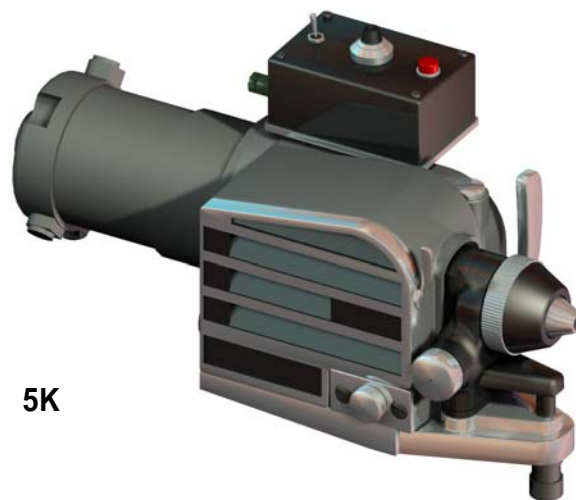


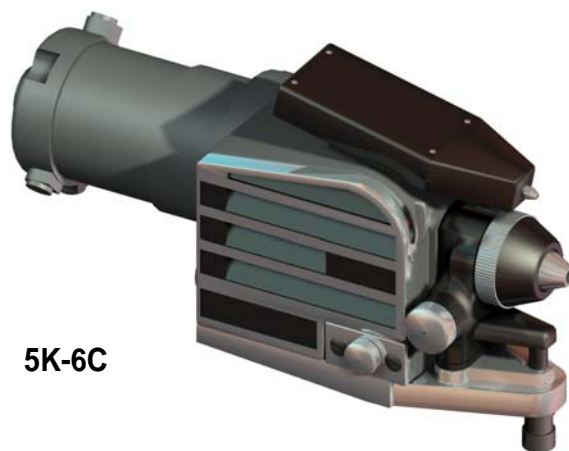
5K / 5K-6C Flame Spray Machine

Combustion Wire Spraying

Parts List
PL 77921 EN 08



5K





5K-6C

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



Parts Depending on Parameters

Designation	Qty	Cat	Old Art. no.	Art. no.
Air cap	1	W	See page 6	
Siphon plug assembly	1	W	See page 7	
Nozzle	1	W	See page 8	
Front wire guide	1	W	See page 10	
Upper drive roll	1	W	See page 14	
Lower drive roll	1	W	See page 14	

Illustrated Parts

Pos.	Designation	Qty	Cat	Old Art. no.	Art. no.
8	O-ring main housing air seal (pkg of 4)	1	W	5K14	1000143
22	O-ring valve core (pkg of 4)	1	W	5K14	1000143
40	Siphon plug O-ring (pkg of 4)	4	W	5K14	1000143
41	Nozzle O-ring, small (pkg of 2)	1	W	5K509	1004714
42	Nozzle O-ring, large (pkg of 2)	1	W	5K508	1000138
145	Fuse 3A 125V Slo-Blow (pkg of 5)	1	K	3K451	1042068

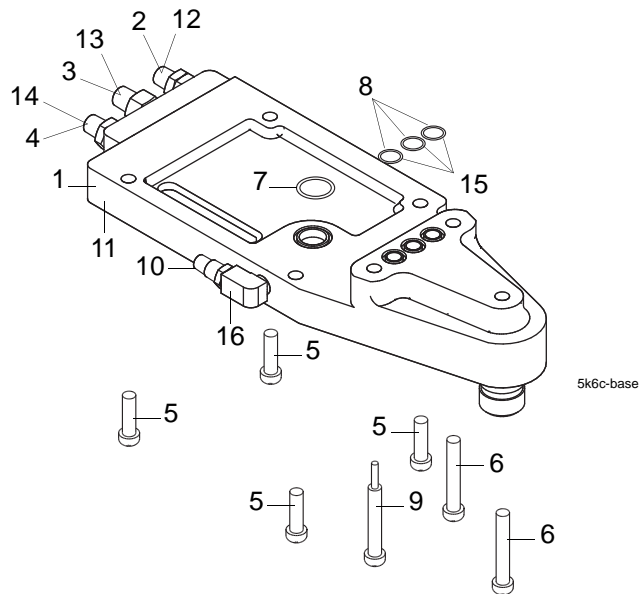
Tools and Miscellaneous

Designation	Qty	Cat	Old Art. no.	Art. no.
Gearlube	1	C	5K110	1001107
Krytox®	1	C	16E97041	1070061
Reseal kit (O-rings siphon plug, nozzle) <i>includes pos. 40, 41, 42</i>	1	W	5K190	1000152

2 Parts List

5K Spray Gun	5K	1001105
5K-6C Spray Gun	5K-6C	1001125

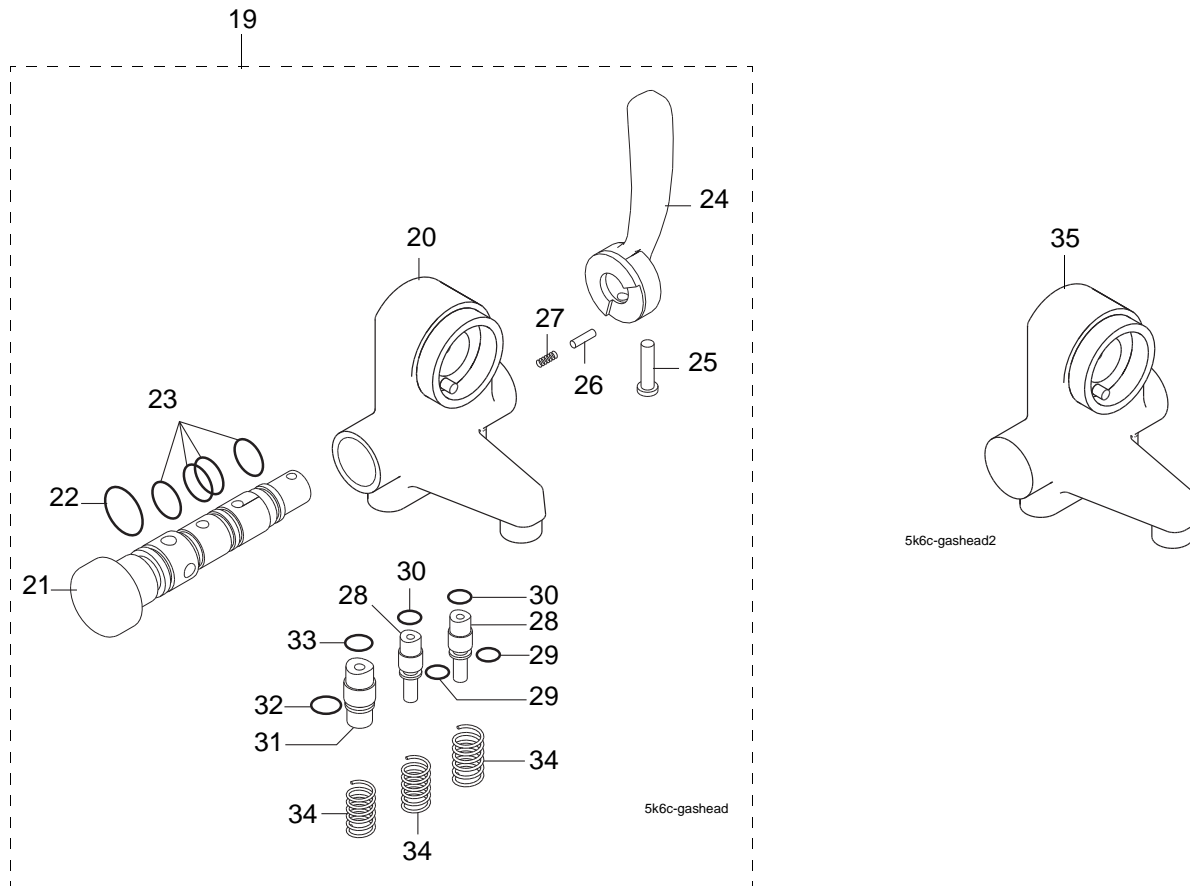
2.1 Base Assembly



Pos.	Designation		Qty	Old Art. no.	Art. no.
5K Spray Gun					
1	Base assembly 5K	<i>includes Pos. 2, 3, 4</i>	1	5K139	1000633
2	Fuel gas hose connection		1	5K21	1000825
3	Oxygen hose connection		1	5K22	1000826
4	Air hose connection		1	5K23	1000824
5	Main housing mounting screw (pkg of 6)		4	5K133	1000631
6	Gas head mounting screw (pkg of 3)		2	5K141	1000634
7	O-ring main housing air seal (pkg of 4)		1	5K14	1000143
8	O-ring base gas head seal (pkg of 6)		3	5K195	1001787
9	Stop screw valve core		1	5K318	1000661
5K-6C Spray Gun					
5	Main housing mounting screw (pkg of 6)		4	5K133	1000631
6	Gas head mounting screw (pkg of 3)		3	5K141	1000634
7	O-ring main housing air seal (pkg of 4)		1	5K14	1000143
10	Hose connection		1	5K22	1000826
11	Base assembly 5K-6C	<i>includes Pos. 12, 13, 14</i>	1	5K940	1005209
12	Fuel gas hose connection		1	5K48182	1035402
13	Oxygen hose connection		1	5K48181	1035401
14	Air hose connection		1	5K23	1000824
15	O-ring base and gas head seal (pkg of 3)		3	5K137	1006359
16	Elbow		1	5K169	1005203



2.2 Gas Head

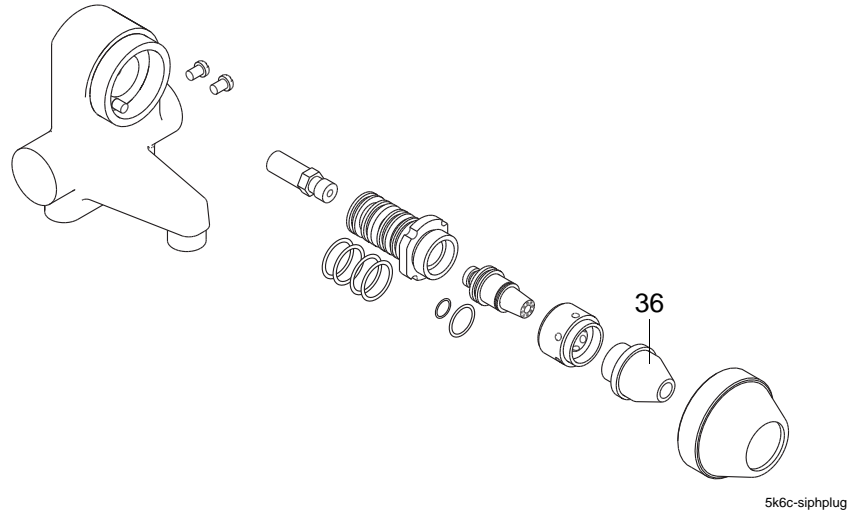


Pos.	Designation	Qty	Old Art. no.	Art. no.
19	Gas head assembly for 5K Spray Gun <i>includes pos. 20 - 34</i>	1	5K505	1001115
20	Gas head subassembly	1	5K515	1001119
21	Valve core	1	5K511	1001117
22	O-ring valve core (pkg of 4)	1	5K14	1000143
23	O-ring valve core (pkg of 6)	4	5K195	1001787
24	Valve handle	1	5K512	1000267
25	Screw valve handle	1	5K12	1000829
26	Detent pin	1	5K309	1000659
27	Spring detent pin	1	5K317	1000660
28	Plunger fuel gas and oxygen	2	5K303	1000654
29	O-ring fuel gas and oxygen plunger (pkg of 2)	2	4EFC56	1000861
30	Seal O-ring fuel gas and oxygen plunger (pkg of 2)	2	5K306	1000657
31	Plunger air	1	5K304	1000655
32	O-ring air plunger (pkg of 2)	1	5K226	1002023
33	Seal O-ring air plunger	1	5K305	1000656
34	Plunger spring	3	5K307	1000658
—	O-ring package for gas head assembly 5K505 <i>includes pos. 22, 23, 29, 30, 32, 33</i>	—	5K680	1001124
35	Gas head assembly for 5K-6C Spray Gun	1	5K505A	1001116

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2.3 Siphon Plug and Related Parts

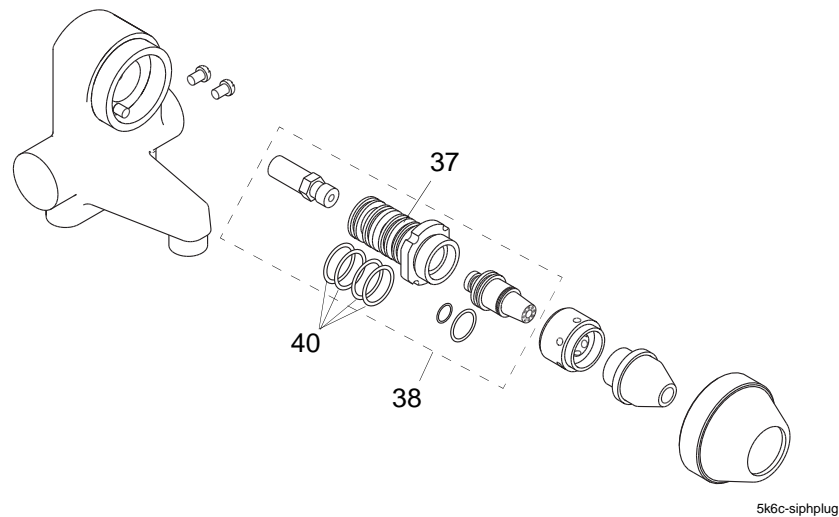
2.3.1 Air Caps



Pos.	Designation		Old Art. no.	Art. no.
Air Caps "Standard"				
Standard with 5K / 5K-6C				
36a	EC	1/8"	5K3-EC	1001570
36b	C	1/8" (bond coat)	5K3-C	1002413
36c	EA	3/16"	5K3-EA	1000666
Optional				
36d	J	11 Ga. / 15 Ga.	5K3-J	1000835
36e	M	15 Ga.	5K3-M	1000836
36f	AM	3/16" MPS	5K3-AM	1000663
Air Caps "Non-load" (optional)				
36g	CH	Non-Load 1/8"	5K3-CH	1000664
36h	AH	Non-Load 3/16"	5K3-AH	1000662
36i	JH	Non-Load 11 Ga.	5K3-JH	1000667
36j	MH	Non-Load 15 Ga.	5K3-MH	1000668
36k	(Deleted)		—	—
36l	CHM	Non-Load 1/8" MPS	5K3-CHM	1000665
Air Caps "Fan Spray" (optional)				
36m	AB Fan Spray	3/16"	5K4-AB	1002414
36n	CD Fan Spray	1/8"	5K4-CD	1000841



2.3.2 Siphon Plugs



Pos.	Designation	Qty	Old Art. no.	Art. no.
40	Siphon plug O-ring (pkg of 4)	4	5K14	1000143
—	Reseal kit (O-rings siphon plug, nozzle) <i>includes pos. 40, 41, 42</i>	1	5K590	1000152

Siphon Plugs

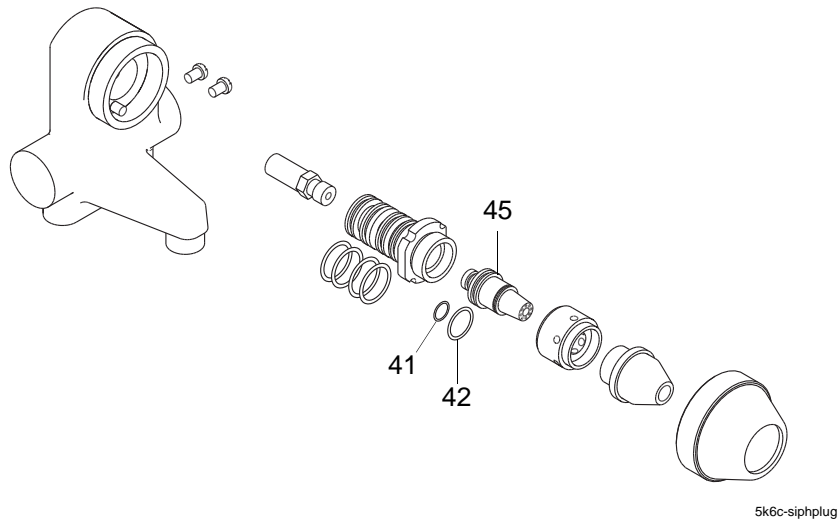
Standard with 5K / 5K-6C

37a	Siphon plug large gauge - Acetylene	<i>includes pos. 40</i>	1	5K2-5	1000259
Optional					
37b	Siphon plug large gauge - Propane/MPS	<i>includes pos. 40</i>		5K2-6	1000260
37c	Siphon plug small gauge - Acetylene	<i>includes pos. 40</i>		5K2-7	1000261
37d	Siphon plug small gauge - Propane/MPS	<i>includes pos. 40</i>		5K2-8	1000262

Siphon Plug Assemblies (Optional)

38a	Siphon plug assembly 3/16" Acetylene	<i>includes</i>		5K200-1	1001108
37a	Siphon plug large gauge - Acetylene	<i>includes pos. 40</i>		5K2-5	1000259
44	Nozzle nut			5K-606	1000270
45a	Nozzle assembly 3/16" Acetylene			5K7-42	1000285
46a	Front wire guide 3/16" - 1/8"			5K632	1001121
38b	Siphon plug assembly 1/8" Acetylene	<i>includes</i>		5K200-2	1001109
37a	Siphon plug large gauge - Acetylene	<i>includes pos. 40</i>		5K2-5	1000259
44	Nozzle nut			5K-606	1000270
45b	Nozzle assembly 1/8" Acetylene			5K7-48	1000290
46b	Front wire guide 1/8" - 11 Ga.			5K633	1001122

2.3.3 Nozzles

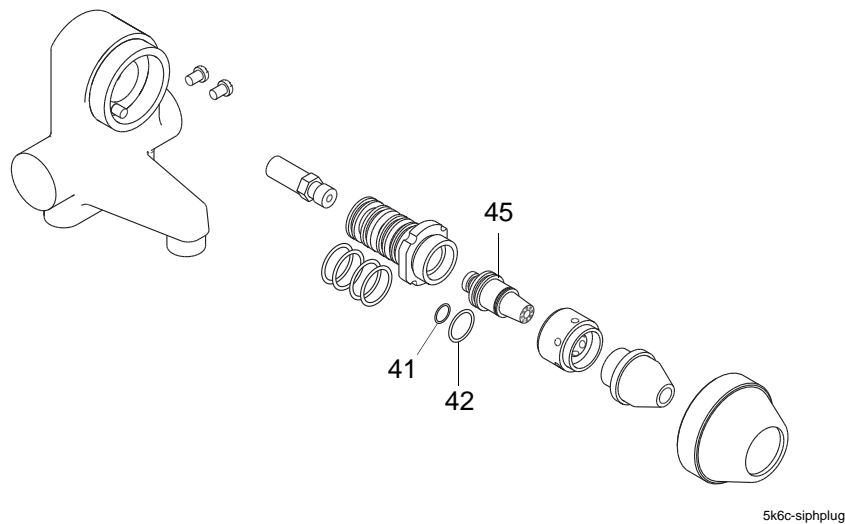


Pos.	Designation	Qty	Old Art. no.	Art. no.
41	O-ring (pkg of 2)	1	5K509	1004714
42	O-ring (pkg of 2)	1	5K508	1000138
—	Reseal kit (O-rings siphon plug, nozzle) <i>includes pos. 40, 41, 42</i>	1	5K590	1000152

Nozzles

Standard with 5K / 5K-6C				
45a	3/16"	Acetylene	1	5K7-42 1000285
45b	1/8"	Acetylene	1	5K7-48 1000290
Optional				
45c	11 Ga.	Acetylene		5K7-35 1000280
45d	15 Ga.	Acetylene		5K7-29 1000275
45e	3/16"	Propane		5K7-43 1000286
45f	1/8"	Propane		5K7-49 1000291
45g	11 Ga.	Propane		5K7-37 1000282
45h	15 Ga.	Propane		5K7-31 1000277
45i	3/16"	MPS		5K7-44 1031129
45j	1/8"	MPS		5K7-25 1000272
45k	11 Ga.	MPS		5K7-39 1004743
45l	15 Ga.	MPS		5K7-33 1000279

Additional nozzles listed on next page

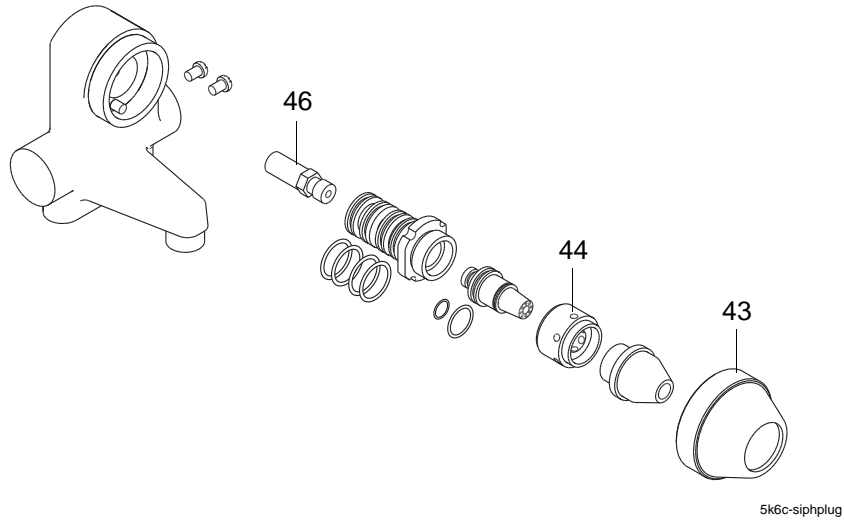


Pos.	Designation	Qty	Old Art. no.	Art. no.
41	O-ring (pkg of 2)	1	5K509	1004714
42	O-ring (pkg of 2)	1	5K508	1000138
—	Reseal kit (O-rings siphon plug, nozzle) <i>includes pos. 40, 41, 42</i>	1	5K590	1000152

Nozzles (optional)

45m	3/16" Acetylene (Non-Load)		5K7-45	1000287
45n	1/8" Acetylene (Non-Load)		5K7-26	1000273
45o	11 Ga. Acetylene (Non-Load)		5K7-36	1000281
45p	15 Ga. Acetylene (Non-Load)		5K7-30	1000276
45q	3/16" Propane (Non-Load)		5K7-46	1000288
45r	1/8" Propane (Non-Load)		5K7-27	1000274
45s	11 Ga. Propane (Non-Load)		5K7-38	1000283
45t	15 Ga. Propane (Non-Load)		5K7-32	1000278
45u	3/16" MPS (Non-Load)		5K7-47	1000289
45v	1/8" MPS (Non-Load)		5K7-28	1031126
45w	11 Ga. MPS (Non-Load)		5K7-40	1031128
45x	15 Ga. MPS (Non-Load)		5K7-34	1031127
45y	11 Ga. Sprabond		5K7-41	1000284

2.3.4 Air Cap Body, Nozzle Nut, Front Wire Guides

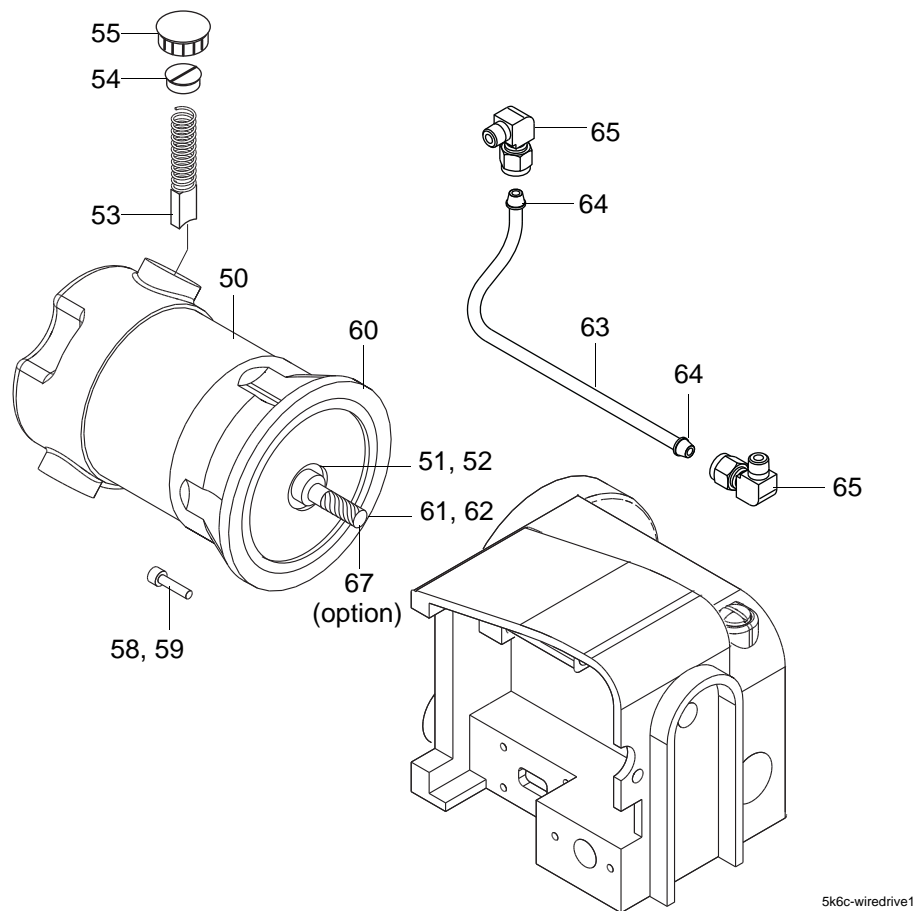


Pos.	Designation	Qty	Old Art. no.	Art. no.
43	Air cap body	1	5K701	1000134
44	Nozzle nut	1	5K606	1000270
Front wire guides				
Standard with 5K / 5K-6C				
46a	Front wire guide 3/16" - 1/8"	1	5K632	1001121
Optional				
46b	Front wire guide 1/8" - 11 Ga.		5K633	1001122
46c	Front wire guide 15 Ga.		5K634	1001123

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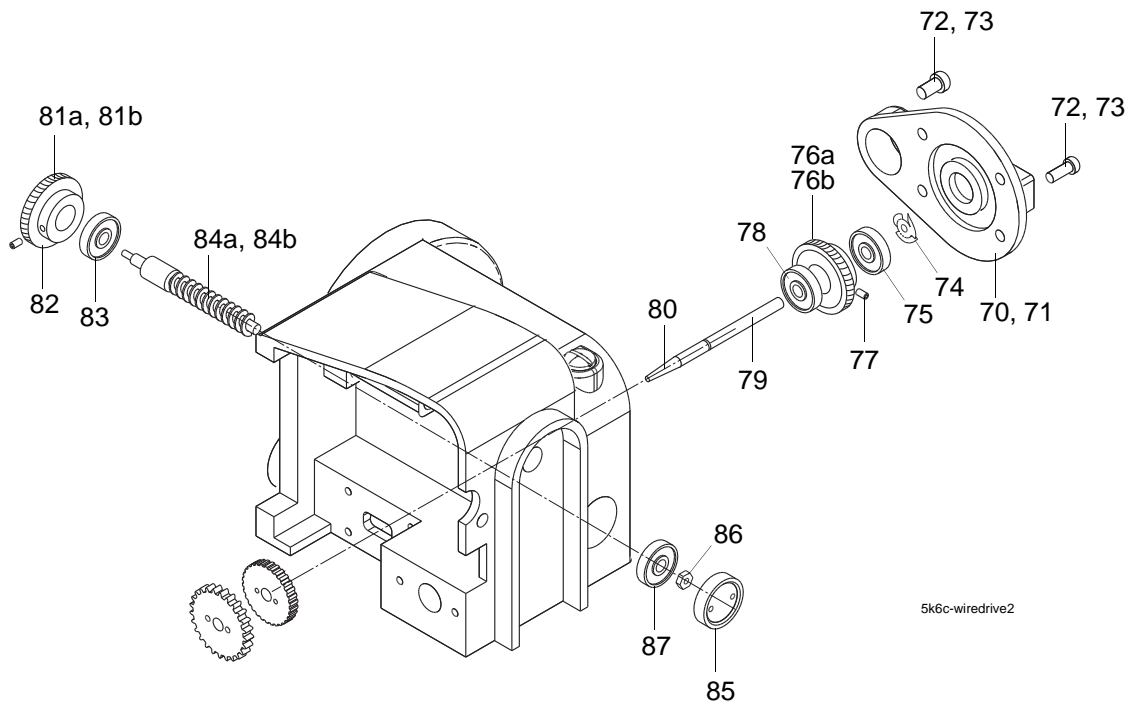
2.4 Wire Drive Unit



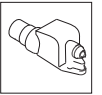
5k6c-wiredrive1

Pos.	Designation	Qty	Old Art. no.	Art. no.
50	Motor assembly	1	5K800	1001127
51	Motor oil seal	1	5K90	1000675
52	O-ring oil seal (pkg of 3)	1	5K121	1001202
53	Motor brush (pkg of 2)	2	5K840	1002363
54	Motor brush cap (pkg of 2)	2	5K880	1002365
55	Brush cap protector (pkg of 4)	2	5K257	1002364
56	Valve cover (not shown)	1	5K249	1000652
57	Cable plug (not shown)	1	5K601	1001120
58	Motor mounting screw (pkg of 5)	4	5K132	1000860
59	Lockwasher (pkg of 5)	4	5K18	1005746
60	Motor flange gasket	1	5K136	1000632
61	Gear set screw	1	5K72	1000850
62	Motor shaft gear	1	5K142	1000635
63	Motor air tube (includes pos. 64)	1	5K799	1001126
64	Ferrule	2	4RG288	1000984
65	Tube Elbow, 1/4 X 1/8 NPTM	2	3K248	1000651
66	Motor air tube fitting (not shown)	1	5K248	1000651
67	Motor shaft gear high speed (option)	1	5K163	1000641

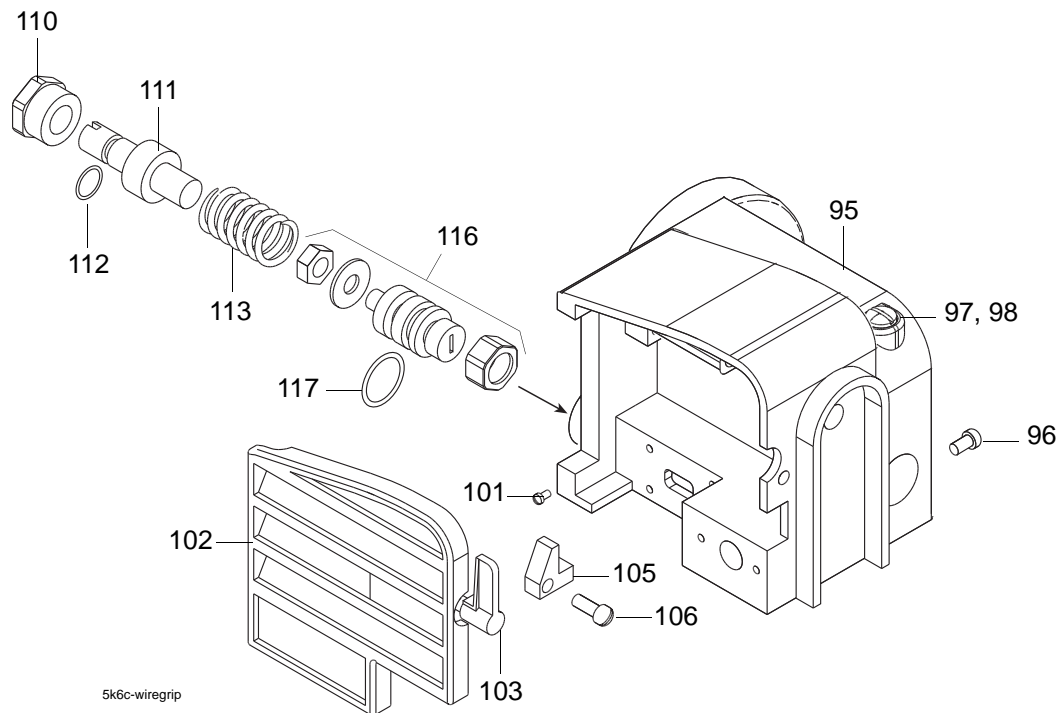
2.5 Wire Drive Unit Gear



Pos.	Designation	Qty	Old Art. no.	Art. no.
70	Gear cover	1	5K209	1000645
71	Gear cover gasket	1	5K61	1002417
72	Cover screw (pkg of 5)	4	5K60	1002416
73	Cover screw washer (pkg of 5)	4	5K26	1001997
74	Finger spring	1	5K85	1002422
75	Left drive shaft bearing	1	5K83	1002421
76a	Drive shaft worm gear	1	5K82-H	1002419
76b	Drive shaft worm gear - low speed	1	5K82-S	1002420
77	Set screw (pkg of 2)	1	5K41	1000837
78	Right drive shaft bearing	1	5K84	1002423
79	Drive shaft	1	5K81	1002017
80	Drive shaft inserting pin	1	5K115	1001979
81a	Countershaft gear	1	5K143	1000636
81b	Countershaft gear - high speed	1	5K87	1002020
82	Countershaft gear set screw (pkg of 5)	1	5K45	1002007
83	Rear countershaft bearing	1	5K88	1002021
84a	Countershaft	1	5K86-H	1002018
84b	Countershaft - low speed	1	5K86-S	1002019
85	Countershaft front bearing retainer	1	5K57	1002415
86	Countershaft bearing nut (pkg of 5)	1	5K75	1000858
87	Front countershaft bearing	1	5K89	1000857
88	Drive shaft seal (not shown)	1	5K155	1001981

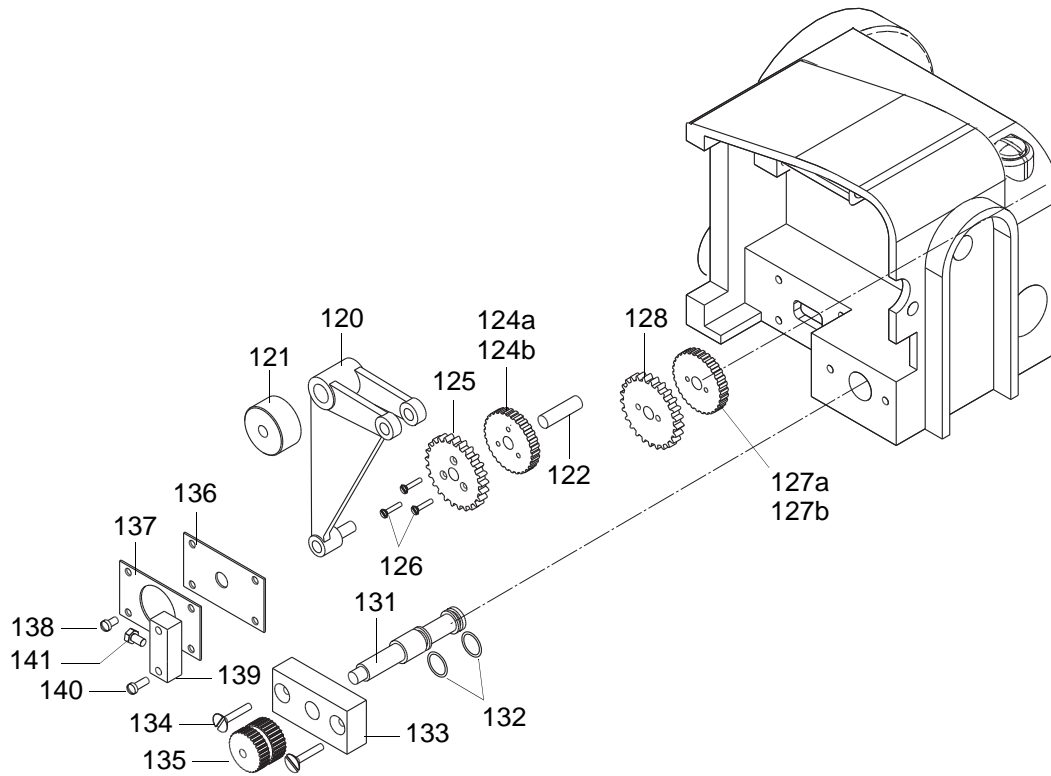


2.6 Main Housing and Wire Grip Control



Pos.	Designation	Qty	Old Art. no.	Art. no.	
95	Main housing	1	5K220	1001111	
96	Seal screw	1	5K55	1031881	
97	Oil filler plug	1	5K50	1000177	
98	Oil filler washer	1	5K149	1000840	
99	Oil level sight plug (not shown)	1	5K148	1001980	
100	O-ring Oil level sight plug (pkg of 3) (not shown)	1	5K46	1002923	
101	Screw (pkg of 5)	1	5K34	1000830	
102	Door	1	5K161	1000639	
103	Door latch	1	5K145	1000637	
104	Door latch bushing (not shown)	1	5K162	1000640	
105	Striker plate	1	5K147	1004942	
106	Striker plate screw	1	5K192	1006432	
107	Hinge pin (not shown)	1	5K197	1001996	
108	Button spring (not shown)	1	5K37	1002147	
109	Door button (pkg of 2) (not shown)	1	5K196	1001995	
110	Dust seal housing	1	5K146	1000638	
111	Spring cap	1	5K171	1000643	
112	O-ring Dust seal (pkg of 3)	1	5K79	1000856	
113	Compression spring	1	5K177	1001986	
116	Piston assembly	1	5K175	1001984	<i>includes pos. 117</i>
117	O-ring Piston (pkg of 3)	1	5K176	1001985	

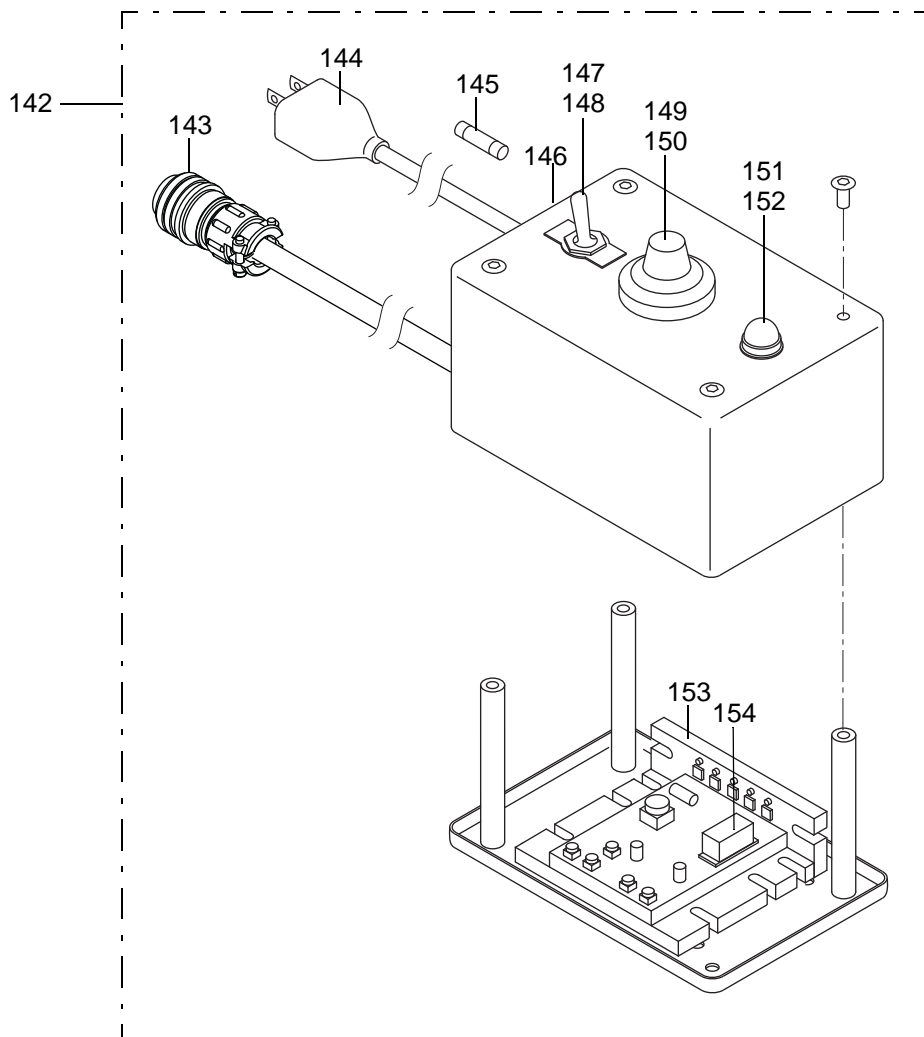
2.7 Wire Grip



Pos.	Designation	Qty	Old Art. no.	Art. no.
120	Upper drive roll carrier	1	5K181	1001988
121	Upper drive roll carrier nut	1	5K182	1001989
122	Drive roll axle	1	5K31	1000828
123	Axle set screw (pkg of 5) (not shown)	1	5K30	1000827
124a	Upper drive roll - 3/16 - 1/8	1	5K32	1001998
124b	Upper drive roll - small gauge	1	5K32-11	1001999
125	Upper drive gear	1	5K33	1002003
126	Screw (pkg of 5)	3	5K34	1000830
127a	Lower drive roll	1	5K35	1002004
127b	Lower drive roll - small gauge	1	5K35-11	1002005
128	Lower drive gear	1	5K36	1002006
129a	Rear wire guide (not shown)	1	5K49	1002009
129b	Rear wire guide - small gauge (not shown)	1	5K49-15	1002010
130	Rear wire guide set screw (pkg of 2) (not shown)	1	5K168	1000642
131	Valve stem	1	5K185	1001990
132	Valve stem O-ring (pkg of 5)	2	5K79	1000856
133	Stop plate	1	5K186	1028633
134	Stop plate screw (pkg of 2)	2	5K187	1001991
135	Valve stem knob	1	5K188	1001992
136	Piston seal	1	5K190	1001994
137	Piston seal retainer	1	5K189	1001993
138	Retainer screw (pkg of 5)	2	5K191	1002155
139	Adjusting screw block	1	5K95	1000677
140	Screw (pkg of 4)	2	5K96	1000678
141	Drive roll travel adjusting screw	1	5K94	1000676



2.8 Speed Control Power Supply (5K Only)



5k_ps

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Pos.	Designation		Qty	Old Art. no.	Art. no.
142	Power Supply	<i>(includes pos. 143–154)</i>	1	5K900	1001128
143	Receptacle Connector		1	5K501	1001113
144	Electrical Cord 12FT (9MC)		1	3K431	1000670
145	Fuse 3A 125V Slo-Blow	<i>(pkg. 5)</i>	1	3K451	1000671
146	Fuse Holder (not shown)		1	C505	1001781
147	Toggle Switch		1	RG118	1028975
148	Toggle Switch Boot		1	RG19	1006091
149	Operator Dial		1	9MC202	1005520
150	Potentiometer, 10 Turn, 5000 Ohms		1	6C101	1001293
151	Light Pilot (red)		1	7MC53	1006229
152	Neon Bulb	<i>(pkg. 3)</i>	1	KR414	1002022
153	DC Motor Speed Control		1	6C154	1001297
154	Resistor, 0.035 Ohm		1	6C153	1032108

2.9 Tools and Lubricants

Designation	Qty.	Old Art. no.	Art. no.
Eye protectors	1	5K293	1000097
Hearing protectors	6	5K294	1002071
Safety package (includes eye and hearing protectors)	1	5K297	1015366
Replacement lens - shade 5	1	5K295	1000098
Replacement cover plate - plastic	1	5K296	1000099
Socket wrench	1	5K100	1005027
Lighter	1	5K101	1000813
Lighter flints (pkg of 12)	1	5K183	1000823
Allen wrench #6	1	5K112	1005905
Allen wrench #8	1	5K102	1005028
Drive roll wrench	1	5K104	1001977
Screw driver	1	5K105	1000814
Adjustable wrench	1	5K106	1000815
Gearlube	1	5K110	1001107
Krytox®	1	16E97041	1070061
Cleaning wire kit	1	5K114	1000817
Drive shaft inserting pin	1	5K115	1001979
Lighting stop plunger wrench	1	5K230	1031641
Tool post mounting	1		
Tool post bar	1	5K243	1000648
Tool post bracket	1	5K244	1000649
Clamp screw	1	5K247	1000650
Clamp screw washer (pkg of 2)	1	5K70	1002418

2.10 Hose and Cable Assemblies (Supplied Separately)

Designation	Qty.	Old Art. no.	Art. no.
Standard hose package (5 m / 15') 5K to 3AF / 3GF <i>includes</i>		6H	1001317
Twin hose: Acetylene/Propane (red) and Oxygen (green)	1	6H40	1001318
Air (black)	1	6H50	1001319
Standard hose package (10 m / 35') 5K-6C to 3AF / 3GF <i>includes</i>		10H	1033680
Twin hose: Acetylene/Propane (red) and Oxygen (green)	1	10H40	1030524
Air (black)	1	7H50	1001451
Optional hose package (10 m / 35') 5K to 3AF / 3GF <i>includes</i>		7H	1033681
Twin hose: Acetylene/Propane (red) and Oxygen (green)	1	7H40	1032254
Air (black)	1	7H50	1001451
Extension Cable, 4.6 m (15'; power supply to motor) <i>includes</i>		5K502	1001114
Receptacle	1	5K501	1001113
Plug	1	5K601	1001120
Extension Cable, 4.6 m (15'; 6C to gun motor) <i>includes</i>		5K525	1005207
Receptacle	1	5K501	1001113
Connector	1	5K238	1001782
Connector boot	1	5K443	1006088
Extension Cable, 10.7 m (35'; power supply to motor) <i>includes</i>		5K503	1005206
Receptacle	1	5K501	1001113
Plug	1	5K601	1001120