

POWDER FLAME SPRAY

6P-II Powder Flame Spray Gun

Technical brochure and spare-parts information for the 6P-II powder flame spray gun.



SPRAY GUN

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POWDER FLAME SPRAY GUN SPARES PARTS LIST **TYPE 6PM-II**

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TYPE 6PM-II-H POWDER FLAME SPRAY GUN

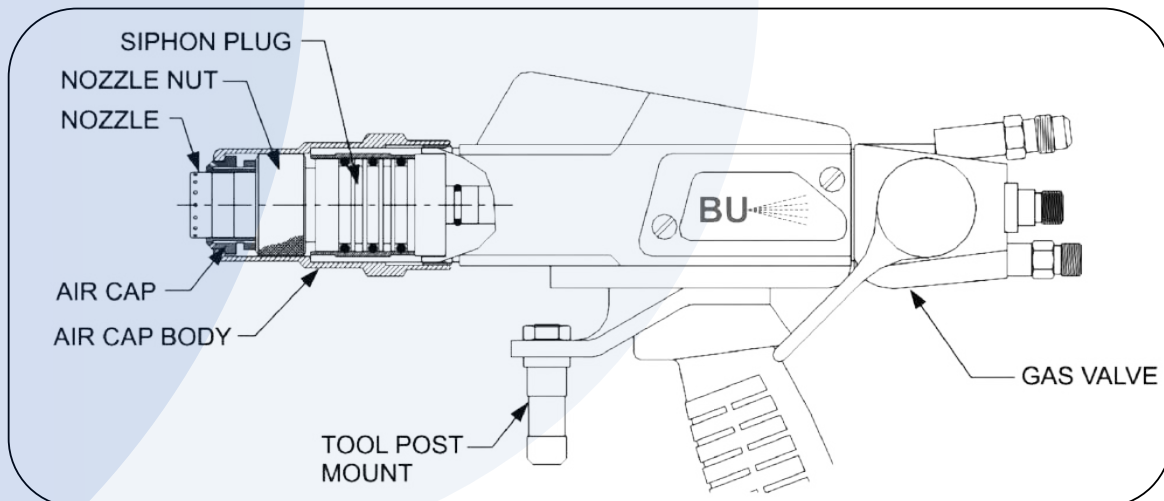


FIGURE 1.1 TYPE 6PM -II POWDER FLAME SPRAY GUN

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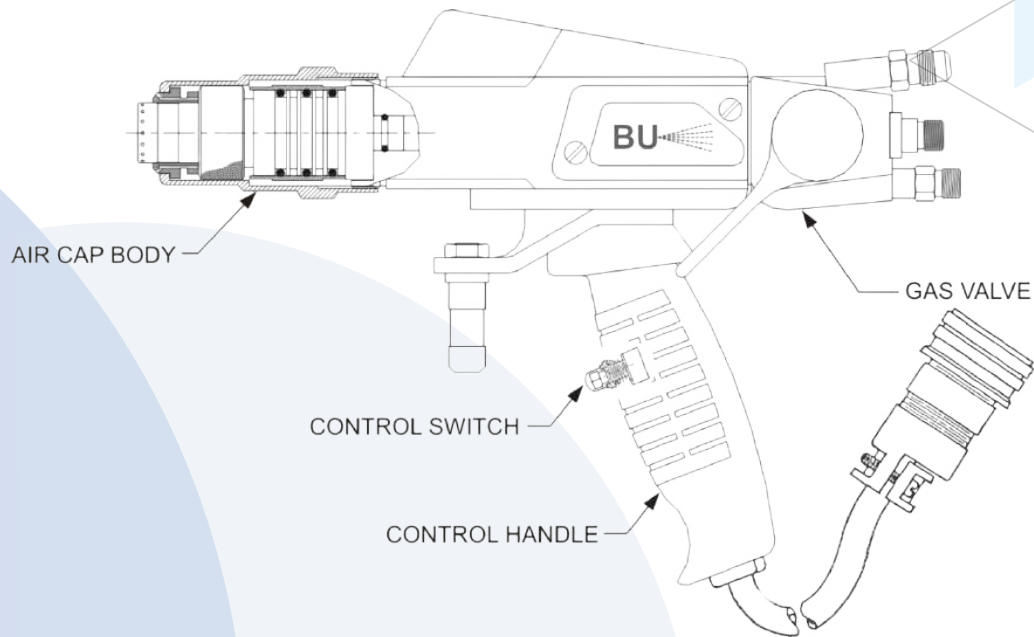


FIGURE 1.2 TYPE6PM-II-H HAND-HELD POWDER FLAME SPRAY GUN

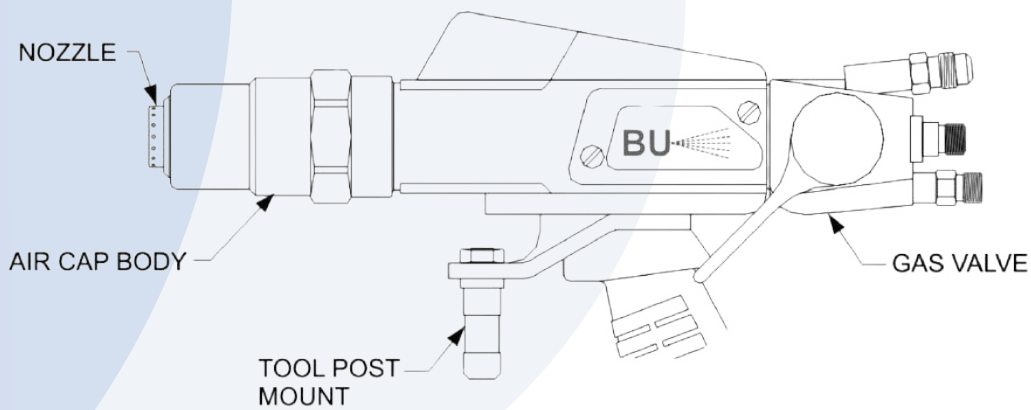


FIGURE 1.3 TYPE 6PM- II-A AUTOMATIC POWDER FLAME SPRAY GUN

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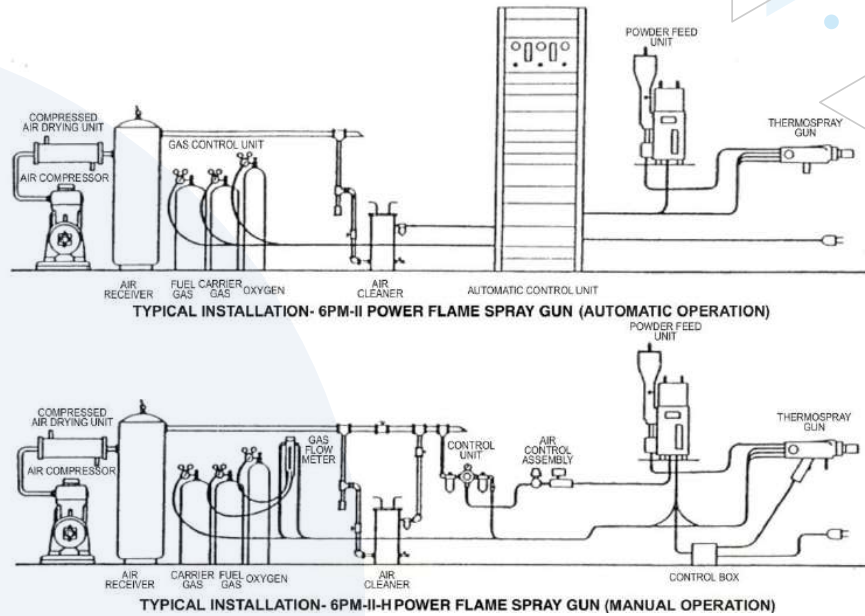


FIGURE 5.1 TYPICAL POWDER FLAME SPRAY SYSTEM INSTALLATION



FIGURE 5.2 TYPE 6PM-II POWDER FLAME SPRAY GUN HOSE CONNECTIONS

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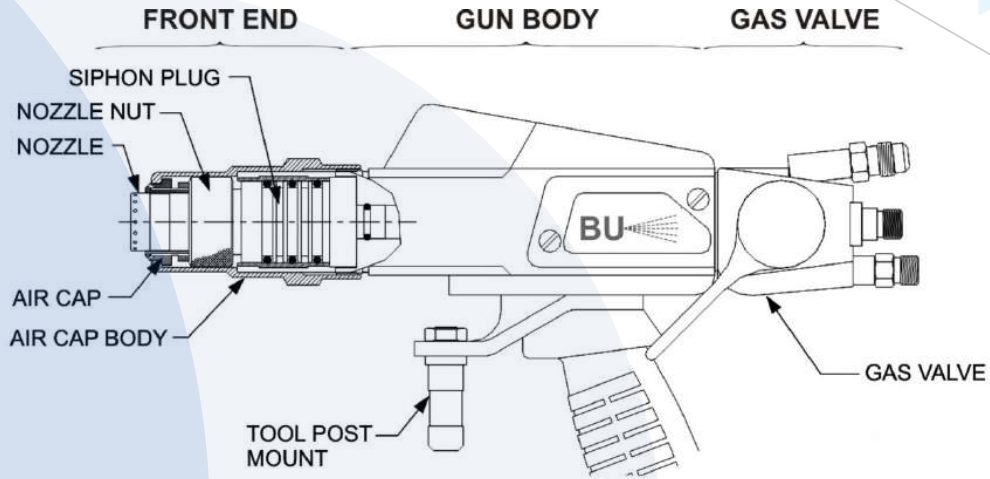


FIGURE 8.1 TYPE 6PM-II POWDER FLAME SPRAY GUN

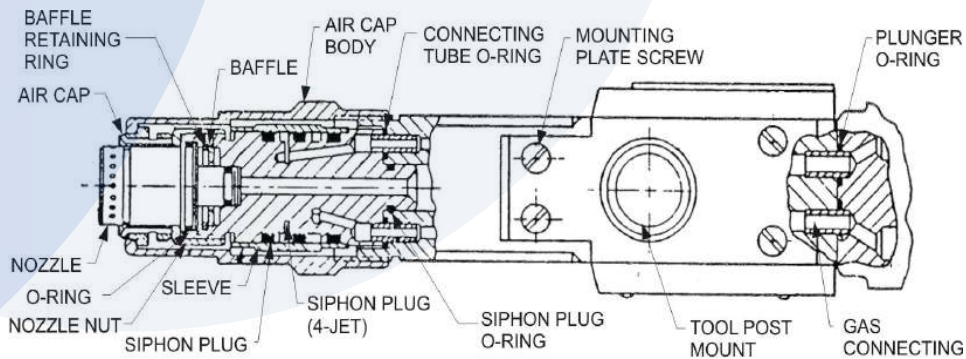


FIGURE 8.2 TYPE 6PM-II BOTTOM VIEW

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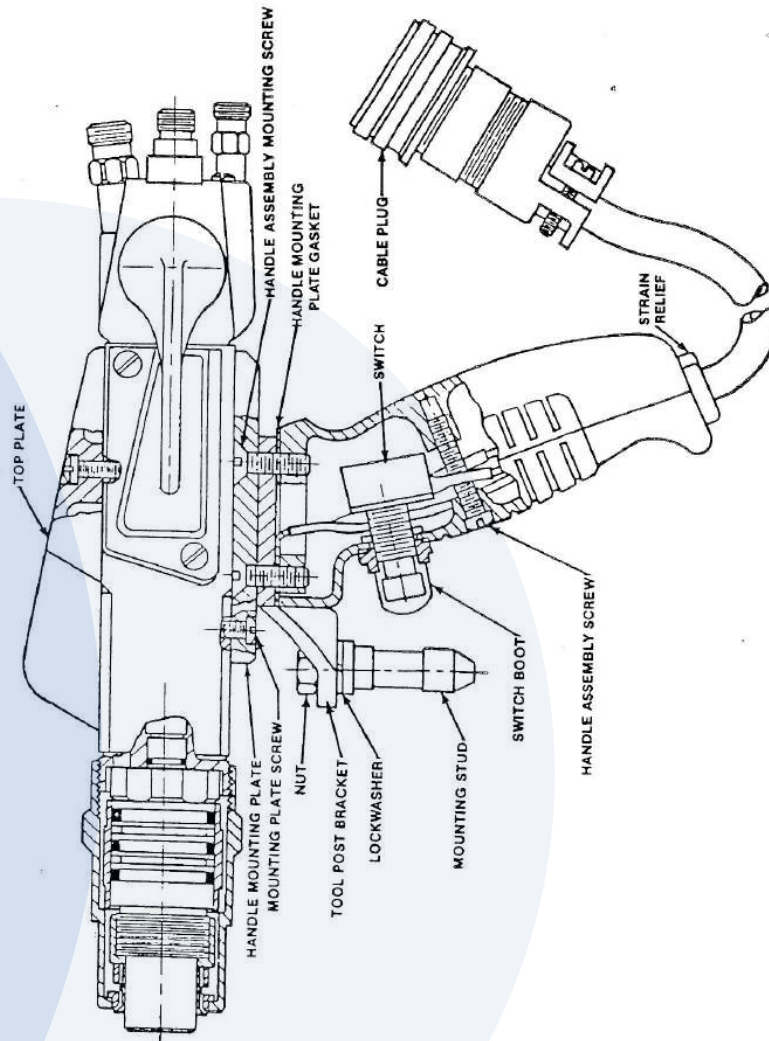
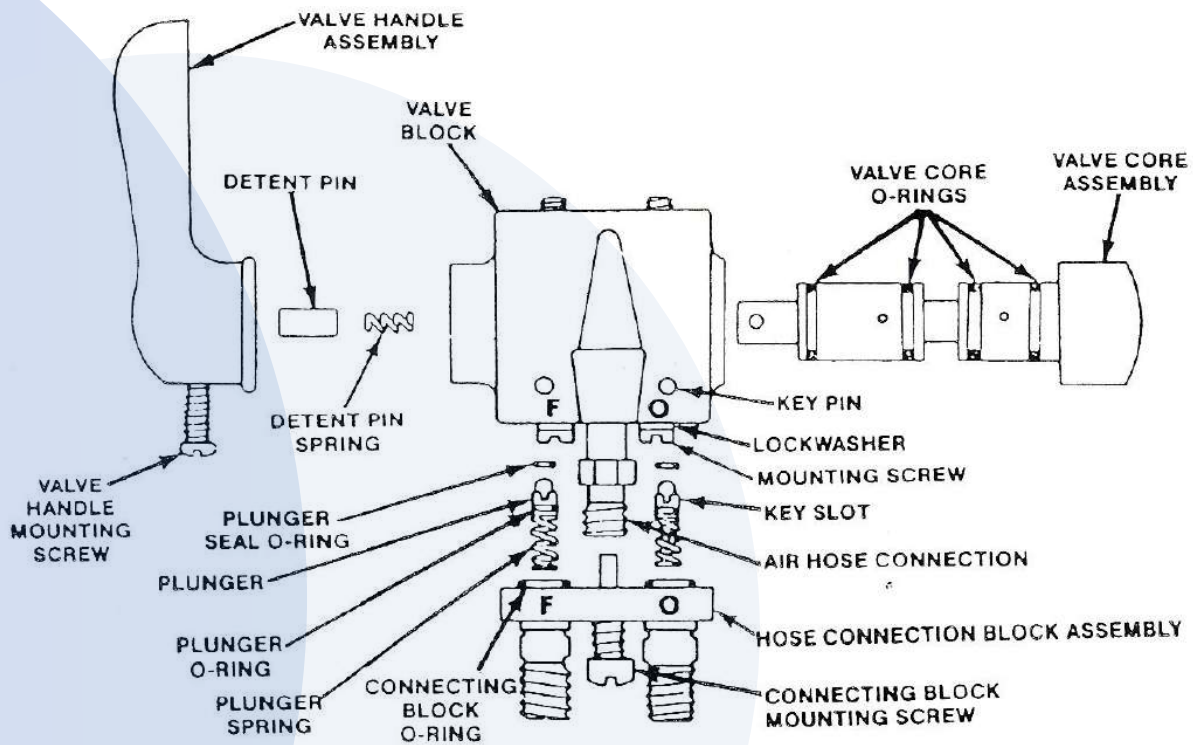


FIGURE 8.3 TYPE 6PM-II-H POWDER FLAME SPRAY GUN FOR HAND-HELD, MANUAL OPERATION

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GAS VALVE (See figure 8.1)

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POWDER SPRAY GUN

TYPE 6PM-II

REPLACEMENT PARTS

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TYPE 6PM – II POWDER FLAME SPRAY GUN

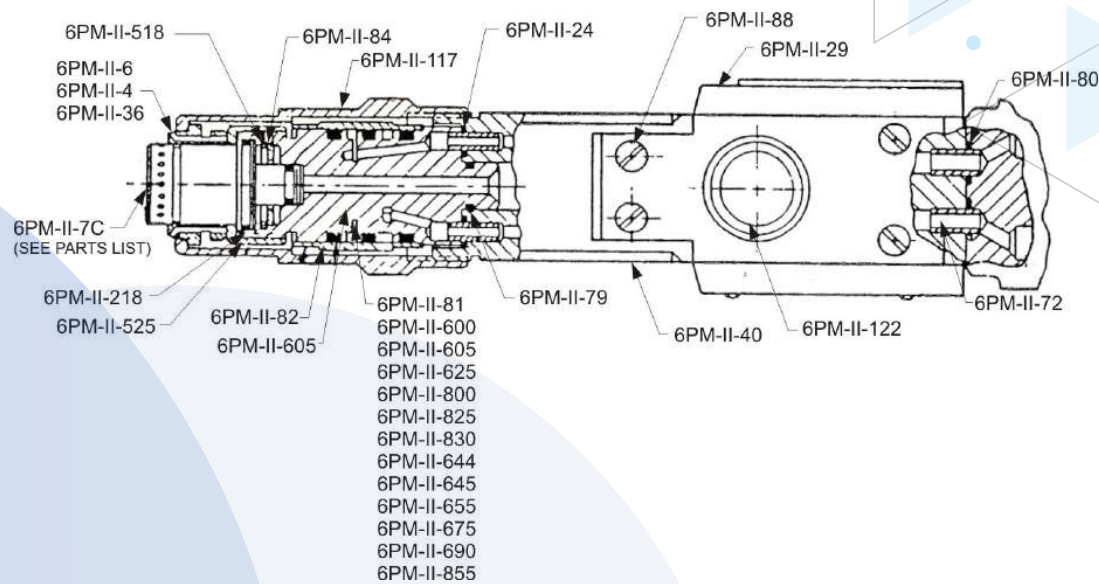
Cat. No.	Description	Cat. No.	Description
6PM-II-3	Air Cap (Power Cool)	6PM-II-600	Siphon Plug Assembly – 2 Jet
6PM-II-4	Air Cap (Gun Cooling)		(Includes Cat. Nos. 6PM-II-79, 81, 82, 84 and 518)
6PM-II-7C-1	#1 Nozzle (MPS)	6PM-II-605	Siphon Plug Assembly – 4 Jet
6PM-II-7C-B	"B" Nozzle		(Includes Cat. Nos. 6PM-II-79, 81, 82, 84 and 518)
6PM-II-7C-D	"D" Nozzle	6PM-II-625	Siphon Plug Assembly – 4 Jet
6PM-II-7C-E	"E" Nozzle		(Includes Cat. Nos. 6PM-II-7C-H, 36, 79, 81, 82, 84, 518 and 525)
6PM-II-7C-F	"F" Nozzle	6PM-II-644	Siphon Plug Assembly – 2 Jet
6PM-II-7C-H	"H" Nozzle Assembly (Included Cat. No. 6PM-II-217 and 218)		(Includes Cat. Nos. 6PM-II-7C-B, 79, 81, 82, 84, 518 525 and 600)
6PM-II-7C-K	"K" Nozzle	6PM-II-645	Siphon Plug Assembly – 2 Jet
6PM-II-7C-L	"L" Nozzle (Included Cat. No. 6PM-II-217 and 218)		(Includes Cat. Nos. 6PM-II-7C-M, 79, 81, 82, 84, 518 525 and 600)
6PM-II-7C-M	"M" Nozzle	6PM-II-655	Siphon Plug Assembly – 4 Jet
6PM-II-7C-MH	"MH" Nozzle		(Includes Cat. Nos. 6PM-II-7C-M, 79, 81, 82, 84, 518 525 and 605)
6PM-II-7C-N	"N" Nozzle	6PM-II-675	Siphon Plug Assembly – 4 Jet
6PM-II-7C-P	"P" Nozzle Assembly (Propane)		(Includes Cat. Nos. 6PM-II-7C-D, 79, 81, 82, 84, 518 525 and 605)
6PM-II-24	(Includes Cat No. 217 and 218)	6PM-II-690	Siphon Plug Assembly – 4 Jet
	O-ring (Pkg. of 5)		(Includes Cat. Nos. 6PM-II-7C-K, 79, 81, 82, 84, 518 525 and 605)
6PM-II-29	Nameplate Mounting Screw	6PM-II-800	Siphon Plug Assembly – 2 Jet
6PM-II-36	Air Cap		(Includes Cat. Nos. 6PM-II-79, 81, 82, 84 and 518)
6PM-II-40	Gun Body Assembly	6PM-II-825	Siphon Plug Assembly – 2 Jet
6PM-II-67	Top Plate Mounting Screw (Not shown)		(Includes Cat. Nos. 6PM-II-7C-P, 36, 79, 81, 82, 84, 518 and 525)
6PM-II-72	Gas Connecting Tube	6PM-II-830	Siphon Plug Assembly – 2 Jet
6PM-II-79	Siphon Plug O-rings		(Includes Cat. Nos. 6PM-II-7C-L, 36, 79, 81, 82, 84, 518 and 525)
6PM-II-80	O-rings (Pkg. of 3)	6PM-II-855	Siphon Plug Spare Parts Package
6PM-II-81	Siphon Plug		(Includes Cat. Nos. 6PM-II-79, 81, 82 and 518)
6PM-II-82	Sleeve		
6PM-II-84	Baffle Retaining Screw		
6PM-II-88	Mounting Plate Screw		
6PM-II-117	Air Cap Body		
6PM-II-122	Tool Post Mount		
6PM-II-169	Top Plate (Not Shown)		
6PM-II-217	O-ring		
6PM-II-218	O-ring		
6PM-II-518	Baffle		
6PM-II-525	Nozzle Nut		

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TYPE 6PM-II POWDER FLAME SPRAY GUN – BOTTOM VIEW

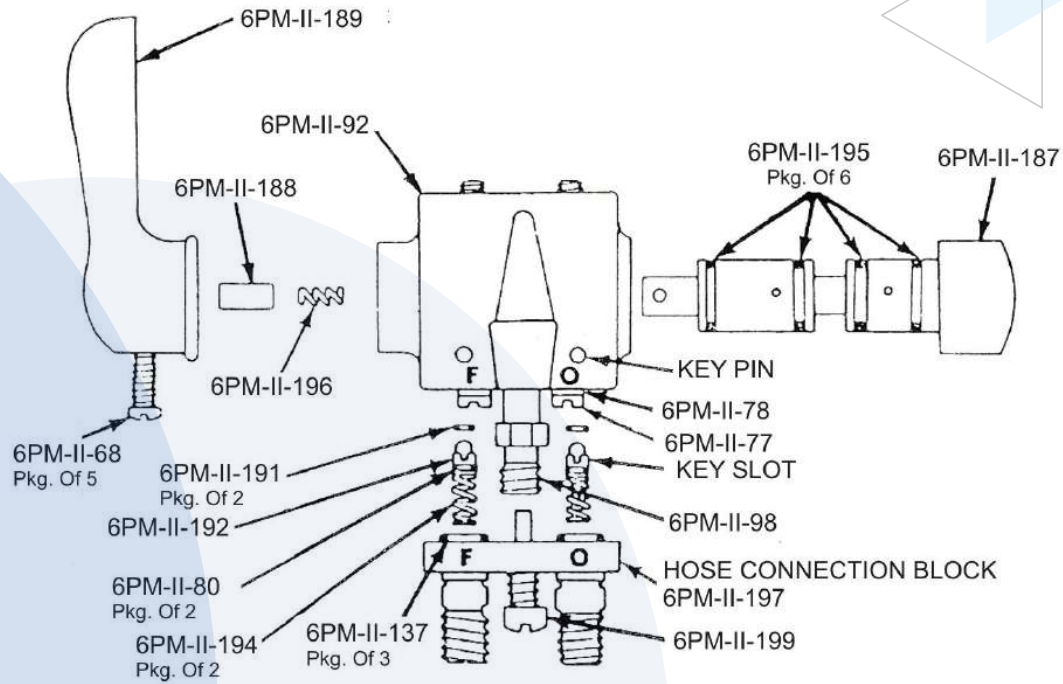
Cat. No.	Cat No. 6PM-II-5GAS VALVE Description
6PM-II-5	Gas Valve Assembly
6PM-II-68	Valve Handle Mounting Screw (Pkg. of 5)
6PM-II-77	Mounting Screw (Pkg. 5)
6PM-II-78	Lockwasher (Pkg. 5)
6PM-II-80	Plunger O-Ring (Pkg. of 2)
6PM-II-92	Valve Block
6PM-II-98	Air Hose Connection
6PM-II-137	Connection Block O Ring (Pkg of 3)
6PM-II-187	Valve Core Assembly
6PM-II-188	Detent Pin
6PM-II-189	Valve Handle Assembly
6PM-II-191	Plunger Sea O-Ring (Pkg. of 2)
6PM-II-192	Plunger
6PM-II-194	Plunger Spring
6PM-II-195	Valve Core O-Ring (Pkg. of 6)
6PM-II-196	Detent Pin Spring
6PM-II-197	Hose Connection Block Assembly
6PM-II-199	Connection Block Mounting Screw
6PM-II-280	Gas Valve O-Ring Package (Includes 6PM-II-80, 6PM-II-137,

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Cat. No.	Description
6PM-II-27	Cable Plug
6PM-II-88	Mounting Plate Screw (Pkg. of 10)
6PM-II-169	Top Plate (Supplied on all type 6PM-II--II Guns)
6PM-II-281	Tool Post Bracket
6PM-II-282	Mounting Stud
6PM-II-283	Nut (Pkg. of 5)
6PM-II-284	Lockwasher (Pkg. 5)
6PM-II-285	Handle Mounting Plate
6PM-II-286	Handle Assembly Mounting Gasket
6PM-II-287	Handle Assembly Mounting Screw
6PM-II-288	Handle Assembly Screw
6PM-II-289	Switch
6PM-II-290	Switch Boot
6PM-II-291	Strain Relief
6PM-II-510	Control Handle Assembly (includes all of the above parts except 6PM-II-88 and 6PM-II-169)

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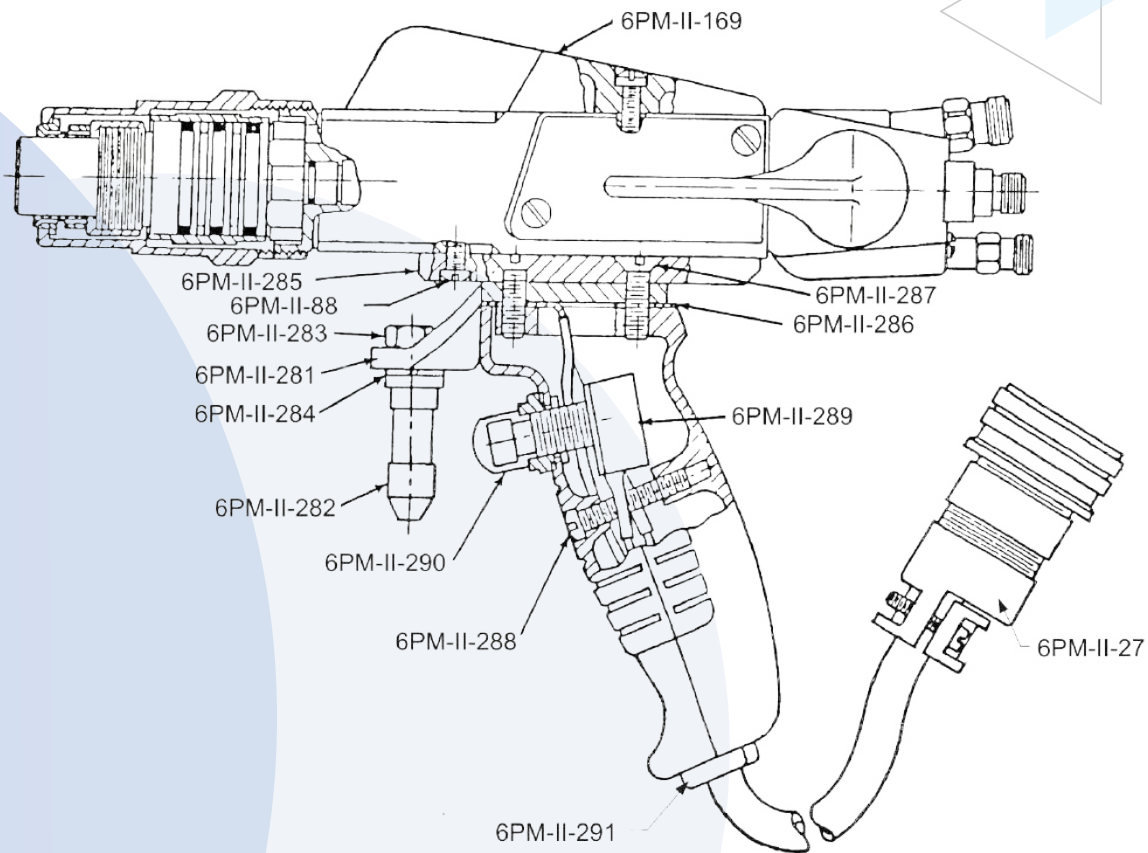


FIGURE 10.3 TYPE 6PM II-H POWDER FLAME SPRAY GUN FOR HAND-HELD MANUAL OPERATION

NOTE:

Cat. Nos. shown, except 6PM-II-88, are all part of Cat. No. 6PM-II-510 Control Handle Assembly. For Gun parts not shown here, see figures 10.1 and 10.2

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TYPE 6PM-II-975 ELECTRICAL CONTROL BOX

Cat. No.	Description
6PM-II-18	Toggle Switch
6PM-II-19	Dust Boot
6PM-II-26	Control Switch Receptacle – 5Terminal – Female
6PM-II-223	Fuse
6PM-II-306	Cover
6PM-II-307	Cover Mounting Screw (Pkg. of 6)
6PM-II-310	Fuse Holder
6PM-II-312	Receptacle Mounting Screw (Pkg. of 6)
6PM-II-313	Receptacle Nut (Pkg. of 6)
6PM-II-317	Powder Feed Receptacle – 5 Terminal – Female
6PM-II-318	Control Box Mounting Screw (Pkg. of 6)
6PM-II-321	Legend Plate
6PM-II-322	Air Vibrator Receptacle – 3 Terminal – Female
6PM-II-376	Receptacle Lockwasher (Pkg. of 6)
6PM-II-445	Strain Relief O-Ring (Pkg. of 6)
6PM-II-446	Connector
6PM-II-447	Connector Nut
6PM-II-544	Strain Relief
6PM-II-595	O –Ring (Pkg. of 4)

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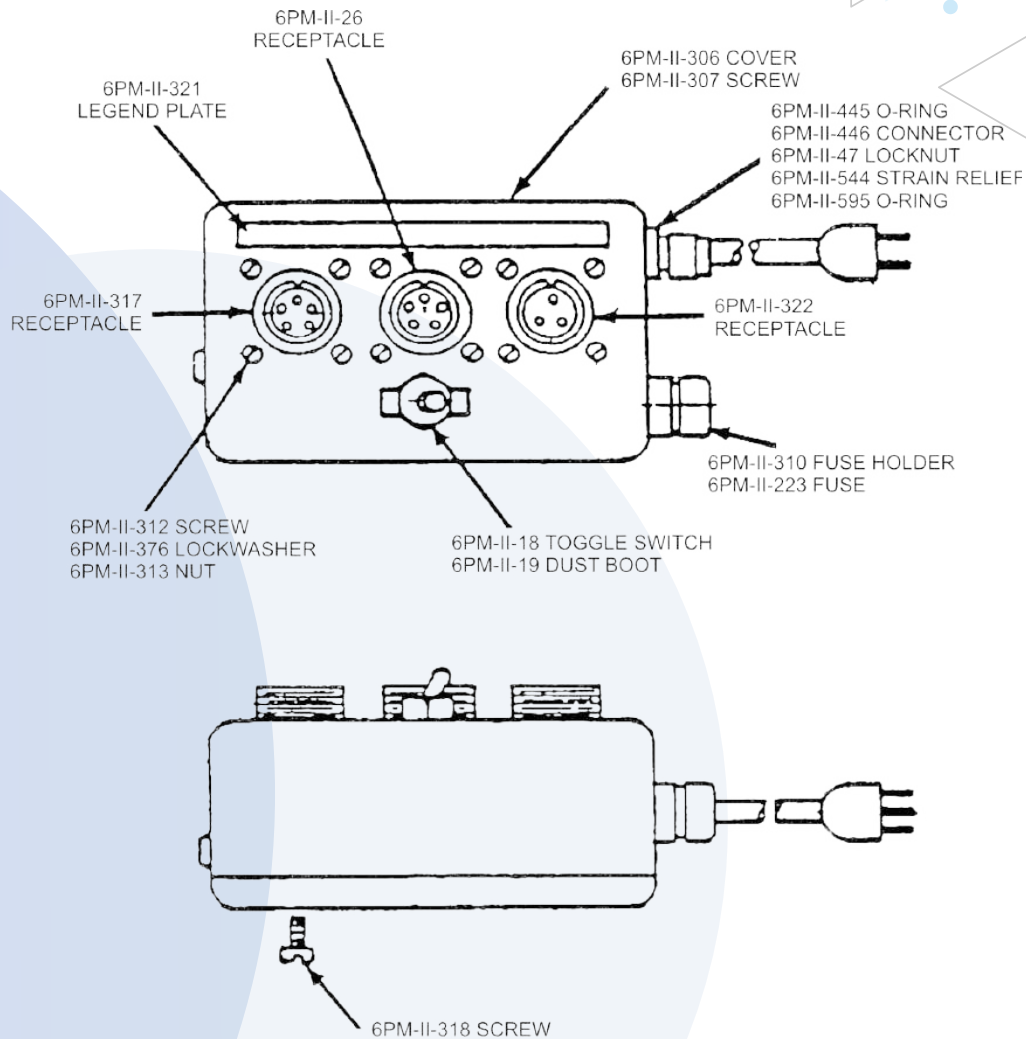


FIGURE 10.4 CAT. NO. 6PM-II-975 ELECTRICAL CONTROL BOX
STANDARD WITH HAND HELD & MACHINE MOUNTED
MANUALLY OPERATED TYPE 6PM-II & 6PM-II-H
POWDER FLAME SPRAY GUN S.

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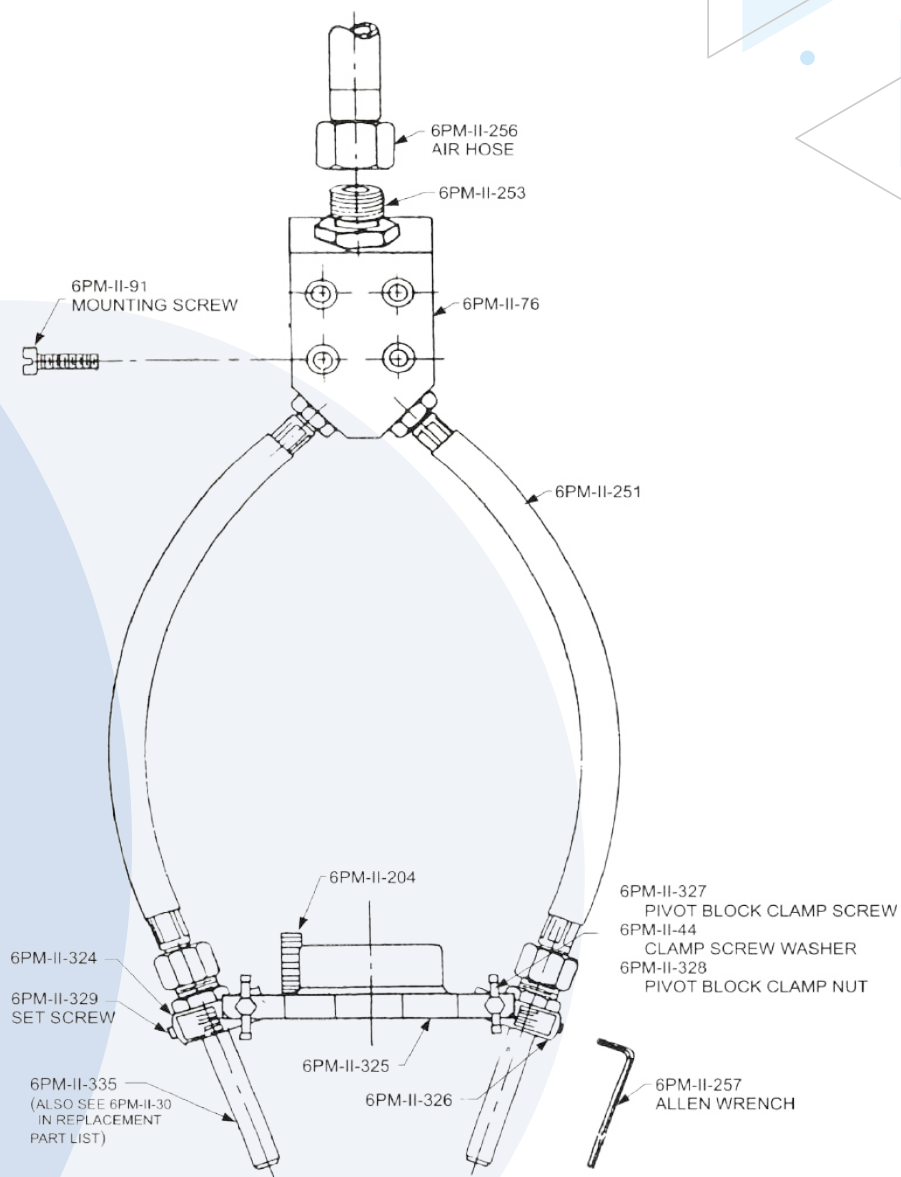
TYPE 6PM-II-330 AIR JET ASSEMBLY

Cat. No.	Description
6PM-II-30	Air Nozzle (for Flat Surfaces)
6PM-II-44	Pivot Block Clamp Screw Washer (Pkg. of 4)
6PM-II-76	Air Block
6PM-II-91	Air Block Mounting Screw (Pkg. of 4)
6PM-II-204	Air Jet Head Clamp Screw
6PM-II-251	Air Nozzle Hose
6PM-II-253	Air Block Hose Connector
6PM-II-256	Supply Air Hose
6PM-II-257	Allen Wrench
6PM-II-324	Pivot Block (Right)
6PM-II-325	Air Jet Head
6PM-II-326	Pivot Block (Left)
6PM-II-327	Pivot Block Clamp Screw
6PM-II-328	Pivot Block Clamp Nut
6PM-II-329	Air Nozzle Set Screw (Pkg. of 4)
6PM-II-330	Air Jet Assembly (See Note)
6PM-II-335	Air Nozzle (for cylindrical surfaces)

Note 6PM-II-330 Air Jet Assembly available as optional equipment (includes all of the above Cat. No.)

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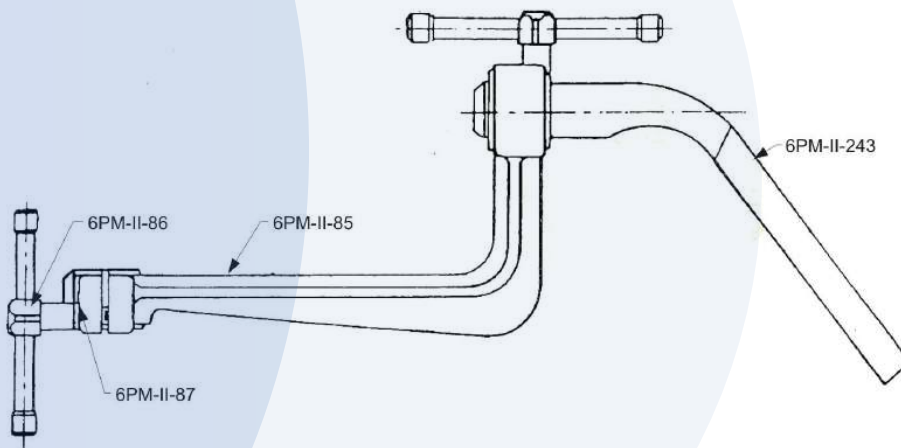
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NOTE:
6PM-II-330 AIR JET ASSEMBLY AVAILABLE AS OPTIONAL EQUIPMENT
(INCLUDES OAA OF THE ABOVE CAT. NOS.)

TYPE 6PM-II-299, TOOL POST FIXTURE ASSEMBLY

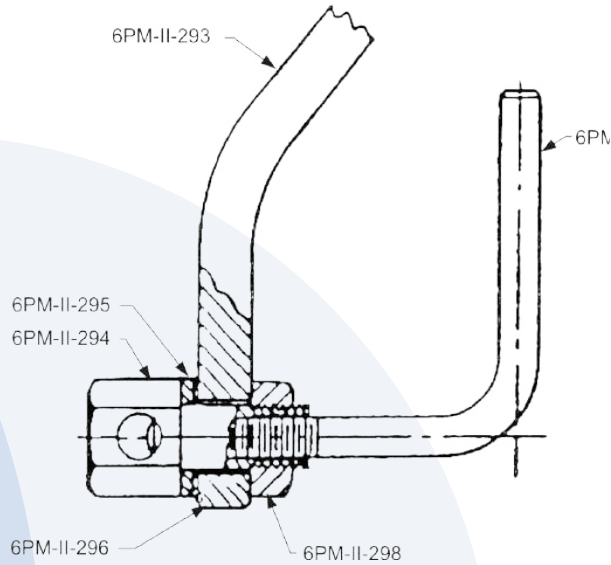
Cat. No.	Description
6PM-II-85	Tool Post Bracket
6PM-II-86	Clamp Screw
6PM-II-87	Washer
6PM-II-125	Tool Post Fixture Assembly (includes 6PM-II-293, 6PM-II-294, 6PM-II-295, 6PM-II-296, 6PM-II-297 and 6PM-II-298)
6PM-II-243	Tool Post Bar
6PM-II-293	Tool Post Fixture Body
6PM-II-294	Tool Post Cross Bar
6PM-II-295	Cross Bar Lockwasher (Pkg. of 5)
6PM-II-296	Cross Bar Washer (Pkg. of 5)
6PM-II-297	Clamp Screw
6PM-II-298	Clamp Screw Nut
6PM-II-299	Tool Post Fixture Assembly (Includes 6PM-II-85, 6PM-II-87 and 6PM-II-243)



CAT. NO. 6PM-II-299 TOOL POST FIXTURE ASSEMBLY AVAILABLE AS OPTIONAL EQUIPMENT FOR MACHINE MOUNTED TYPE 6PM-II OR 6PM-II-A POWDER FLAME SPRAY GUN

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CAT. NO. 6PM-II-125 TOOL POST FIXTURE ASSEMBLY STANDARD WITH
HAND HELD, MANUALLY OPERATED TYPE 6PM-II-H POWDER FLAME
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ADDITIONAL REPLACEMENT PARTS (NOT SHOWN)

Cat. No.	Description
6PM-II-13	Individual Hose Clamp
6PM-II-18	Switch
6PM-II-19	Screw
6PM-II-27	Cable Plug
6PM-II-50	Gas Block Assembly ("5C" System) (Includes 6PM-II-98, 6PM-II-301, 6PM-II-302)
6PM-II-52	Twin Hose Retaining Ferrule
6PM-II-89	Twin Oxygen & Acetylene Hose Assembly
6PM-II-90	Air Hose Assembly
6PM-II-98	Air Hose Connection
6PM-II-99	Air Hose Connection Cap
6PM-II-101	Powder Feed Hose
6PM-II-111	TruearePhers
6PM-II-112	Adjustable Open-End Wrench
6PM-II-118	Screwdriver
6PM-II-126	Spark Lighter
6PM-II-127	Cleaning Brush
6PM-II-128	Cleaning Wire Kit
6PM-II-193	BU(MSE)Powderlube
6PM-II-198	BU(MSE)Valvelube
6PM-II-301	Oxygen House Fitting
6PM-II-302	Acetylene House Fitting
6PM-II-352	Gun Case
6PM-II-393	Eye Protectors
6PM-II-394	Hearing Protectors
6PM-II-395	Replacements Lens
6PM-II-396	Replacement Cover Plate
6PM-II-397	Safety Package (Consists of 6PM-II-393, 6PM-II-394)
6PM-II-400	Quick Disconnect Hose Package
6PM-II-590	Remote Control Cable (Includes 6PM-II-18, 19 27)
6PM-II-666	BU(MSE) Flame Spray Handbook, Vol. 11

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