10CTO	1034542

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