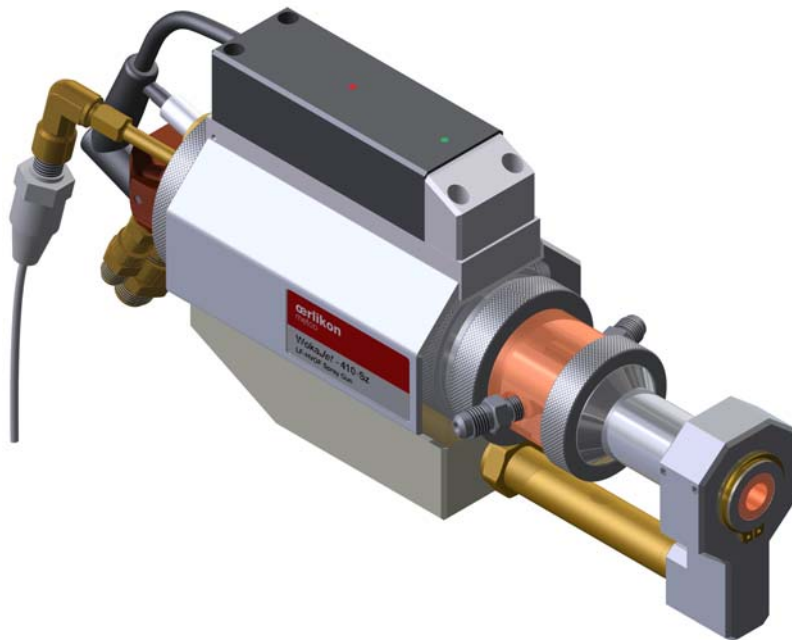


# WokaJet™-410 Spray Gun

## HVOF Spraying


Parts List  
PL 98995 EN 13




## Oerlikon Metco US, Inc.

1101 Prospect Avenue

Westbury, NY 11590

 +1 516 334 1300

 +1 516 338 2414

[www.oerlikon.com/metco](http://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**

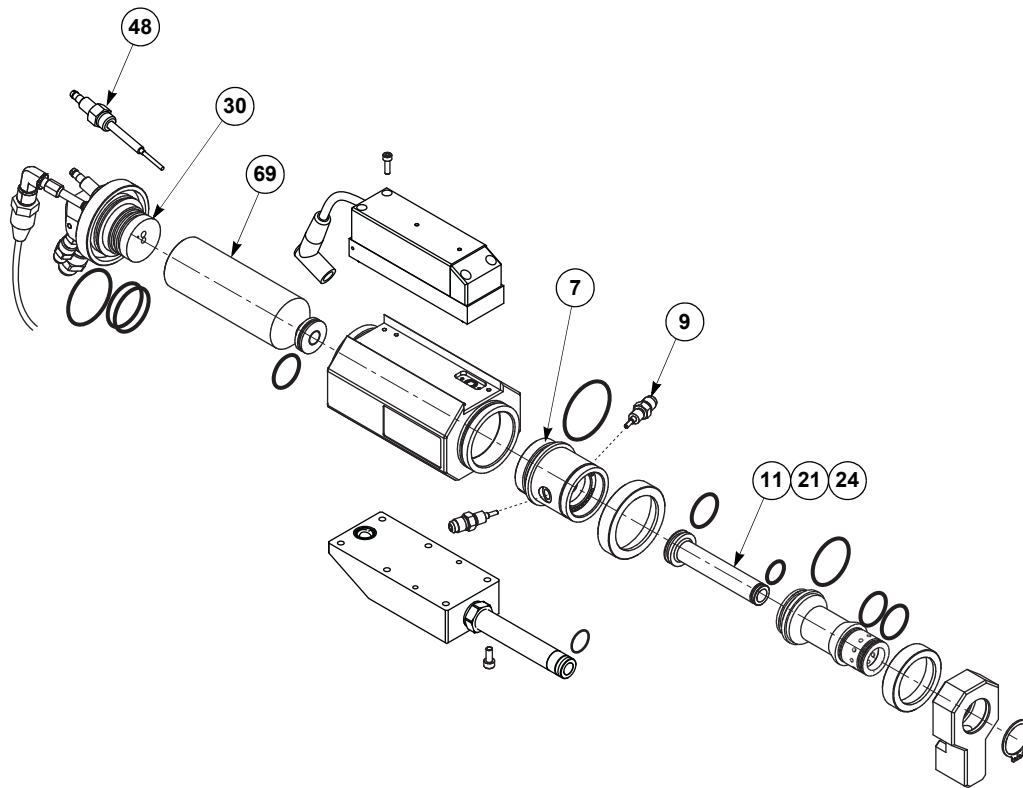
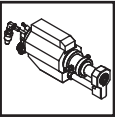
Parts recommended in order to guarantee maximum availability of component. This prevents downtime caused by delay in procurement.



## Warranty Disclaimer

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

# 1 Recommended Spare Parts, WokaJet™-410 Spray Gun



wj-410\_spare

Item No.	Description	Qty.	Cat.	Order No.
7	Middle Gun Body	1	K	1041806
9	Powder Injector	2	K	1041807
11	Barrel, 4"	1	C	1039131
21	Barrel, 6" (optional)	1	C	1039132
24	Barrel, 8" (optional)	1	C	1042672
30	Burner Assembly	1	K	1041798
48 <sup>(1)</sup>	Spark Plug	1	K	1071047
69	Combustion Chamber	1	W	1039375
78	Krytox®	1	C	1070061
83	Reseal Kit	1	W	1075833

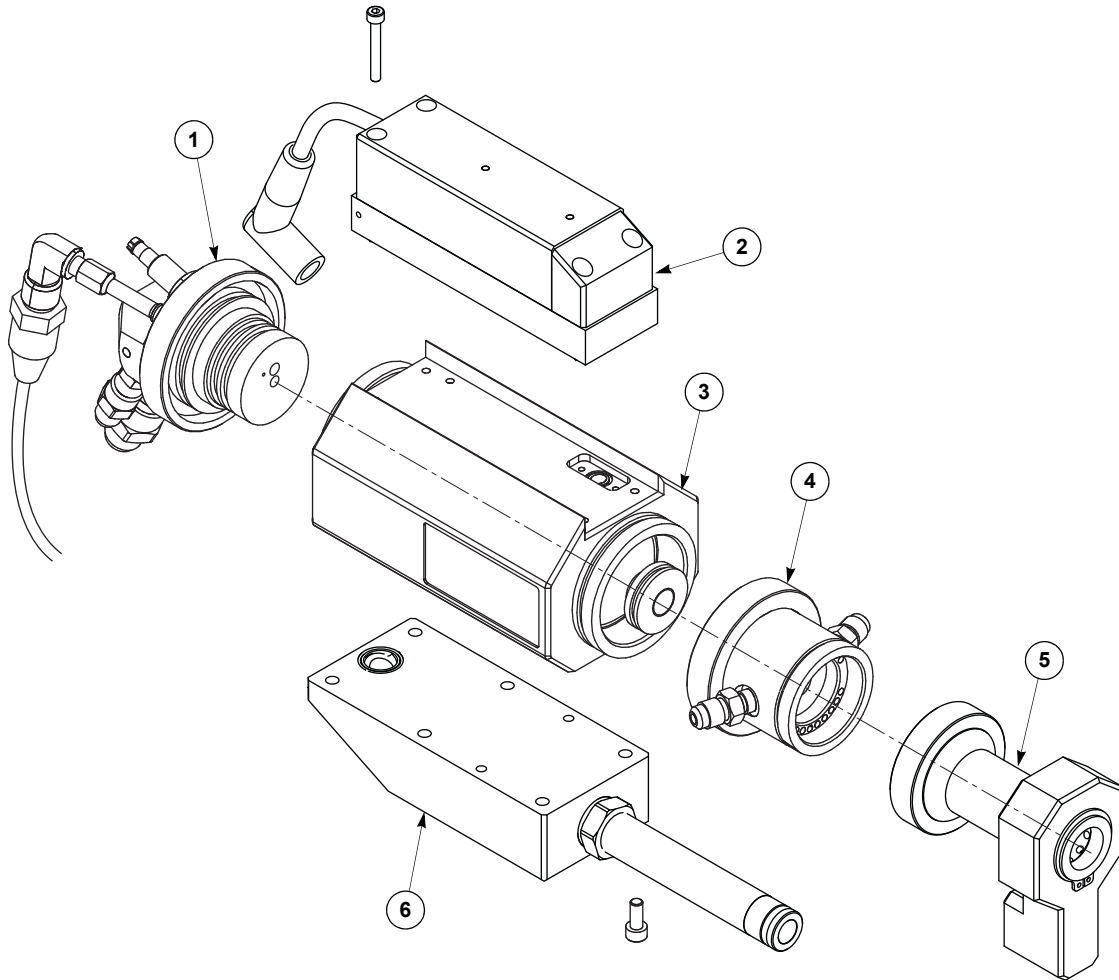
1. WokaJet-410-Sz and WokaJet-410-S

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## 2 Parts List for WokaJet™-410 Spray Gun

### 2.1 Spray Gun Assembly

WokaJet-410 HVOF Spray Gun	(hydrogen pilot)	1070683
WokaJet-410-S HVOF Spray Gun	(spark plug)	1070995
WokaJet-410-Sz HVOF Spray Gun	(spark plug with ignition)	1089589

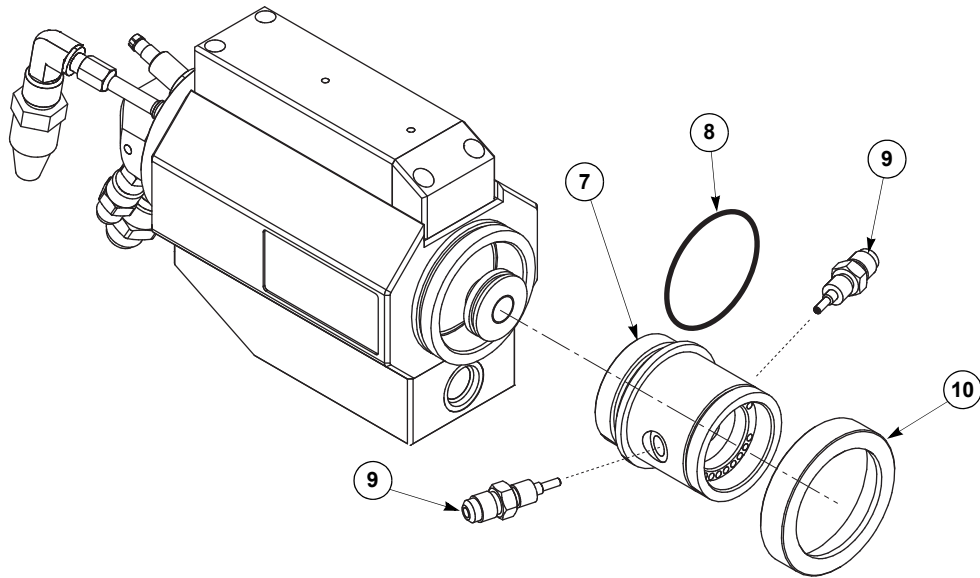
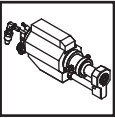


wj-410\_overview

Item No.	Description	Qty.	Order No.
1	Burner Assembly	1	See page 8.
2 (1)	Ignition Assembly	1	See page 10.
3	Rear Gun Body Assembly	1	See page 10.
4	Middle Gun Body Assembly	1	See page 5.
5	Front Gun Body Assembly	1	See page 6.
6	Water Connection / Mounting Block	1	See page 10.

1. WokaJet-410-Sz

## 2.2 Middle Gun Body

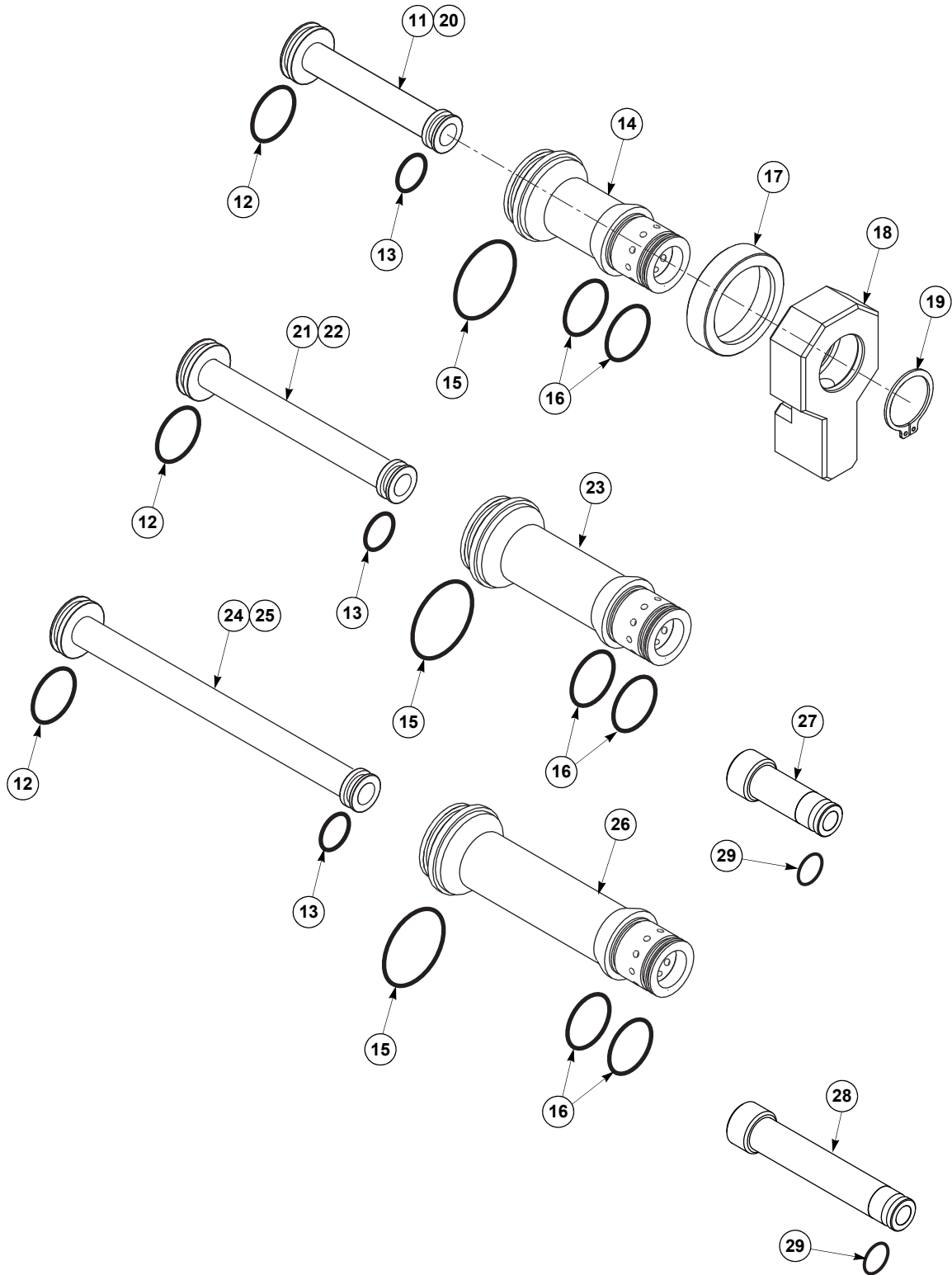


wj-440\_mid

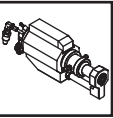
Item No.	Description	Qty.	Order No.
7	Middle Gun Body (includes item 8)	1	1041806
8	O-Ring, Buna 1.674 x 0.103 in.	1	1017589
9	Powder Injector	2	1041807
10	Middle Ring Nut	1	1041808

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## 2.3 Front Gun Body



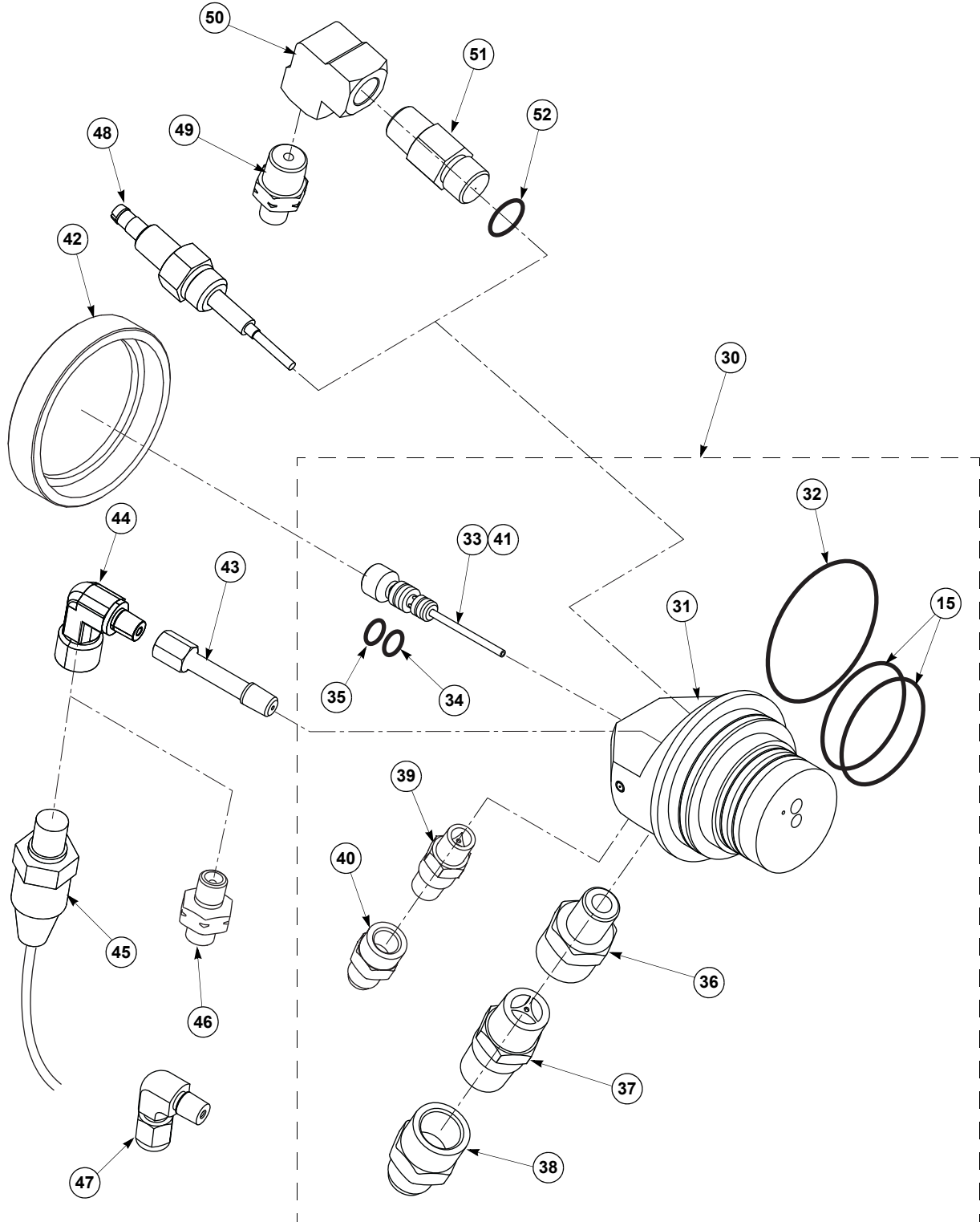
wj-440\_front



Item No.	Description	Qty.	Order No.
11	Barrel, 4" (includes items 12 & 13)	1	1039131
12	O-Ring (Rear), Viton 0.924 x 0.103 in.	1	1041816
13	O-Ring (Front), Viton 0.549 x 0.103 in.	1	1060529
14	Front Gun Body, 4" (includes items 15 & 16)	1	1041810
15	O-Ring (Rear), Viton 1.266 x 0.103 in.	1	1017893
16	O-Ring (Front), Black Viton 0.989 x 0.07 in.	2	1000225
17	Front Ring Nut	1	1041813
18	Water Manifold	1	1072287
19	Snap Ring	1	1041812
<b>Optional:</b>			
20	Barrel, 4" (with chamfer) (includes items 12 & 13)	—	1072819
21 <sup>(1)</sup>	Barrel, 6" (includes items 12 & 13)	—	1039132
22 <sup>(1)</sup>	Barrel, 6" (with chamfer) (includes items 12 & 13)	—	1072820
23 <sup>(1)</sup>	Front Gun Body, 6" (includes items 15 & 16)	—	1041386
24 <sup>(2)</sup>	Barrel, 8" (includes items 12 & 13)	—	1042672
25 <sup>(2)</sup>	Barrel, 8" (with chamfer) (includes items 12 & 13)	—	1072821
26 <sup>(2)</sup>	Front Gun Body, 8" (includes items 15 & 16)	—	1042877
27	Water Tube, 6" Extension (includes items 29)	—	1072315
28	Water Tube, 8" Extension (includes items 29)	—	1072316
29	O-Ring, Buna, 0.487 x 0.103 in.	1	1072313

1. Water Tube, 6" Extension, item 27 also required with this item.
2. Water Tube, 8" Extension, item 28 also required with this item.

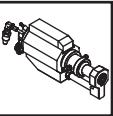
## 2.4 Burner Assembly



wj-410\_burner

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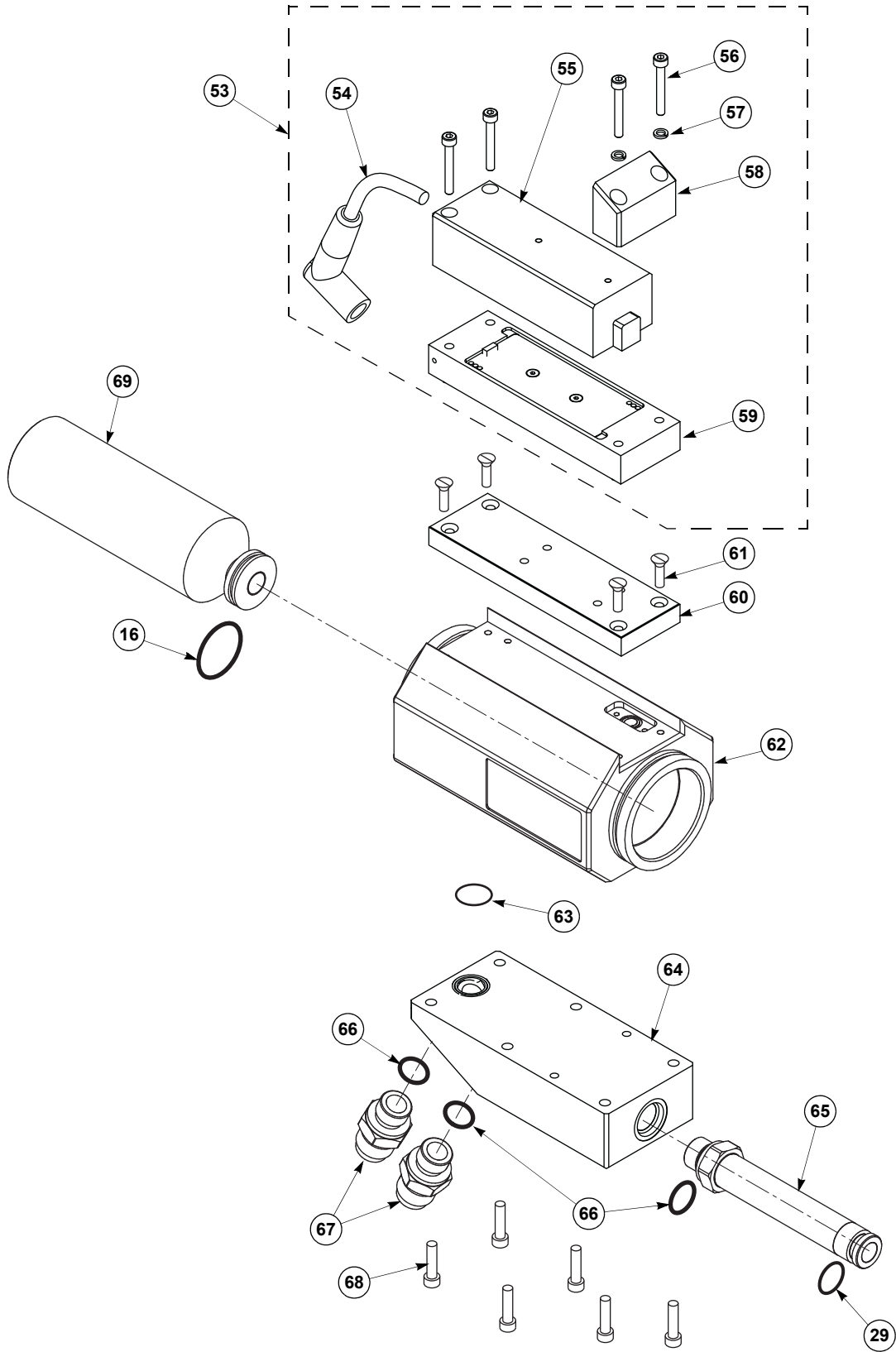




Item No.	Description	Qty.	Order No.
30	Burner Assembly (includes items 32 - 40)	1	1041798
31	Burner Body Assembly (includes items 15 & 32)	1	1094268
15	O-Ring, Viton 1.266 x 0.103 in.	2	1017893
32	O-Ring, Black Viton 1.799 x 0.103 in.	1	1000384
33	Fuel Injector Assembly (includes items 34 & 35)	1	1041799
34	O-Ring (Front), Buna 0.145 x 0.07 in.	1	1017522
35	O-Ring (Rear), Buna 0.208 x 0.07 in.	1	1001434
36	Pipe Adapter, 1/4NPTM x 3/8NPTF	1	—
37	Oxygen Check Valve	1	1041800
38	Oxygen Fitting	1	1041801
39	Fuel Check Valve	1	1041802
40	Fuel Fitting	1	1041803
41	Fuel Injector with chevrons tip ( <i>optional</i> )	—	1085962
42	Rear Ring Nut	1	1041805
43 (1)(2)	NPT Extension	1	1060332
44	Elbow, 1/8 NPTF X 1/16 NPTM	1	1066214
45 (1)	Transducer Assembly	1	1072288
46 (2)	Fitting 1/8NPT x 3/8-24LH	1	1066213
47 (2)	Male Elbow, 1/8 Tube x 1/16NPT ( <i>optional</i> ; use in place of items 44 & 46)	—	1060328
48 (1)(2)	Spark Plug	1	1071047
49 (3)	Hydrogen Fitting	1	1049884
50 (3)	Elbow 1/4 NPTF x 1/4 NPTF	1	1068349
51 (3)	Hydrogen Pilot Adapter Fitting	1	1059099
52 (3)	O-Ring, Black Viton 0.426 x 0.07 in. (pkg. 2)	1	1001493

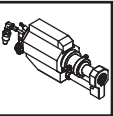
1. WokaJet-410-Sz
2. WokaJet-410-S
3. WokaJet-410

## 2.5 Rear Gun Body



wj-410\_rear

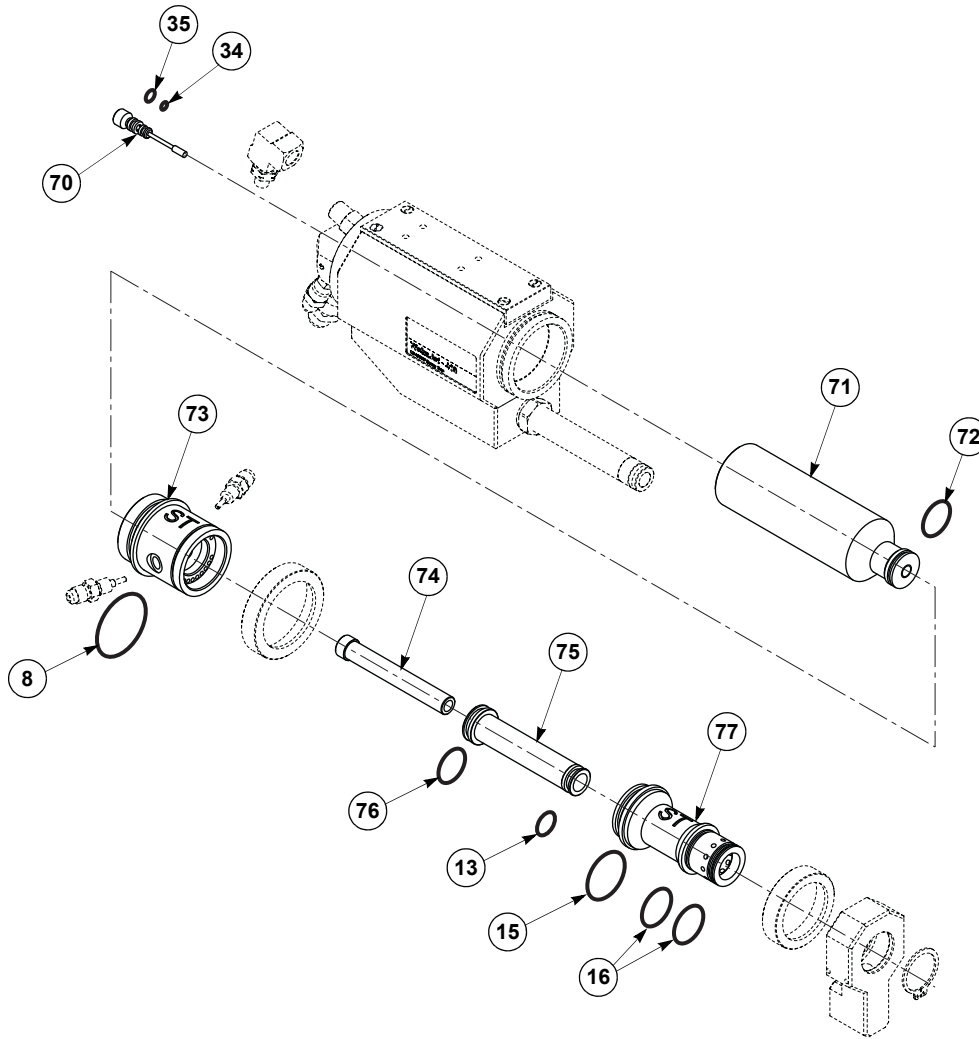
PL 98995 EN 13 Released on: 08/01/2018



Item No.	Description	Qty.	Order No.
16	O-Ring, Black Viton 0.989 x 0.07 in.	1	1000225
29	O-Ring, Buna, 0.487 x 0.103 in.	1	1072313
53 <sup>(1)</sup>	Ignition Assembly (includes items 54-59)	1	1082625
54	Spark Plug Ignition Cable	1	1072300
55	Ignition Unit	1	1072289
56	Screw, M4 x 30 mm	4	1070092
57	Lock Washer	2	1071113
58	Ignition Cover Clamp	1	1072290
59	Base Plate	1	—
60 <sup>(2)(3)</sup>	Blank Cover	1	1072291
61 <sup>(2)(3)</sup>	Screw, M4 x 16 mm	4	—
62	Rear Gun Body	1	1086531
63	O-Ring, Buna, 16 mm x 1 mm	1	1072296
64	Water Connection / Mounting Block	1	—
65	Water Tube, 4" (includes items 29 & 66)	1	1072312
66	O-Ring, Buna, 0.549 x 0.103 in. (pkg. of 3)	3	1015320
67	Water Fitting (includes item 66)	2	1072314
68	Screw, M5 x 12 mm	6	1072299
69	Combustion Chamber (includes item 16)	1	1039375

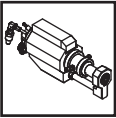
1. WokaJet-410-Sz
2. WokaJet-410-S
3. WokaJet-410

## 2.6 Small Target (ST) Parts (Optional)



wj-410\_st\_parts

Item No.	Description	Qty.	Order No.
8	O-Ring, Buna 1.674 x 0.103 in.	1	1017589
13	O-Ring, Viton 0.549 x 0.103 in.	1	1060529
15	O-Ring (Rear), Viton 1.266 x 0.103 in.	1	1017893
16	O-Ring (Front), Black Viton 0.989 x 0.07 in.	2	1000225
34	O-Ring (Front), Buna 0.145 x 0.07 in.	1	1017522
35	O-Ring (Rear), Buna 0.208 x 0.07 in.	1	1001434
70	Fuel Injector Assembly ST (includes items 34 & 35)	1	1061138
71	Combustion Chamber Assembly ST (includes item 72)	1	1062826
72	O-Ring, Black Viton 0.864 x 0.07 in.	1	1015536
73	Middle Gun Body Assembly ST (includes item 8)	1	1062827
74	Inner Barrel ST	1	1062830
75	Outer Barrel Assembly ST (includes items 13 & 76)	1	1062829
76	O-Ring (Rear), Black Viton 0.799 x 0.103 in. (pkg. 3)	1	1001173
77	Front Gun Body Assembly ST (includes items 15 & 16)	1	1062831



## 2.7 Tools and Spares

The following items are supplied with WokaJet™-410 Spray Gun.

Item No.	Description	Qty.	Order No.
78	Krytox®	1	1070061
79	Allen Wrench, 7/32"	1	1041815
80	Retaining Ring Pliers	1	1004993
81 <sup>(1)</sup>	Flame Sensor Adapter Block	1	1075927
82 <sup>(1)</sup>	Screw, M4 x 12mm (pkg. of 4)	2	1062281
83	Reseal Kit includes the following items:	1	1075833
8	O-Ring, Buna 1.674 x 0.103 in.	1	1017589
12	O-Ring, Viton 0.924 x 0.103 in.	1	1041816
13	O-Ring, Viton 0.549 x 0.103 in.	1	1060529
15	O-Ring, Viton 1.266 x 0.103 in.	3	1017893
16	O-Ring, Black Viton 0.989 x 0.07 in.	3	1000225
29	O-Ring, Buna, 0.487 x 0.103 in.	1	1072313
32	O-Ring, Black Viton 1.799 x 0.103 in.	1	1000384
34	O-Ring, Buna 0.145 x 0.07 in.	1	1017522
35	O-Ring, Buna 0.208 x 0.07 in.	1	1001434
52	O-Ring, Black Viton 0.426 x 0.07 in.	1	1001493
63	O-Ring, Buna, 16 mm x 1 mm	1	1072296

1. Not supplied with WokaJet-410-Sz.

### 3 Additional Equipment

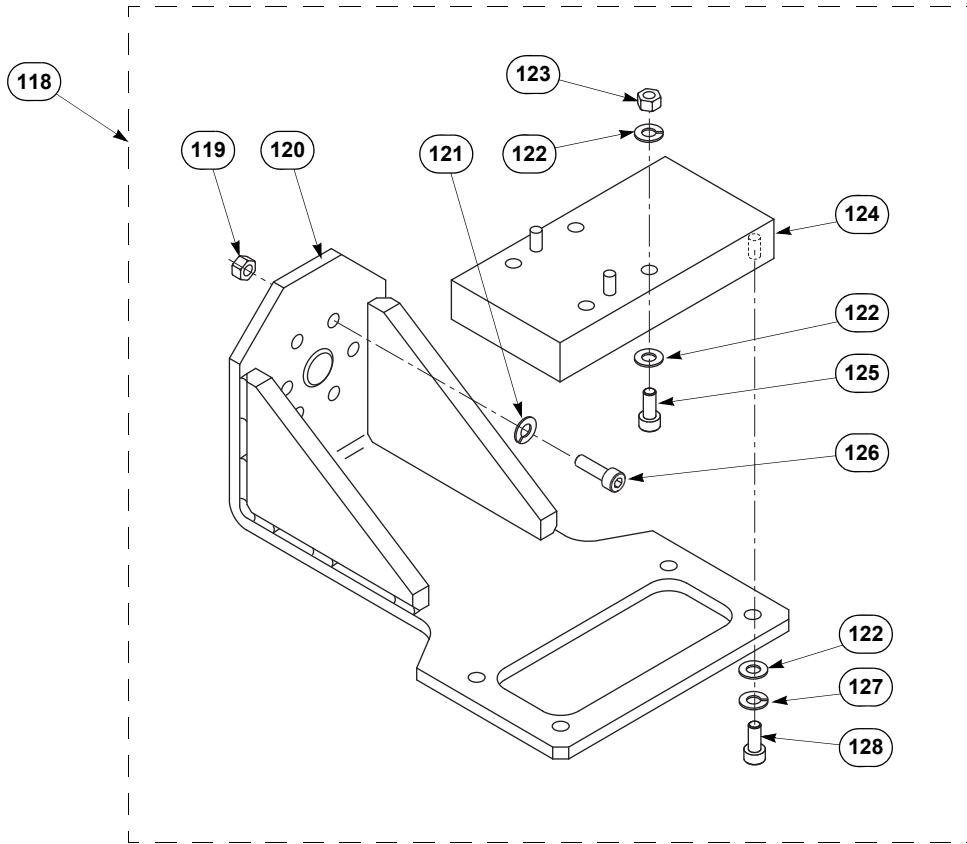
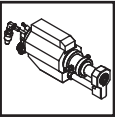
Items in this section are not supplied with WokaJet™-410 Spray Gun.

#### 3.1 Hoses and Fittings

Item No.	Description	Qty.	Order No.
<b>Standard Hose Packages and Fittings</b>			
84	Complete 18H Hose Assembly 25' (7.6 m; spray gun to JAMbox)	—	1041826
85	Hydrogen Hose Assembly 25' (7.6 m)	1	1041821
86	Oxygen Hose Assembly 25' (7.6 m) 3/8 ID	1	1041822
87	Fuel Hose Assembly 25' (7.6 m) 1/4 ID	1	1041823
88	Complete 18H-15 Hose Assembly 15' (4.6 m; spray gun to JAMbox)	—	1049797
89	Hydrogen Hose Assembly 15' (4.6 m)	1	1059809
90	Oxygen Hose Assembly 15' (4.6 m) 3/8 ID	1	1059830
91	Fuel Hose Assembly 15' (4.6 m) 1/4 ID	1	1059833
92	Complete 18H-35 Hose Assembly 35' (10.7 m; spray gun to JAMbox)	—	1049798
93	Hydrogen Hose Assembly 35' (10.7 m)	1	1059827
94	Oxygen Hose Assembly 35' (10.7 m) 3/8 ID	1	1059831
95	Fuel Hose Assembly 35' (10.7 m) 1/4 ID	1	1059835
96	Complete 18H-50 Hose Assembly 50' (15.2 m; spray gun to JAMbox)	—	1049799
97	Hydrogen Hose Assembly 50' (15.2 m)	1	1059828
98	Oxygen Hose Assembly 50' (15.2 m) 3/8 ID	1	1059832
99	Fuel Hose Assembly 50' (15.2 m) 1/4 ID	1	1059836
100	Complete 19H-25 Hose Assembly 25' (7.6 m; Includes 86, 87, 101 & 102.)	—	1070914
101	Water-In Hose Assembly, 25' (7.6 m)	1	1001819
102	Water-Out Hose Assembly, 25' (7.6 m)	1	1001820
103	Complete 19H-50 Hose Assembly 50' (15.2 m; Includes 98, 99, 104 & 105.)	—	1070831
104	Water Hose-In (made to order 5-50')	1	1049868
105	Water Hose-Out (made to order 5-50')	1	1049869
106	Complete 19H-70 Hose Assembly 70' (21.3 m; Includes 107-110.)	—	1301048
107	Water-In Hose Assembly, 70' (21.3 m)	1	1049868
108	Water-Out Hose Assembly, 70' (21.3 m)	1	1049869
109	Oxygen Hose Assembly 70' (21.3 m) 1/4 ID	1	—
110	Fuel Hose Assembly 70' (21.3 m) 1/4 ID	1	—
111	Quick Disconnect Socket 3/8NPTF	—	1001821
112	Hose Hex Nipple Fitting, 1/2 x 3/8-18NPTF	—	1001822
<b>Praxair JP-5000 Integration Components</b>			
47	Male Elbow, 1/8 Tube x 1/16NPT (use in place of items 44 & 46)	—	1060328
113	Praxair Adapter Kit (Refer to AI128356.)	—	1098196
114	Praxair-style Powder Tube	—	1042920
<b>Gun Cable Packages (For WokaJet-410-Sz. Each includes sensor, ignition and ground cables.)</b>			
115	Liquid Fuel Gun Cable Package, 8 m (26 ft)	—	1090453
116	Liquid Fuel Gun Cable Package, 15 m (50 ft)	—	1090463
117	Liquid Fuel Gun Cable Package, 20 m (66 ft)	—	1301092

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### 3.2 Mounting Bracket

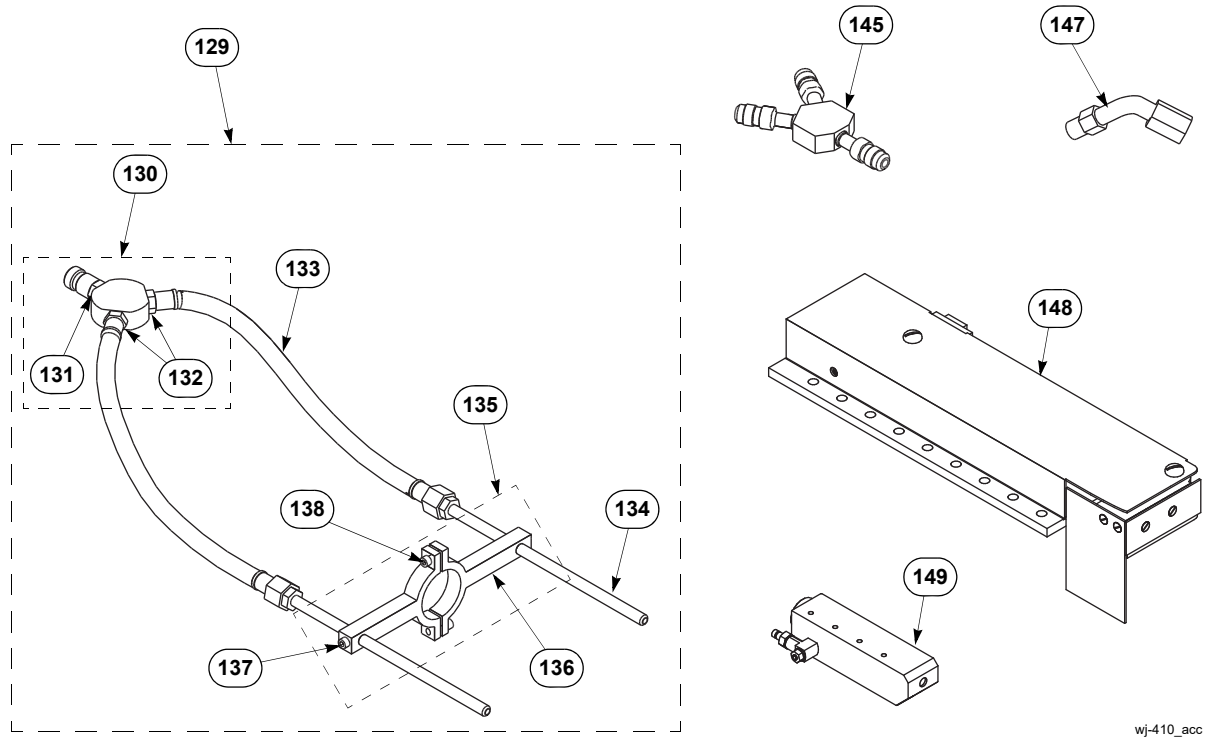


wj-440\_mount

Item No.	Description	Qty.	Order No.
118	Gun Bracket Assembly, 90° includes items 119-128		1071272
119	Nut, 6mm X 5mm (pkg. of 5)	6	1000197
120	Gun Bracket	1	—
121	Split Spring Lock Washer	6	1038223
122	Flat Washer (pkg. of 4)	12	1000553
123	Nut, M5	4	—
124	Insulator Plate	1	—
125	Screw, M5 X 20mm	4	—
126	Screw	6	1038221
127	Spring Lock Washer (pkg. of 4)	4	1000554
128	Screw, 10-32 X 9/16	4	—

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### 3.3 Accessories



wj-410\_acc

Item No.	Description	Qty.	Order No.
129	Air Jet Assembly	—	1051091
	includes items 130-139		
130	Wye Assembly	1	1000541
131	Hex Nipple	1	1000824
132	Hex Nipple	2	1000464
133	Hose Assembly Air Nozzle 15 in. (380 mm)	2	1000543
134	Air Jet Tube Assembly	2	1060775
135	Air Jet Clamp Assembly	1	1060774
	includes items 136-138		
136	Air Jet Clamp	2	1051090
137	Screw, M5x8	(pkg. 10)	1000178
138	Screw, M5x20	2	—
139	Air Hose 10.7 m (35 ft; not shown)	1	1001451
140	Air Hose 4.6 m (15 ft, not shown)	—	1001319
141	Air Hose 5.8 m (19 ft, not shown)	—	1001473
142	Air Hose 15.2 m (50 ft, not shown)	—	1005827
143 <sup>(1)</sup>	Hose Fitting, 1/4" X 9/16-18RH	—	1301332
144	Powder Wye Assembly	—	1049888
	includes items 145 & 146		
145	Powder Wye	1	1049944
146	Powder Feed Hose, Orange, 0.34 m (1.1') 3.2 mm (1/8") ID (not shown)	2	1049945
147	Powder 45 Elbow	—	1000694
148	Ignition Device, ZG2 (Refer to MAN 121082.)	—	1083161
149	Flame Sensor, 90° (Refer to MAN 121082.)	—	1009657

1. Use to connect/combine any two air hoses, items 139–142.