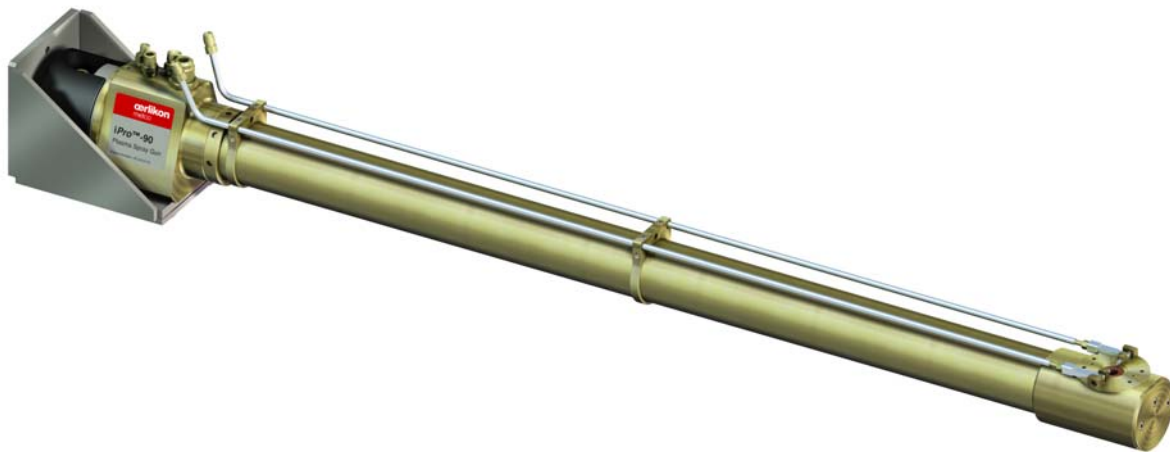


# iPro™-90 Plasma Extension Gun Plasma Spraying


Parts List  
PL 79631 EN 04




## 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**

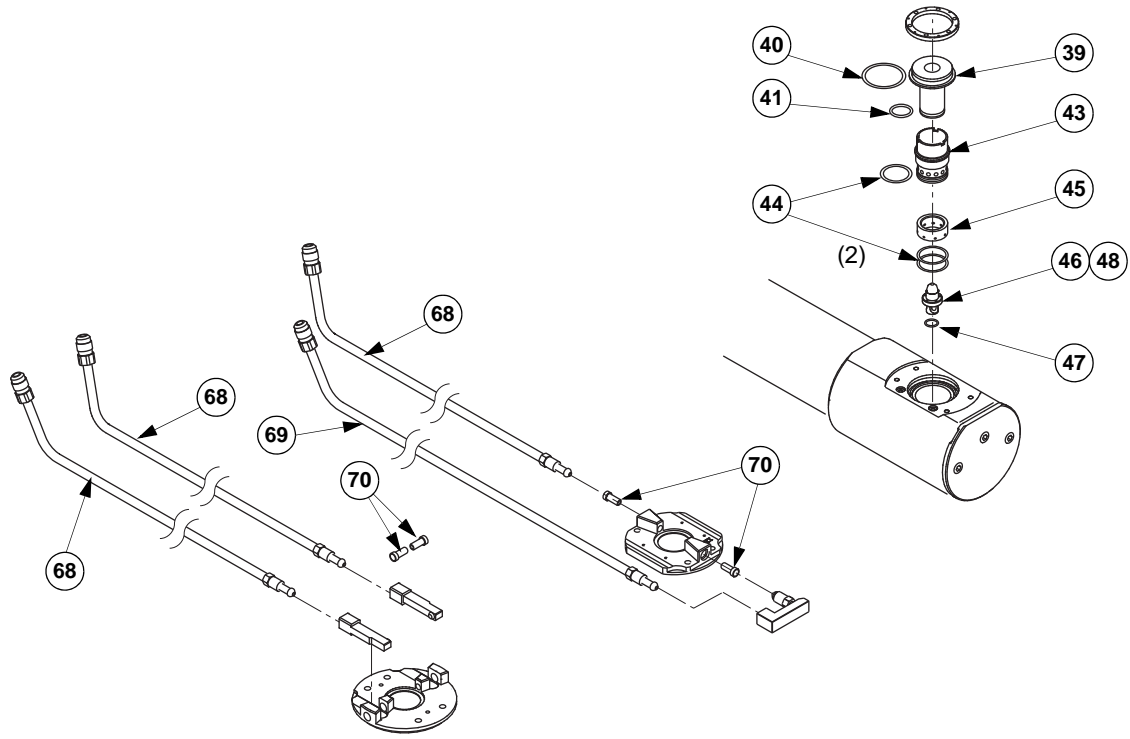
Parts recommended in order to guarantee maximum availability of component. This prevents downtime caused by delay in procurement.



## Warranty Disclaimer

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

# 1 List of Recommended Spare Parts for iPro-90



iPro-90\_spares

Item No.	Description	Qty.	Cat.	Order No.
39	Nozzle 9mm (includes items 40 & 41)	1	C	1061089
40	O-ring, 1.051 x 0.070 Black Viton	1	W	1000729
41	O-ring, 0.551 x 0.070 Black Viton (pkg. 4)	1	W	1020266
43	Baffle Cartridge	1	K	1062540
44	O-ring, 0.739 x 0.070 Black Viton	3	W	1000646
45	Gas Ring	1	W	1062291
46	Electrode (thorium-free) (includes item 47)	1	C	1083820
47	O-ring, 0.330 x 0.070 Black Viton	1	W	1031649
48	Electrode (includes item 47)	1	W	1061072
68	Powder Tube Assembly 37"	2	K	1062265
69	Powder Tube Assembly 40"	1	K	1062264
70	Powder Port #4	2	W	1000683
71	Powder Port #8	2	W	1063255
104	O-ring Kit Package	1	W	1062556

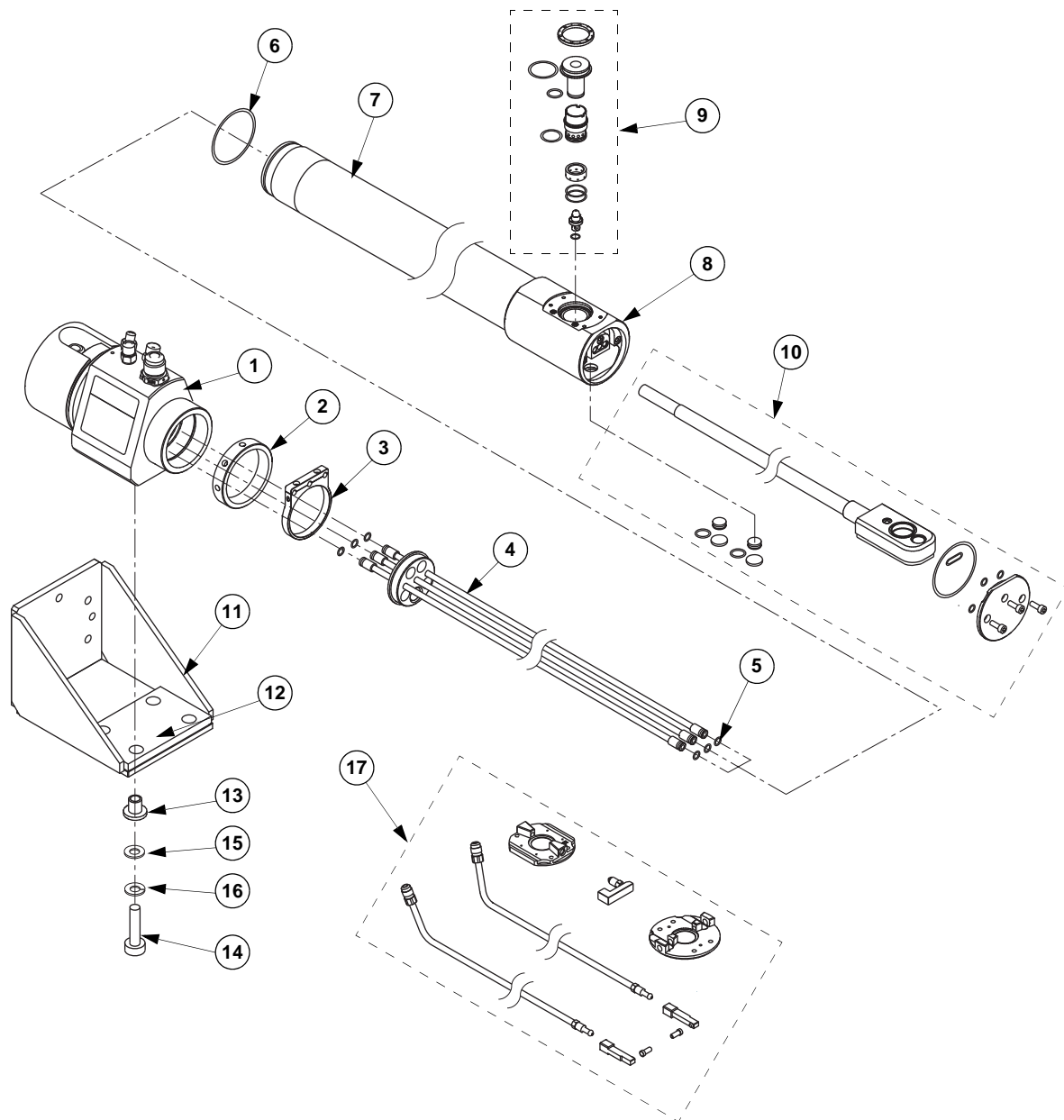
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## 2 Parts List

iPro™-90 Plasma Extension Gun

1062545

### 2.1 Complete Gun Assembly



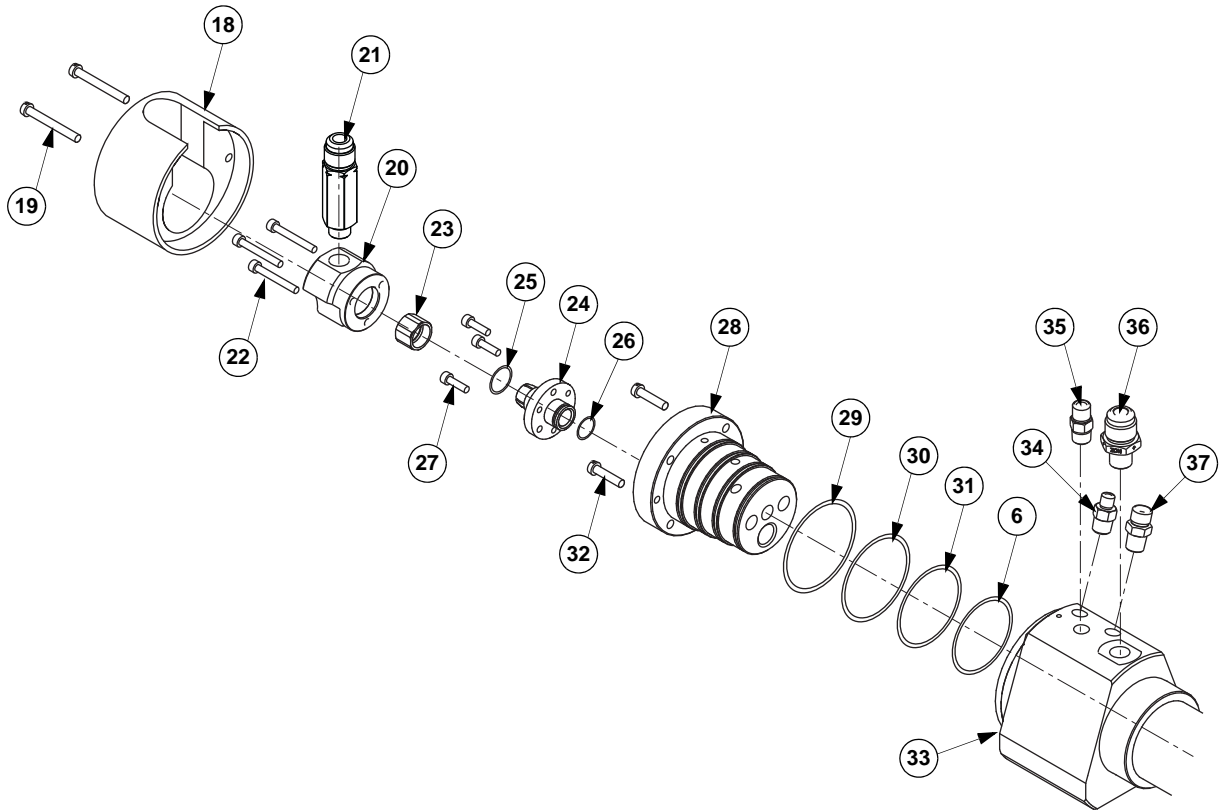
iPro-90\_overview

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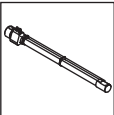
Item No.	Description	Qty.	Order No.
1	Manifold Housing Assembly	1	See page 6.
2	Tube Locking Ring	1	—
3	Tube Clamp Assembly	2	See page 9.
4	Tube & Spider Assembly (includes item 5)	1	1062531
5	O-ring, 0.239 x 0.070 Black Viton	6	1031639
6	O-ring, 2.239 x 0.070 Black Viton	1	1017900
7	Extension Tube and Front Gun Body Assembly (includes item 8)	1	1096726
8	Front Gun Body (Do not remove from item 7.)	1	—
9	Front Gun Body Assembly	1	See page 7.
10	Rear Gun Body Assembly	1	See page 8.
11	Robot Mounting Bracket (includes items 12-16)	1	1062183
12	Insulator Plate	1	1062191
13	Screw Insulator	4	1062192
14	Mounting Screw	4	1062193
15	Washer	4	1062194
16	Lock Washer	4	1062195
17	Powder Tubes, Holders and Injectors		See page 9.

## 2.2 Manifold Housing Assembly

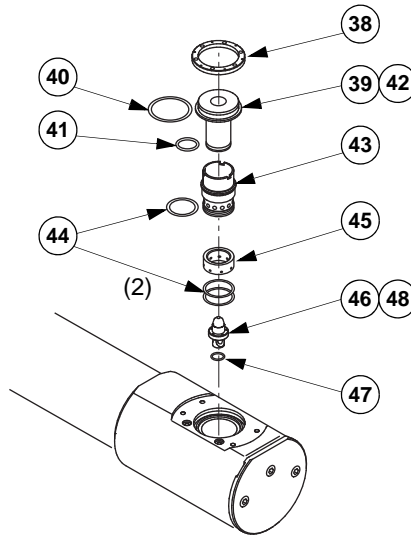


iPro-90\_manifold

Item No.	Description	Qty.	Order No.
6	O-ring, 2.239 x 0.070 Black Viton	1	1017900
18	Negative Conductor Cover	1	1062269
19	Screw	2	1062267
20	Negative Connector Block (includes item 21)	1	1062442
21	Negative Hose Fitting	1	—
22	Screw	3	1062268
23	Negative Nut	1	1062443
24	Negative Connector	1	1062445
25	O-ring, 0.801 x 0.070 Black Viton (pkg. 2)	1	1000549
26	O-ring, 0.614 x 0.070 Black Viton (pkg. 6)	1	1001462
27	Screw	3	1062444
28	Manifold Housing Insulator	1	1062528
29	O-ring, 2.614 X 0.070 Buna-N	1	1062551
30	O-ring, 2.489 x 0.070 Black Viton	1	1062548
31	O-ring, 2.364 x 0.070 Buna-N	1	1062547
32	Screw	4	1062527
33	Manifold Housing Assembly (includes items 34-37)	1	1062529
34	Hose Nipple, 3/8-24M x 1/4	1	—
35	Hose Adapter, 1/2-20M x 1/4	1	—
36	Water Fitting ( <b>NOZ+</b> )	1	1000103
37	Hose Fitting, 9/16-18 x 1/4	1	1000495



## 2.3 Front Gun Body Assembly

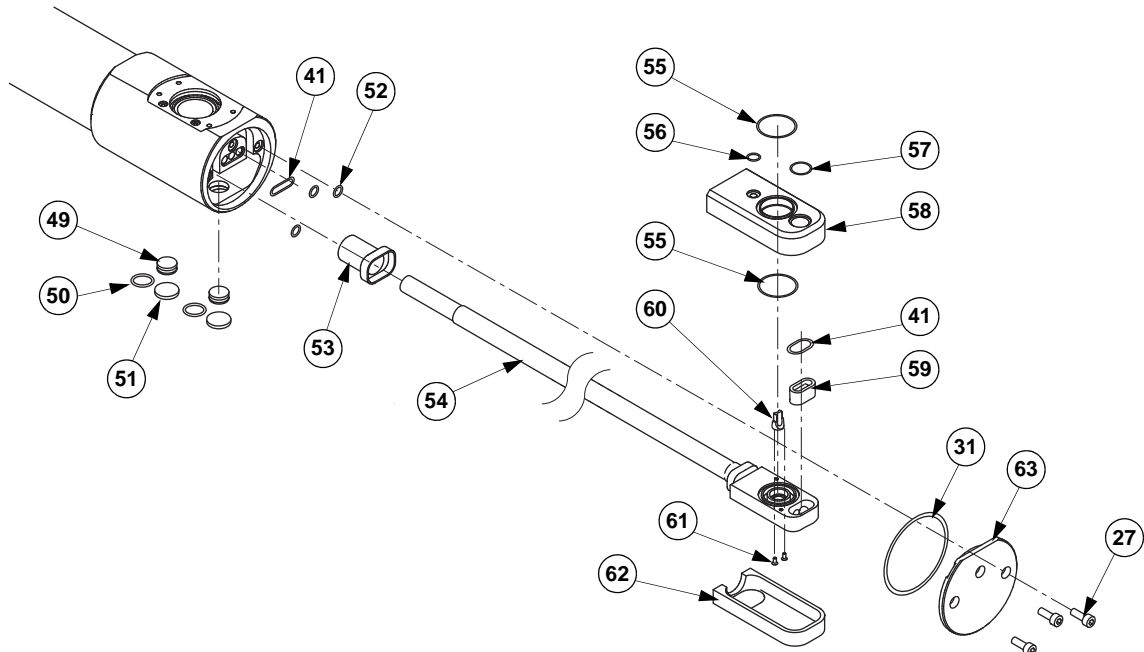


iPro-90\_front

Item No.	Description	Qty.	Order No.
38	Locking Ring	1	1062534
39	Nozzle 9mm (includes items 40 & 41)	1	1061089
40	O-ring, 1.051 x 0.070 Black Viton	1	1000729
41	O-ring, 0.551 x 0.070 Black Viton (pkg. 4)	1	1020266
42	Nozzle 7mm (optional) (includes items 40 & 41)	1	1075124
43	Baffle Cartridge	1	1062540
44	O-ring, 0.739 x 0.070 Black Viton (pkg. 2)	3	1000646
45	Gas Ring	1	1062291
46	Electrode (thorium-free) (includes item 47)	1	1083820
47	O-ring, 0.330 x 0.070 Black Viton	1	1031649
48	Electrode (includes item 47)	1	1061072

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## 2.4 Rear Gun Body Assembly

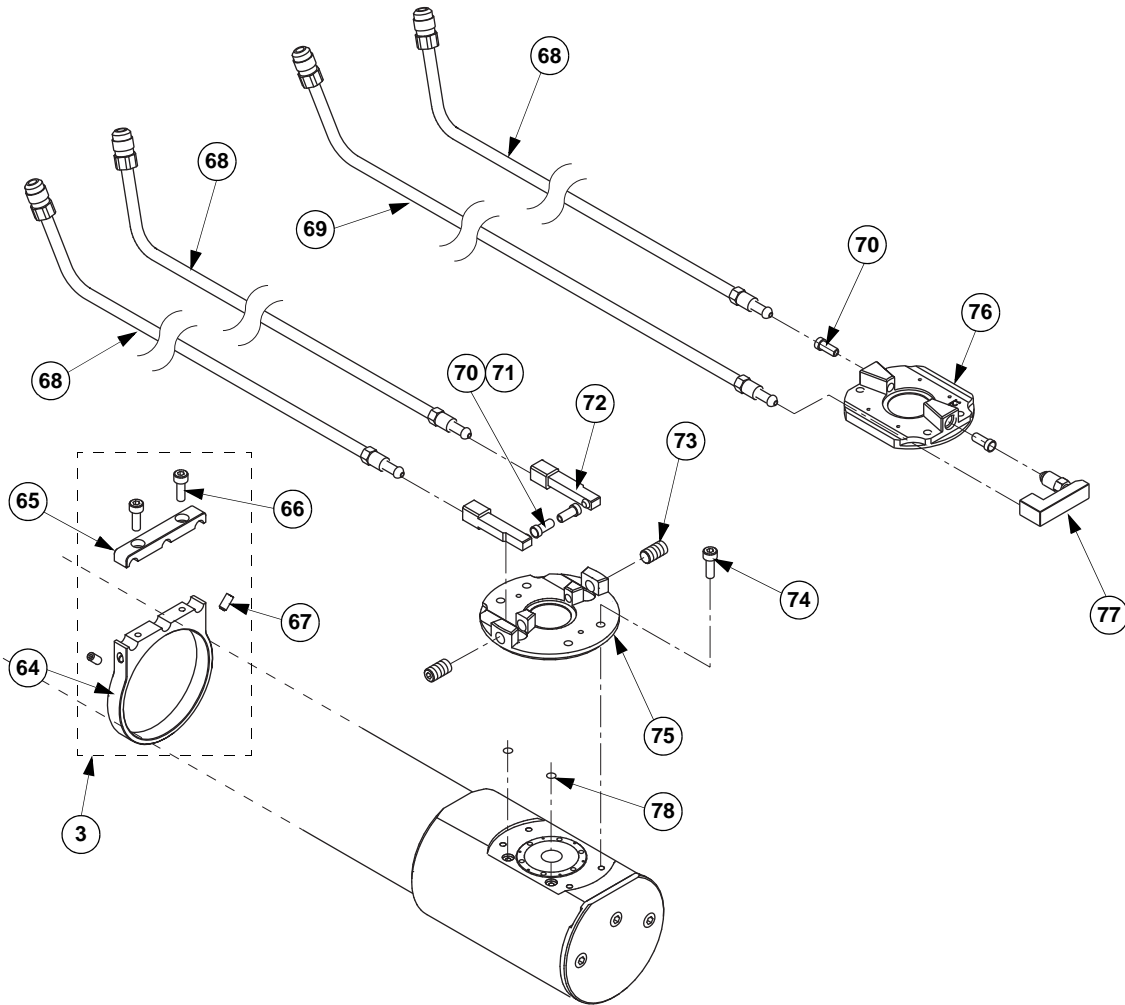


iPro-90\_rear

Item No.	Description	Qty.	Order No.
27	Screw	3	1062444
31	O-ring, 2.364 x 0.070 Buna-N	1	1062547
41	O-ring, 0.551 x 0.070 Black Viton (pkg. 4)	2	1020266
49	Plug Seal	2	1062541
50	O-ring, 0.426 x 0.070 Black Viton (pkg. 2)	2	1001493
51	Plug Screw	2	1062542
52	O-ring, 0.208 x 0.070 Polyurethane (pkg. 2)	3	1001323
53	Bottom Insulator	1	1062535
54	Rear Gun Body Assembly	1	1062538
55	O-ring, 0.989 x 0.070 Black Viton (pkg. 2)	2	1000225
56	O-ring, 0.301 x 0.070 Black Viton	1	1000737
57	O-ring, 0.489 x 0.070 Black Viton	1	1000359
58	Insulator	1	1062537
59	Insulator Insert	1	1062539
60	Electrode Baffle	1	1062533
61	Screw	2	1062532
62	Insulator Cover	1	1062536
63	Cover	1	1062543



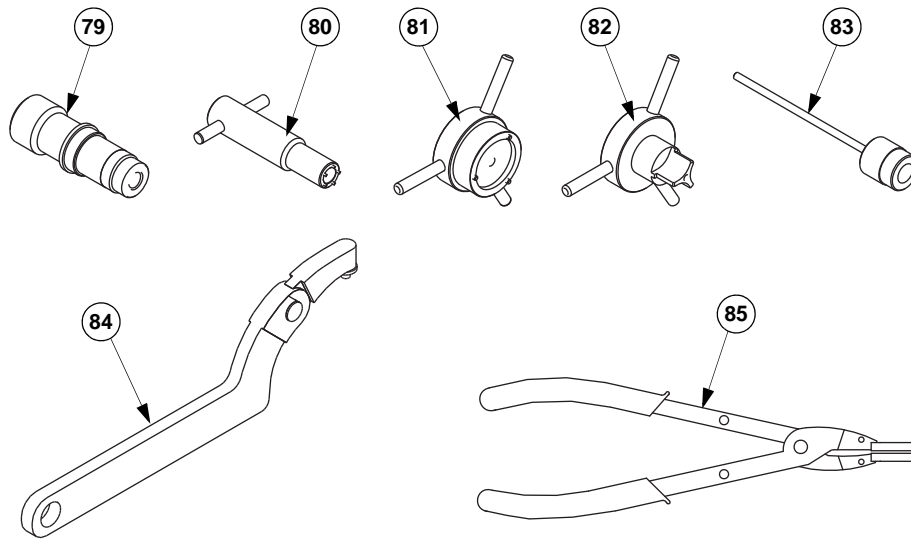
## 2.5 Powder Tubes, Holders and Injectors



iPro-90\_powder

Item No.	Description	Qty.	Order No.
3	Tube Clamp Assembly (includes items 64-67)	2	1062530
64	Tube Clamp (qty. per Tube Clamp Assy.)	1	—
65	Tube Clamp Top (qty. per Tube Clamp Assy.)	1	—
66	Screw (qty. per Tube Clamp Assy.)	2	—
67	Set Screw (qty. per Tube Clamp Assy.)	2	—
68	Powder Tube Assembly 37"	2	1062265
69	Powder Tube Assembly 40"	1	1062264
70	Powder Port #4	2	1000683
71	Powder Port #8	2	1063255
72	Powder Block	2	1062284
73	Set Screw	2	1062283
74	Screw	4	1062281
75	Powder Injector Holder 93	1	1062266
76	Powder Injector Holder 126	1	1062253
77	Powder Bar Assembly	1	1062252
78	O-ring, 0.114 x 0.070 Buna-N (pkg. 5)	2	1001160

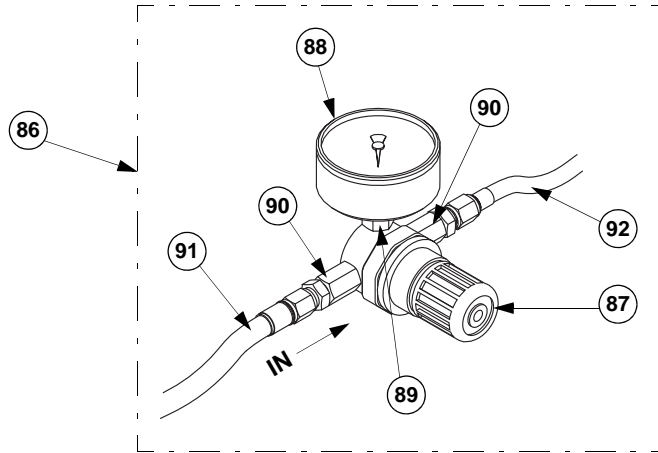
## 2.6 Tools



iPro-90\_tools

Item No.	Description	Qty.	Order No.
79	Alignment Tool	1	1062188
80	Electrode Wrench	1	1062230
81	Nozzle Wrench	1	1062229
82	Cartridge Wrench	1	1062228
83	Gas Ring Tool	1	1062185
84	Spanner Wrench	1	1062190
85	Electrode Puller Pliers	1	1001461

## 2.7 Hoses, Cables and Spares Packages (Optional)



iPro-90\_air\_reg\_kit

Item No.	Designation	Qty.	Order No.
86	Powder/Port Air Regulator Kit (includes items 87-92)	1	1033997
87	Regulator, 0.7 bar (10 psi)	1	1051700
88	Diaphragm Pressure Gage	1	—
89	Pipe Adapter 1/8NPTM x 1.25 x 1/4	1	—
90	Hose Adapter 1/8MNPT x 9/16-18	2	—
91	Air Hose Assembly, 7.6m (25 ft.)	1	1001877
92	Hose, 4.6m (15 ft.)	1	1002188
93	Hose and Cable Assembly, 8m (26 ft.) (includes items 94-97)	1	1034014
94	Hose Assembly, Plasma Gas 9.1m (30 ft.)	1	1001553
95	Electric Cable, Water Cooled (Red) 8m (26 ft.)	1	1034470
96	Electric Cable, Water Cooled (Blue) 8m (26 ft.)	1	1034471
97	T-Clip Fastener	3	—
98	Hose and Cable Assembly, 5m (16.4 ft.) (includes items 99-101, & 97)	1	1034011
99	Hose Assembly, Plasma Gas	1	1001561
100	Electric Cable, Water Cooled (Red) 5m (16.4 ft.)	1	1034012
101	Electric Cable, Water Cooled (Blue) 5m (16.4 ft.)	1	1034013
102	Spiral Cable Wrapping 11.3m (37 ft.)	1	1000530
103	Current Connection Insulator	2	1001470

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Item No.	Designation	Qty.	Order No.
104	O-ring Kit Package (includes the following items:)	—	1062556
5	O-ring, 0.239 x 0.070 Black Viton	6	1031639
6	O-ring, 2.239 x 0.070 Black Viton	2	1017900
25	O-ring, 0.801 x 0.070 Black Viton	1	1000549
26	O-ring, 0.614 x 0.070 Black Viton	1	1001462
29	O-ring, 2.614 X 0.070 Buna-N	1	1062551
30	O-ring, 2.489 x 0.070 Black Viton	1	1062548
31	O-ring, 2.364 x 0.070 Buna-N	2	1062547
40	O-ring, 1.051 x 0.070 Black Viton	1	1000729
41	O-ring, 0.551 x 0.070 Black Viton	3	1020266
44	O-ring, 0.739 x 0.070 Black Viton	3	1000646
47	O-ring, 0.330 x 0.070 Black Viton	1	1031649
50	O-ring, 0.426 x 0.070 Black Viton	2	1001493
52	O-ring, 0.208 x 0.070 Polyurethane	3	1001323
55	O-ring, 0.989 x 0.070 Black Viton	2	1000225
56	O-ring, 0.301 x 0.070 Black Viton	1	1000737
57	O-ring, 0.489 x 0.070 Black Viton	1	1000359
78	O-ring, 0.114 x 0.070 Buna-N	2	1001160

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