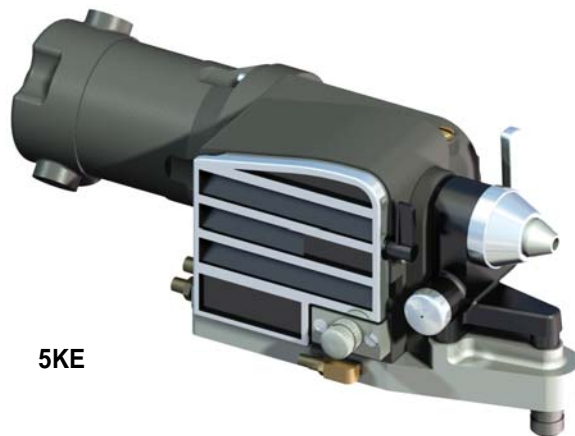
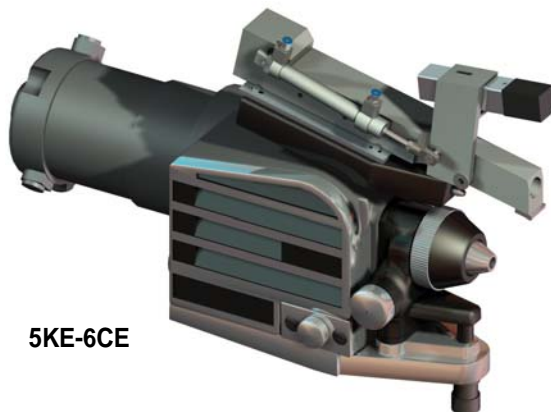


5KE / 5KE-6CE Flame Spray Machine Combustion Wire Spraying

Parts List
PL 79164 EN 05



5KE





5KE-6CE

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

Parts Depending on Parameters

Designation	Qty.	Cat	Old Art. no.	Art. no.
Air cap	1	C	See page 6	
Siphon plug assembly	1	C	See page 7	
Nozzle	1	C	See page 8	
Front wire guide	1	C	See page 10	
Upper drive roll	1	C	See page 14	
Lower drive roll	1	C	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	C	5K14	1000143
22	O-ring valve core	(pkg of 4)	1	C	5K14	1000143
40	Siphon plug O-ring	(pkg of 4)	4	C	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

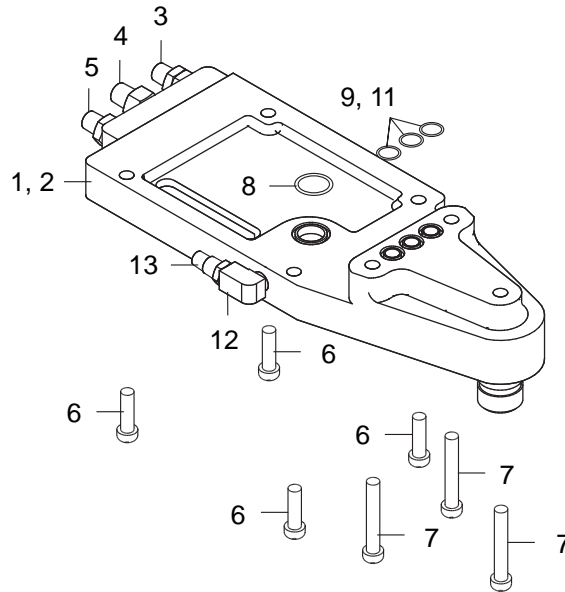
Tools and Miscellaneous

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

2 Parts List

5KE Spray Gun	5KE	1001132
5KE-6CE Spray Gun	5KE-6CE	1001133

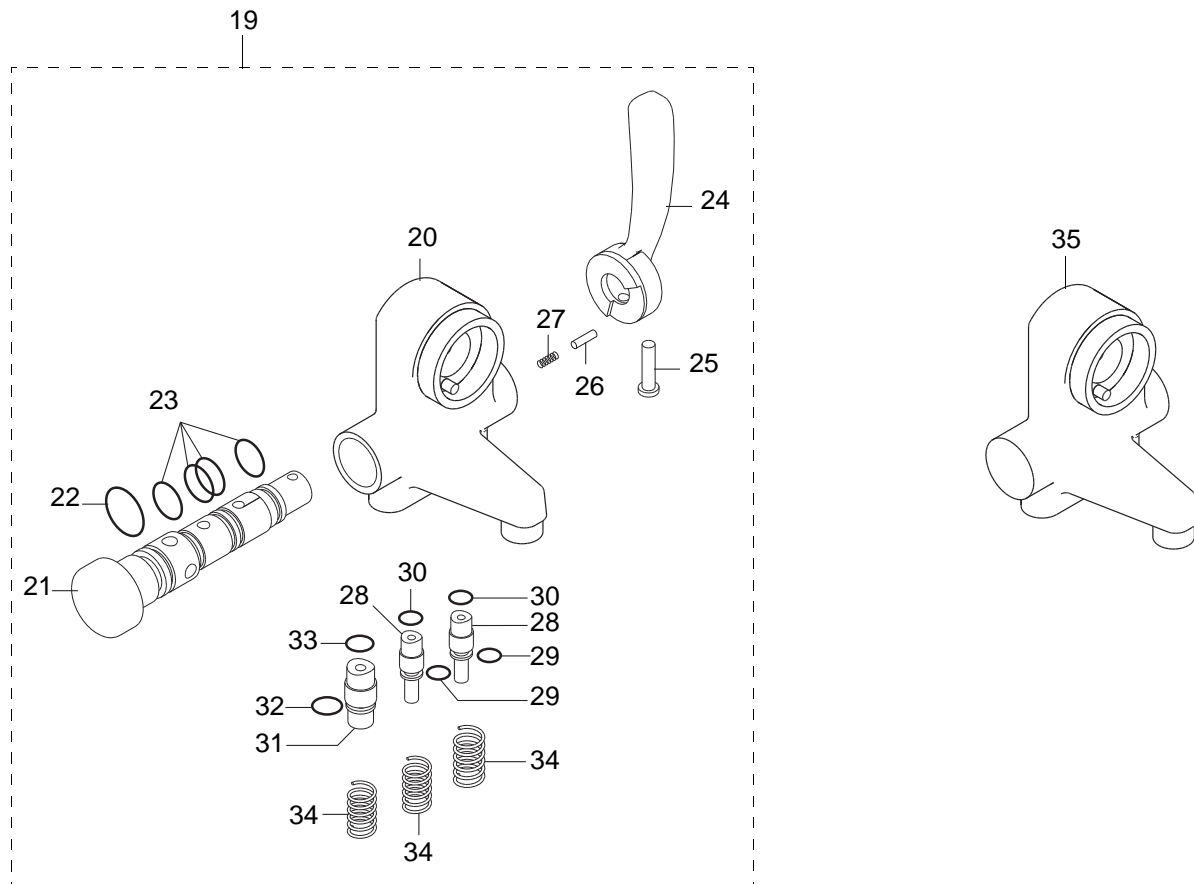
2.1 Base Assembly



Pos.	Designation		Qty.	Old Art. no.	Art. no.
1	Base assembly 5KE	<i>includes Pos. 3, 4, 5</i>	1	5K1040	1041321
2	Base assembly 5KE-6CE	<i>includes Pos. 3-5, 12, 13</i>	1	5K940	1005209
3	Fuel hose fitting adapter		1	5K48182	1035402
4	Oxygen hose fitting adapter		1	5K48181	1035401
5	Air hose connection		1	5K23	1000824
6	Main housing mounting screw	(pkg of 6)	4	5K133	1000631
7	Gas head mounting screw	(pkg of 3)	3	5K141	1000634
8	O-ring main housing air seal	(pkg of 4)	1	5K14	1000143
Only 5KE					
9	O-ring base gas head seal	(pkg of 4)	3	5K195	1001787
10	Stop screw valve core	(not illustrated)	1	5K318	1000661
Only 5KE-6CE					
11	O-ring base and gas head seal	(pkg of 3)	3	5K137	1006359
12	Elbow		1	5K169	1005203
13	Hose connection		1	5K22	1000826



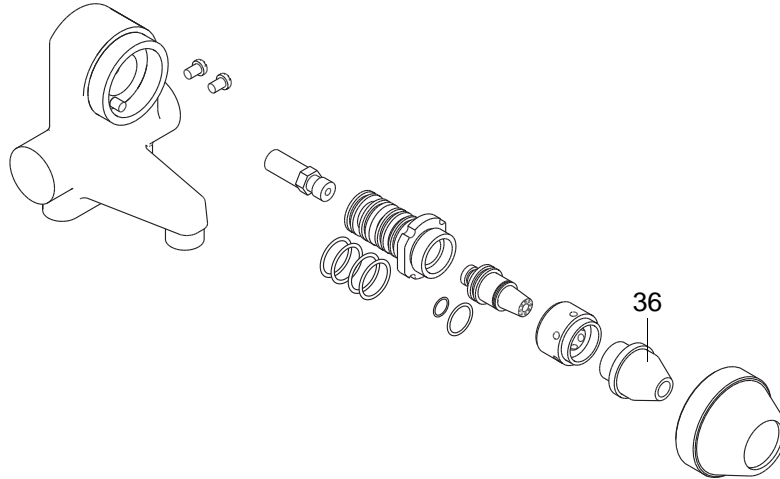
2.2 Gas Head



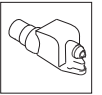
Pos.	Designation		Qty.	Old Art. no.	Art. no.
19	Gas head assembly for 5KE	<i>includes Pos. 20-34</i>	1	5K505	1001115
20	Gas head subassembly		1	5K515	1001119
21	Valve core		1	5K511	1001117
22	O-ring valve core	(pkg of 4)	1	5K14	1000143
23	O-ring valve core	(pkg of 4)	4	5K195	1001787
24	Valve handle		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	5K319	1002915
30	Seal O-ring fuel gas and oxygen plunger	(pkg of 2)	2	5K306	1002919
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	1002918
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 5KE-6CE Spray Gun		1	5K505A	1001116

2.3 Siphon Plug and Related Parts

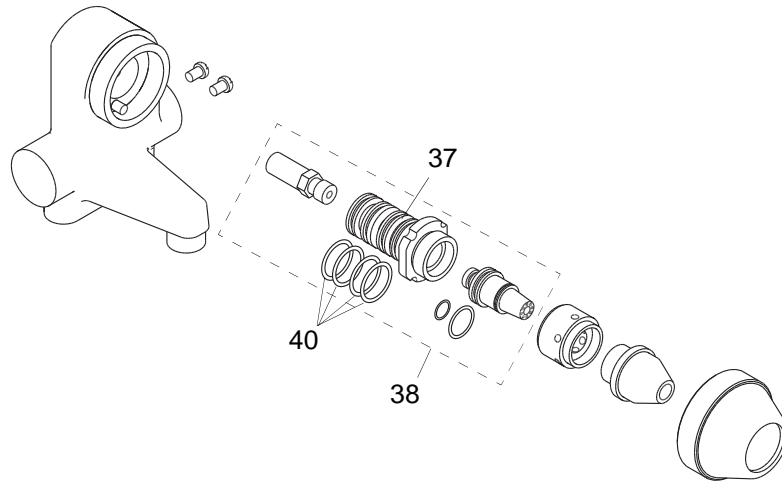
2.3.1 Air Caps



Pos.	Designation		Old Art. no.	Art. no.
Air Caps "Standard"				
Standard with 5KE / 5KE-6CE				
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
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

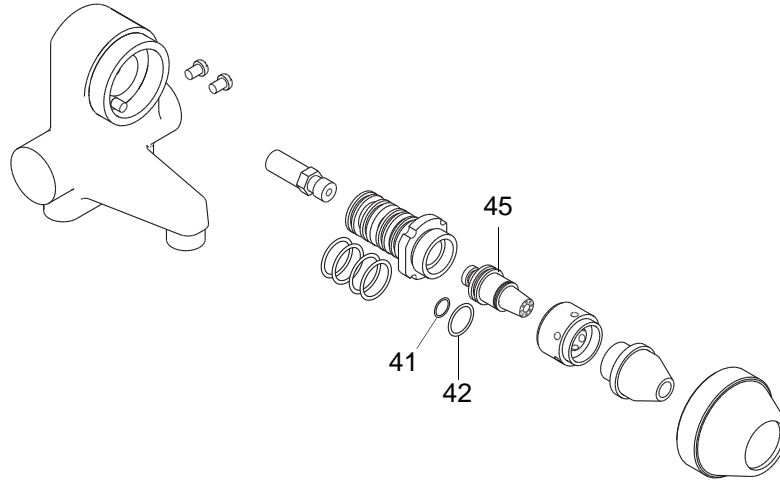
Standard with 5KE / 5KE-6CE

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			5K606	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			5K606	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

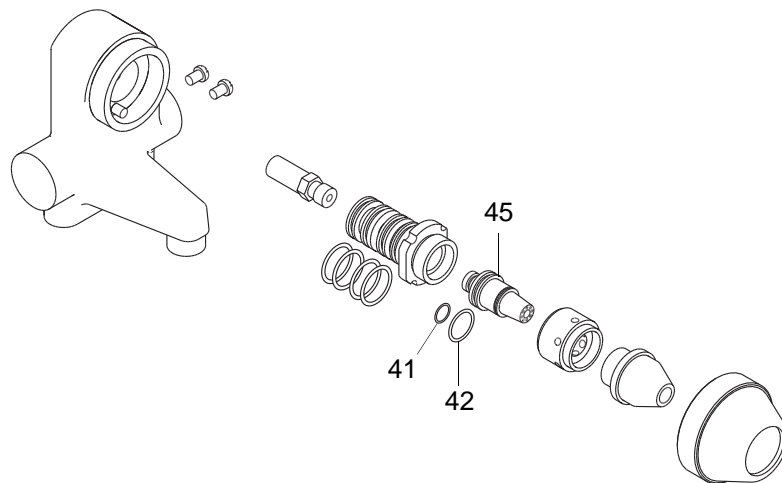
Standard with 5KE / 5KE-6CE

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

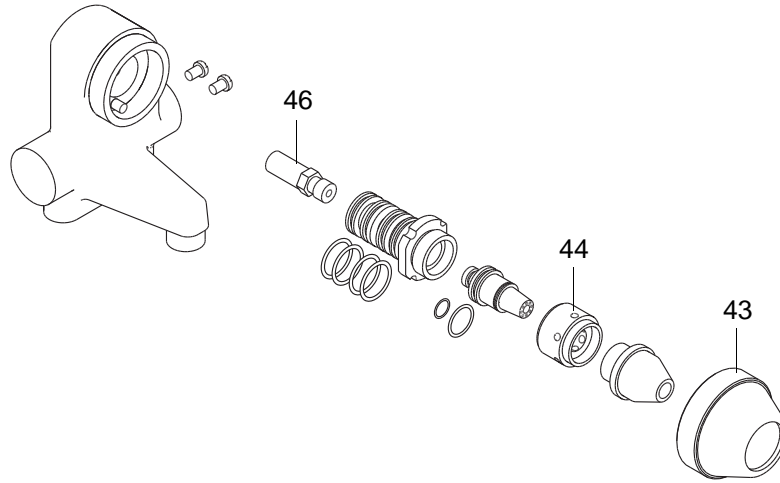


Pos.	Designation		Qty.	Old Art. no.	Art. no.
41	O-ring	(pkg of 2)	1	5K509	1004714
42	O-ring	(pkg of 2)	1	5K508	1000138
--	Reseal kit (O-rings siphon plug, nozzle) <i>includes Pos. 40, 41, 42</i>		1	5K590	1000152

Nozzles (optional)

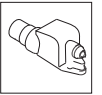
45m	3/16"	Acetylene (non-load)		5K7-45	1000287
45n	1/8"	Acetylene (non-load)		5K7-26	1000273
45o	11 Ga.	Acetylene (non-load)		5K7-36	1000281
45p	15 Ga.	Acetylene (non-load)		5K7-30	1000276
45q	3/16"	Propane (non-load)		5K7-46	1000288
45r	1/8"	Propane (non-load)		5K7-27	1000274
45s	11 Ga.	Propane (non-load)		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

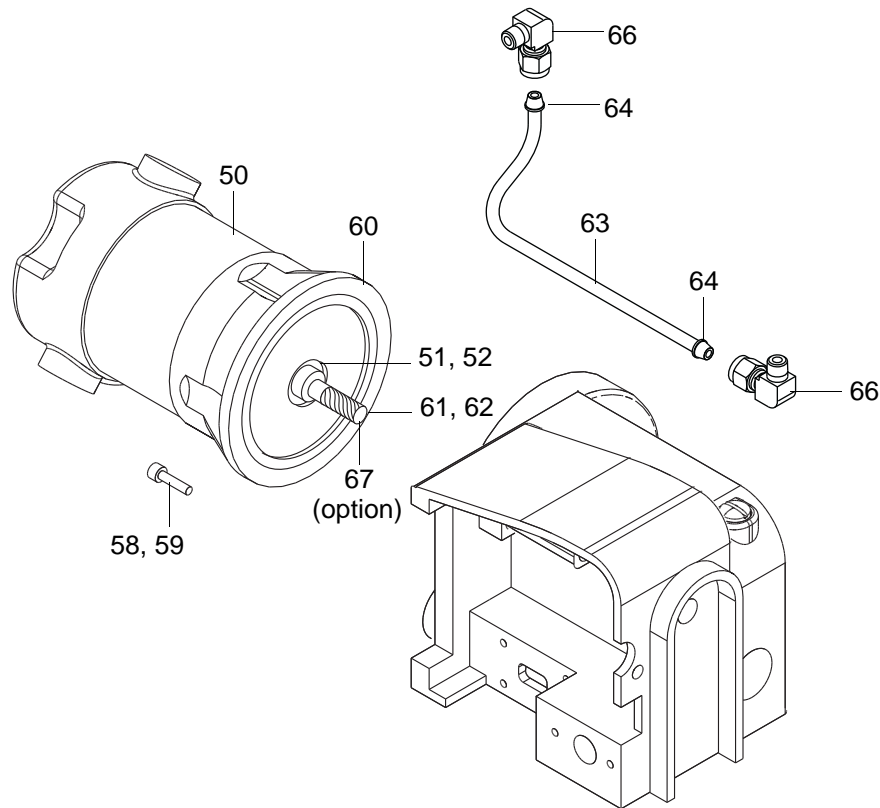


Pos.	Designation	Qty.	Old Art. no.	Art. no.
43	Air cap body	1	5K701	1000134
44	Nozzle nut	1	5K606	1000270
Front wire guides				
Standard with 5KE / 5KE-6CE				
46a	Front wire guide 3/16" - 1/8"	1	5K632	1001121
Optional				
46b	Front wire guide 1/8" - 11 Ga.		5K633	1001122
46c	Front wire guide 15 Ga.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

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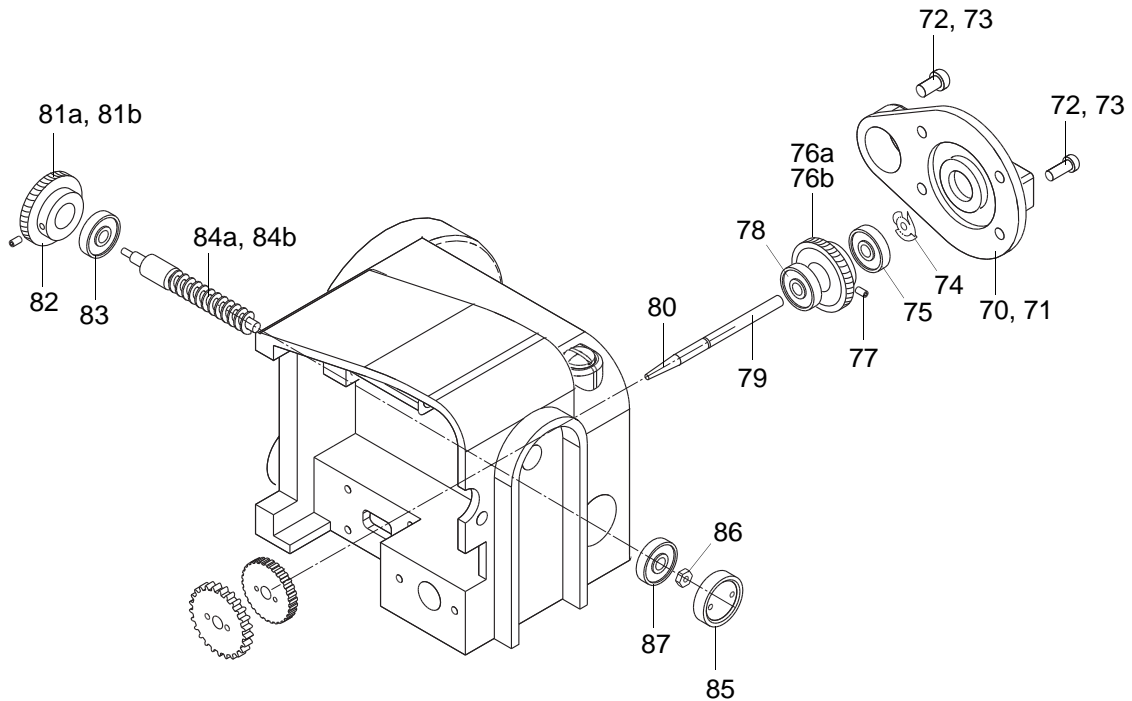


2.4 Wire Drive Unit

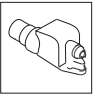


Pos.	Designation	Qty.	Old Art. no.	Art. no.
50	Motor assembly	1	5K1000	1001106
51	Motor oil seal	1	5K90	1000675
52	O-ring oil seal	(pkg of 3)	5K121	1001202
53	Motor brush	(pkg of 2) (not illustrated)	5K840	1002363
54	Motor brush cap	(pkg of 2) (not illustrated)	5K880	1002365
55	Brush cap protector	(pkg of 4) (not illustrated)	5K257	1002364
58	Motor mounting screw	(pkg of 5)	5K132	1000860
59	Lockwasher	(pkg of 5)	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)	5K799	1001126
64	Ferrule	2	4RG288	1000984
66	Tube Elbow, 1/4 X 1/8 NPTM	2	3K248	1000651
67	Motor shaft gear high speed (option)	1	5K163	1000641

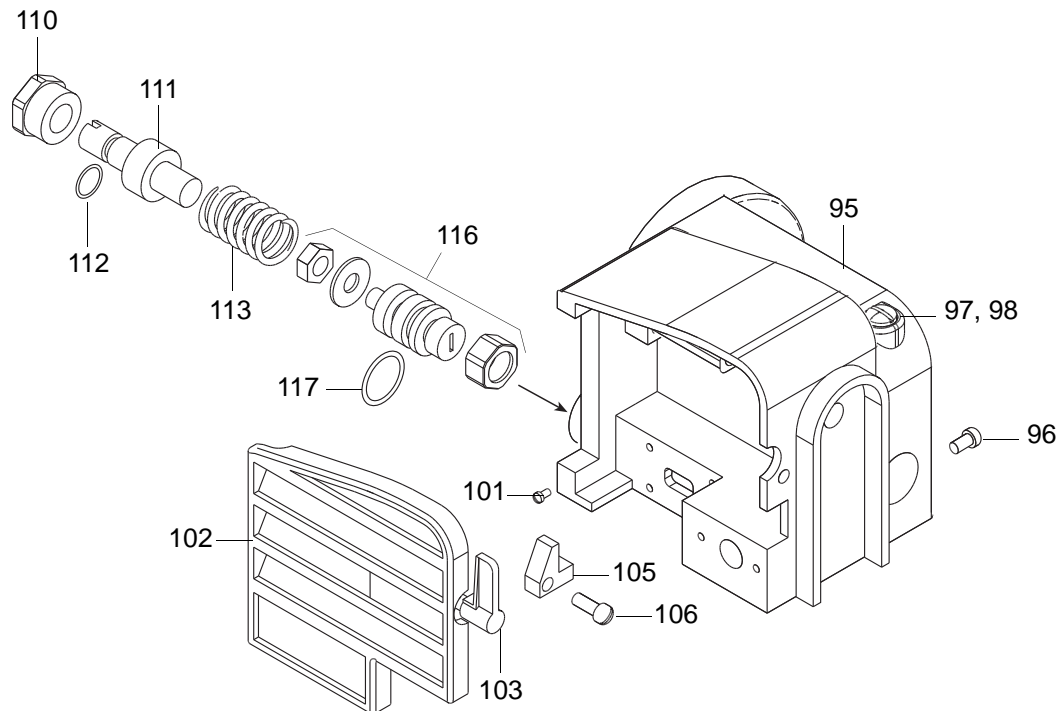
2.5 Wire Drive Unit Gear



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)	5K60	1002416
73	Cover screw washer	(pkg of 5)	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)	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
81a	Countershaft gear - high speed	1	5K87	1002020
82	Countershaft gear set screw	(pkg of 5)	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)	5K75	1000858
87	Front countershaft bearing	1	5K89	1000857
88	Drive shaft seal	(not illustrated)	5K155	1001981
89	Mounting screw wire drive unit	(pkg of 6) (not illustrated)	5K133	1000631

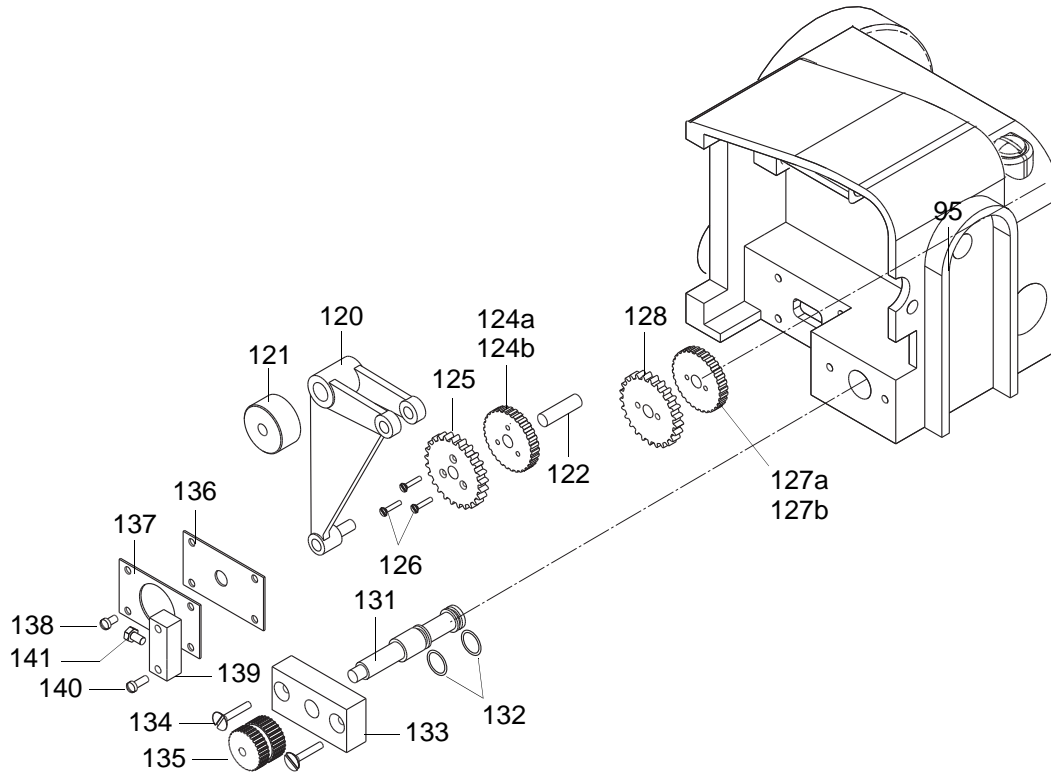


2.6 Main Housing and Wire Grip Control



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 illustrated)	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 illustrated)	1	5K162	1000640
105	Striker plate		1	5K147	1004942
106	Striker plate screw		1	5K192	1006432
107	Hinge pin	(not illustrated)	1	5K197	1001996
108	Button spring	(not illustrated)	1	5K37	1002147
109	Door button	(pkg of 2) (not illustrated)	1	5K196	1001995
110	Dust seal housing		1	5K146	1000638
111	Spring cap		1	5K171	1000643
112	O-ring Dust seal	(pkg of 5)	1	5K79	1000856
113	Compression spring		1	5K177	1001986
116	Piston assembly	<i>includes Pos. 117</i>	1	5K175	1001984
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 illustrated)	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)	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 illustrated)	5K49	1002009
129b	Rear wire guide - small gauge	(not illustrated)	5K49-15	1002010
130	Rear wire guide set screw	(pkg of 2) (not illustrated)	5K168	1000642
131	Valve stem	1	5K185	1001990
132	Valve stem O-ring	(pkg of 5)	5K79	1000856
133	Stop plate	1	5K186	1028633
134	Stop plate screw	(pkg of 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)	5K191	1002155
139	Adjusting screw block	1	5K95	1000677
140	Screw	(pkg of 4)	5K96	1000678
141	Drive roll travel adjusting screw	1	5K94	1000676



2.8 Tools and Lubricants

Designation	Old Art. no.	Art. no.
Gun case	5K270	--
Eye protectors	5K293	1000097
Hearing protectors	5K294	1002071
Safety package (includes eye and hearing protectors)	5K297	1015366
Replacement lens - shade 5	5K295	1000098
Replacement cover plate - plastic	5K296	1000099
Socket wrench	5K100	1005027
Lighter	5K101	1000813
Lighter flints (pkg of 12)	5K183	1000823
Allen wrench #6	5K112	1005905
Allen wrench #8	5K102	1005028
Drive roll wrench	5K104	1001977
Screw driver	5K105	1000814
Adjustable wrench	5K106	1000815
Gear oil	5K110	1001107
Krytox® lubricant	16E97041	1070061
Cleaning wire kit	5K114	1000817
Drive shaft inserting pin	5K115	1001979
Lighting stop plunger wrench	5K230	1031641
<i>Tool post mounting includes:</i>		
Tool post bar	5K243	1000648
Tool post bracket	5K244	1000649
Clamp screw	5K247	1000650
Clamp screw washer (pkg of 2)	5K70	1002418

2.9 Hose and Cable Assemblies

Designation	Old Art. no.	Art. no.
Standard hose package (10 m / 35') 5KE-6CE to 3AF / 3GF <i>includes:</i>	10HEX	1000101
Oxygen hose (blue)	10HEX51570	1036302
Acetylene hose (red)	10HEX51752	1034565
Propane hose (orange)	10HEX51293	1036303
Air (black)	7H50	1001451

2.10 Optional Equipment

Designation		Old Art. no.	Art. no.
Wire meter and door assembly	<i>includes:</i>	5K211	1031638
Door		5K144	1031635
Counter		5K251	1005916
Counter screw	(pkg of 5)	5K92	1005041
Spur gear assembly		5K253	1028635
Spur gear set screw		5K72	1000850
Pinion assembly		5K254	1005917
Pinion shaft		5K255	1005918
Pinion shaft retaining ring	(pkg of 5)	5K256	1005919