



## **PPS CORROSPRAY Wire Metalizing Gun**



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**Section 1: Parts Lists – Diagrams**

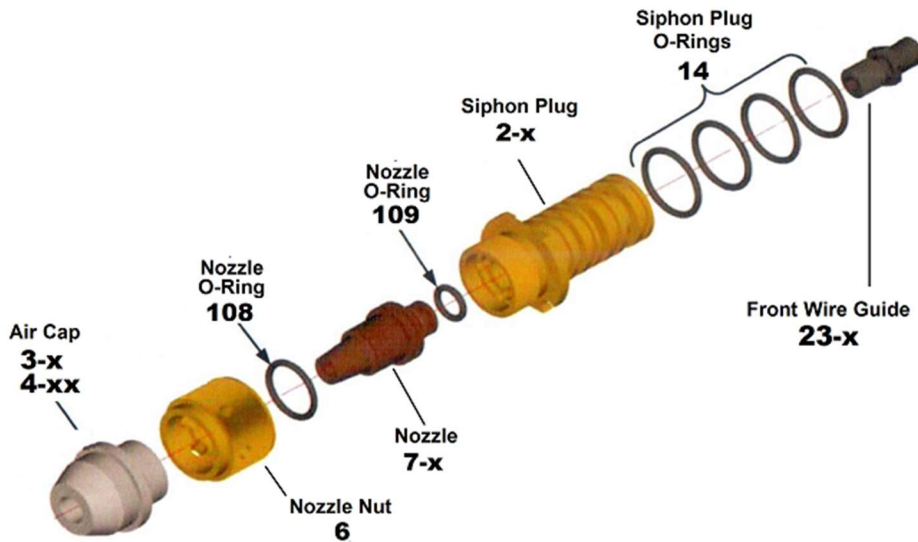
**1.1 CORROSPRAY/11E Nozzles (Includes O-Rings)**

Part No.	Description	Part No.	Description
87-7-7	Noz Acet 3/16	87-7-13	Noz Acet 1/8
87-7-8	Noz Acet 3/16 N/L	87-7-14	Noz Acet 1/8 N/L
87-7-9	Noz Prop 3/16	87-7-15	Noz Prop 1/8
87-7-10	Noz Prop 3/16 N/L	87-7-16	Noz Prop 1/8 N/L

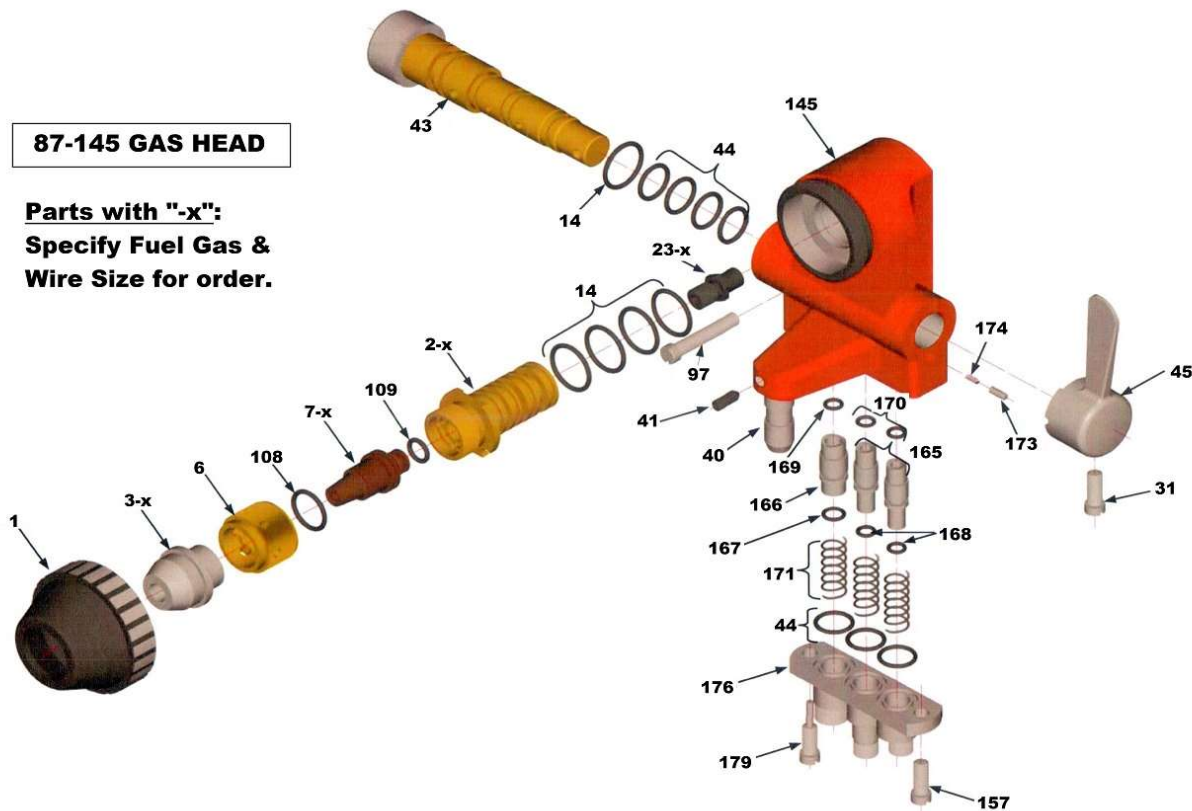
*\* N/L (Non-Loading) Nozzles are for frequent wire feed Start/Stop operation*

**1.2 CORROSPRAY/11E Air Cap, Siphon Plug, Front Wire Guides**

Part No.	Description	Part No.	Description
<b>Air Caps</b>		<b>Front Wire Guides</b>	
87-3-AH	Air Cap 3/16" Wire	87-23-1/8	FRONT WIRE GUIDE 1/8" Wire
87-3-CH	Air Cap 1/8" Wire	87-23-3/16	FRONT WIRE GUIDE 3/16" Wire
87-4-AB	Fan Spray Air Cap 3/16" Wire	<b>Nozzle Nut &amp; O-Rings</b>	
87-4-CD	Fan Spray Air Cap 1/8" Wire	87-6	Nozzle Nut
<b>Siphon Plugs</b>		87-14	O-Rings: Siphon Plug PK/6
87-2-3	Siphon Plug Acet 1/8" – 3/16"	87-108	O-Ring: Nozzle Large
87-2-4	Siphon Plug Prop 1/8" – 3/16"	87-109	O-Ring: Nozzle Small



### 1.3 CORROSPRAY/11E Gas Head Assembly



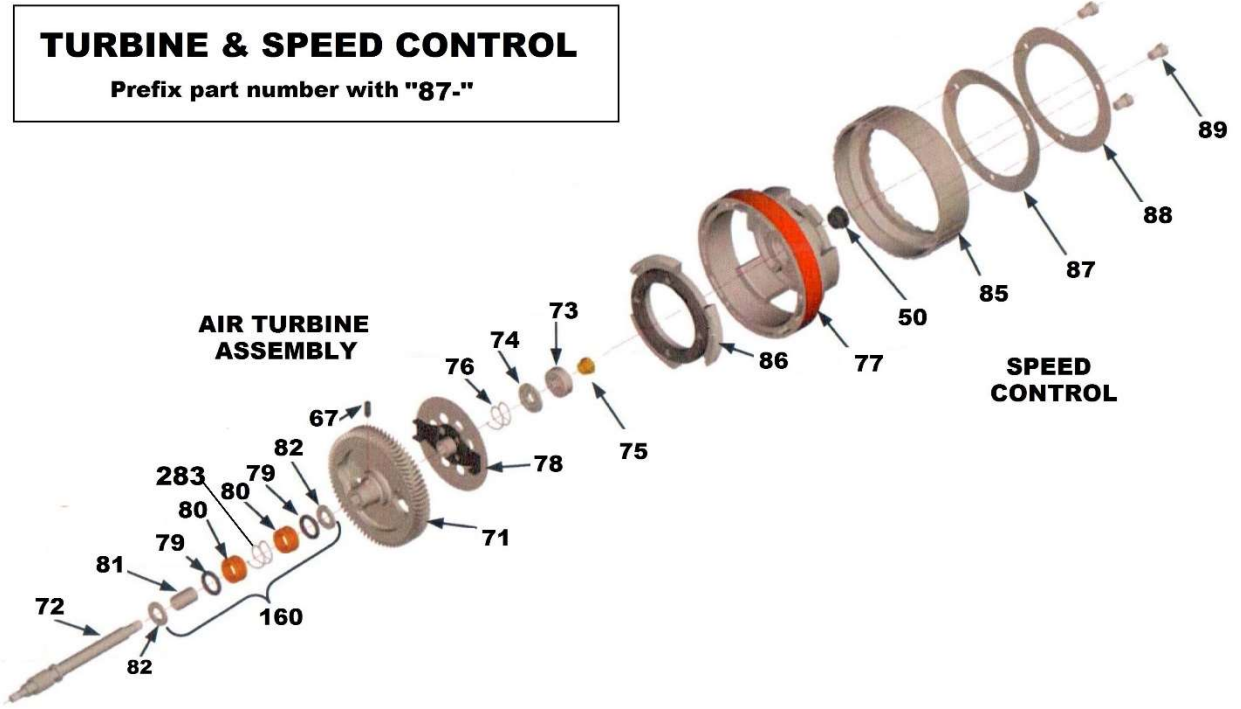
**87-145 GAS HEAD**

**Parts with "-x":**  
**Specify Fuel Gas &**  
**Wire Size for order.**

#### Gas Head Assembly

87-1	Air Cap Body	87-97	Gas Head Mounting Screw, Front PK/5
87-2-x	Siphon Plug	87-145	Gas Head Body (Inc. 87-40 & 41)
87-3-x	Air Cap	87-157	Hose Connection Block Mounting Screw PK/1
87-5	Gas Head Assembly	87-165	Plunger (Fuel Gas & Oxygen)
87-6	Nozzle Nut	87-166	Plunger (Air)
87-7-x	Nozzle	87-168	O-Ring: Plunger (Fuel Gas & Oxygen) PK/2
87-14	O-Ring: Valve Core/Siphon Plug/Counter Shaft PK/6	87-169	O-Ring: Plunger Seal (Air) PK/1
87-23-x	Front Wire Guide	87-170	O-Ring: Plunger Seal (Fuel Gas & Oxygen) PK/2
87-31	Valve Handle Screw PK/5	87-171	Plunger Spring
87-40	Mounting Stud	87-173	Detent Pin
87-41	Mounting Stud Roll Pin	87-174	Detent Pin Spring
87-43	Valve Core (With O-Rings)	87-176	Hose Connection Block
87-44	O-Ring: Valve Core/Hose Conn Block PK/7	87-179	Valve Core Stop Screw
87-45	Valve Handle	87-184	O-Ring Set - (Complete Set) PK/44
87-96	Gas Head Mounting Screw, Rear (not shown) PK/5	87-186	O-Ring: Plunger (Air) PK/3

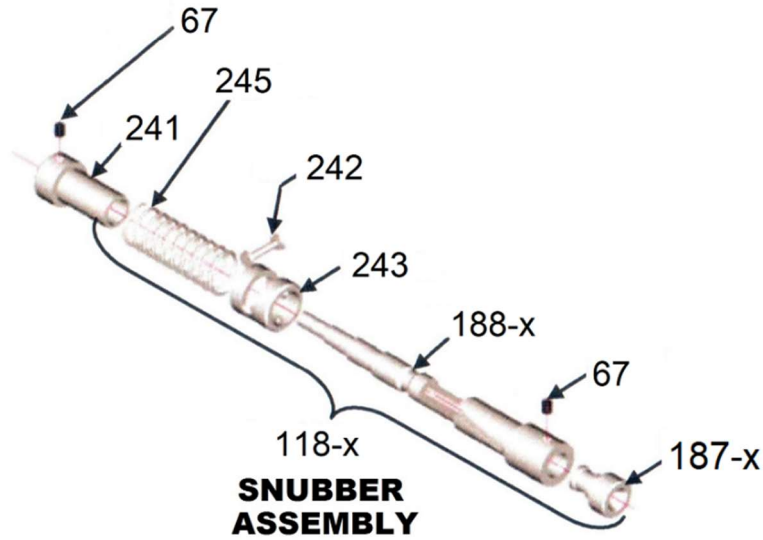
1.4 CORROSPRAY/11E Turbine and Speed Control Assembly



Turbine and Speed Control Assembly

87-50	Grease Plug Screw	87-80	Oil Seal Bobbin
87-67	Turbine Rotor Set Screw PK/2	87-81	Oil Seal Sleeve
87-71	Turbine Rotor (Inc. 67)	87-82	Oil Seal Washer PK/2
87-72	Turbine Shaft	87-84	Left Bearing Nut
87-73	Turbine Shaft Bearing - Right	87-85	Speed Control Ring
87-74	Washer for Disc Brake Return	87-86	Spider Assembly (Brake pad)
87-75	Turbine Shaft Nut – Right	87-87	Detent Spring
87-76	Brake Disc Return Spring	87-88	Name Plate Ring
87-77	Turbine Cover Assembly	87-89	Name Plate Ring Screw PK/5
87-78	Brake Disc	87-160	Oil Seal Assembly (Inc. 79, 80, 81, 82 & 283)
87-79	O-Ring: Shaft Seal PK/5	87-283	Oil Seal Spring

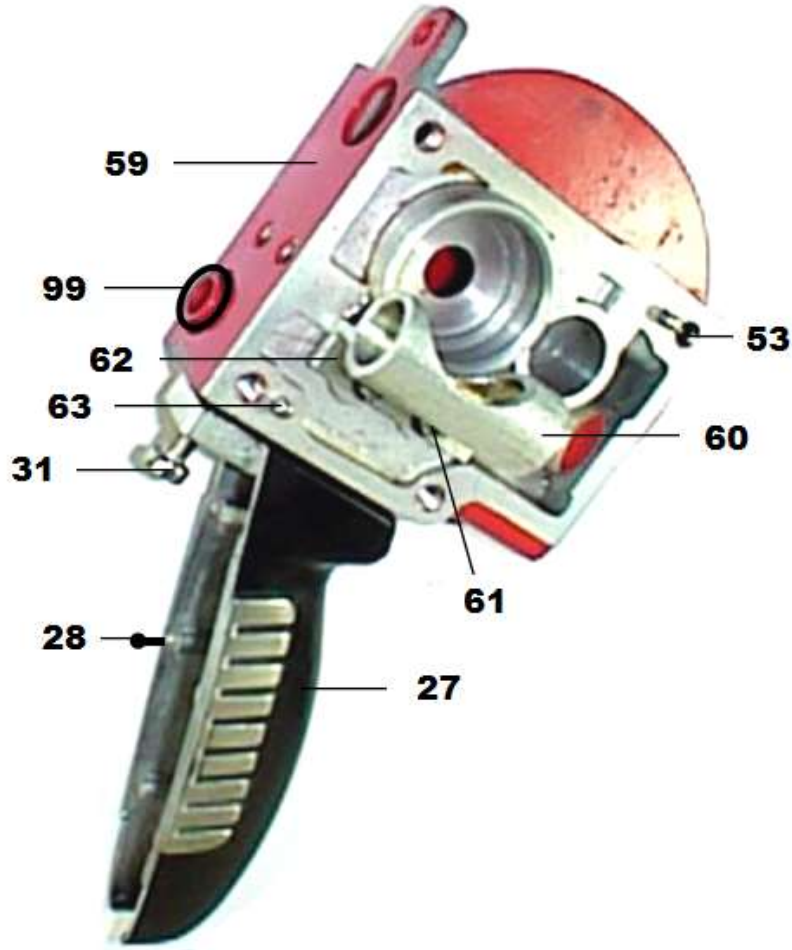
**1.5 CORROSPRAY/11E Snubber Assembly**



87-67	Set Screw PK/2
87-118-x	Snubber Assembly – (15Ga, 1/8", 3/16")
87-187-x	Guide Insert – (15Ga, 1/8", 3/16")
87-188-x	Snubbing Guide – (15Ga, 1/8", 3/16")
87-241	Spring Retainer
87-242	Roller
87-243	Spring Housing
87-245	Spring
87-24-x	Plain Rear Wire Guide – (15Ga, 1/8", 3/16") (not shown)

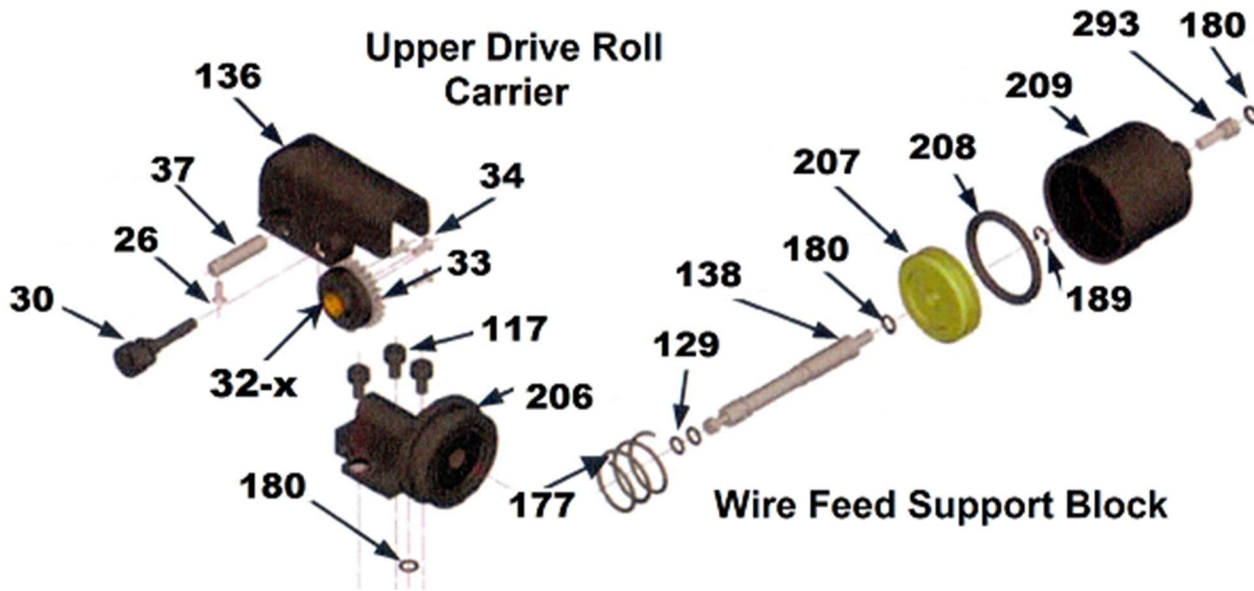


**1.6 CORROSPRAY/11E Central Housing – Gun Handle**



87-27	Gun Handle (Inc. 28)	87-61	Pump Housing Mounting Screw PK/5
87-28	Gun Handle Screw PK/5	87-62	Pump Housing Lock Washer PK/1
87-31	Gun Handle Mounting Screw PK/5	87-63	Dowel Pin for mounting Gear Cover
87-53	Gear Cover Screw PK/10	87-99	O-Ring: Gas Head to Body PK/5
87-59	Central Housing (Inc. 60, 61, 62, 63)	87-180	O-Ring: Wire Grip/Valve Block PK/2
87-60	Pump Housing		

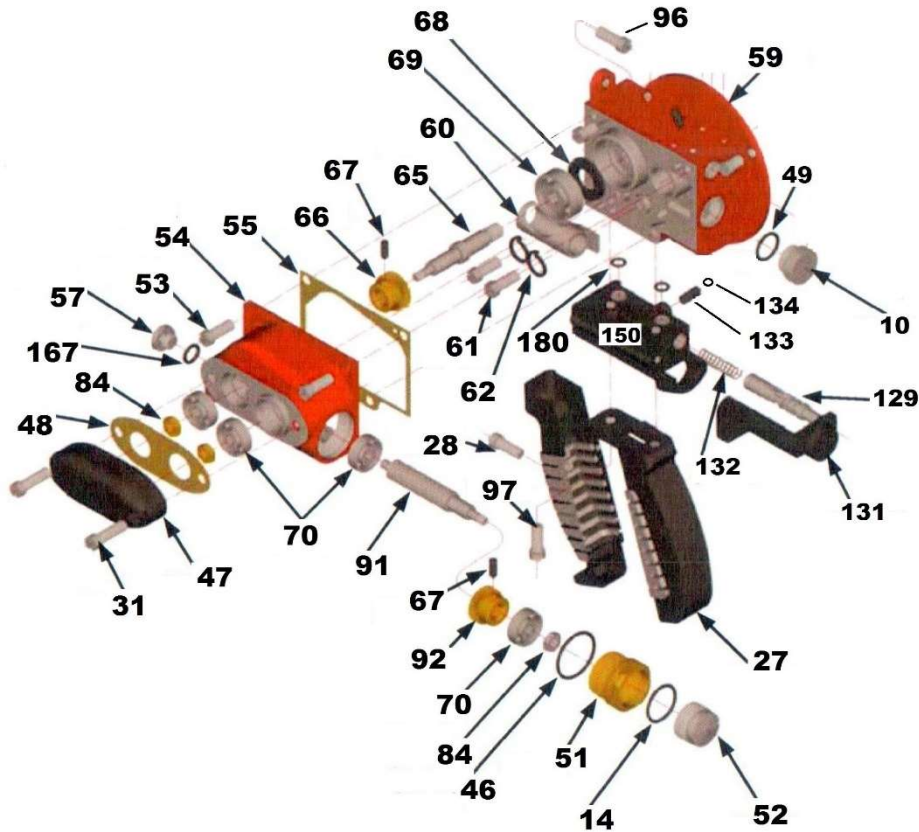
**1.7 CORROSPRAY/11E Support Block, Drive Rolls & Piston**



87-26	Drive Roll Axle Screw PK/5	87-129	O-Ring: Push Rod PK/2
87-30	Drive Roll Carrier Pivot Pin	87-136	Drive Roll Carrier
87-32-x	Upper Drive Roll	87-138	Piston Rod
87-33	Upper Drive Roll Gear	87-177	Piston Return Spring
87-34	Upper Drive Roll Gear Screw PK/5	87-180	O-Ring: Wire Feed Valve Block PK/2
87-35-x	Lower Drive Roll	87-189	Retainer Ring
87-36	Lower Drive Roll Gear	87-206	Support Block Assembly
87-37	Upper Drive Roll Axle	87-207	Piston
87-293	Piston Stop Screw	87-208	O-Ring: Piston PK/3
87-117	Support Block Mounting Screw PK/5	87-209	Cylinder



**1.8 CORROSPRAY/11E Transmission & Gear Covers.**



87-10	Oil Sight Plug	87-54	Gear Cover
87-14	O-Ring: Countershaft PK/6	87-55	Gear Cover Gasket
87-28	Gun Handle Screw	87-57	Front Plug Screw
87-31	Bearing Cover Mounting Screw	87-59	Central Housing (Inc. 60, 61, 62, 63)
87-46	O-Ring: Bearing Retainer PK/2	87-61	Pump Housing Mounting Screw
87-47	Bearing Cover	87-62	Pump Housing Lock Washer
87-48	Bearing Cover Gasket	87-65	Drive Shaft
87-49	O-Ring: Oil Sight Plug	87-66	Drive Shaft Gear
87-51	Bearing Retainer – Rear	87-67	Gear Set Screw
87-52	Retainer/Bearing Plug	87-68	Drive Shaft Seal
87-53	Gear Cover Screw	87-69	Drive Shaft Bearing
87-70	Bearing: Countershaft (2) – Drive Shft (L), Trbn Shaft	87-131	Valve Shaft Assembly (Inc. 129)
87-84	Countershaft Nut PK/5	87-132	Valve Shaft Spring
87-91	Countershaft	87-133	Cam Follower Screw (Inc. 134)
87-92	Countershaft Gear	87-134	O-Ring: Cam Follower PK/2
87-96	Gas Head Mounting Screw	87-150	Wire Grip Valve Block
87-97	Gas Head Mounting Screw – Front	87-186	O-Ring: Front Plug PK/3
87-129	O-Ring: Shaft Seal	87-180	O-Ring: Wire Grip Valve

**1.9 Tools & Lubricants/ Tool Post Fixture**

Part No	Description	Part No	Description
87-101	Lighter	87-114	Cleaning Wire Kit
87-103	Drive Roll Tool	87-124	Tool Post
87-110	Gear Lube PK/3	87-55810	Spanner Wrench
87-111	Valve Lube		



114 Wire Cleaning Kit



101 Spark Lighter



124 Tool Post



55810 Spanner

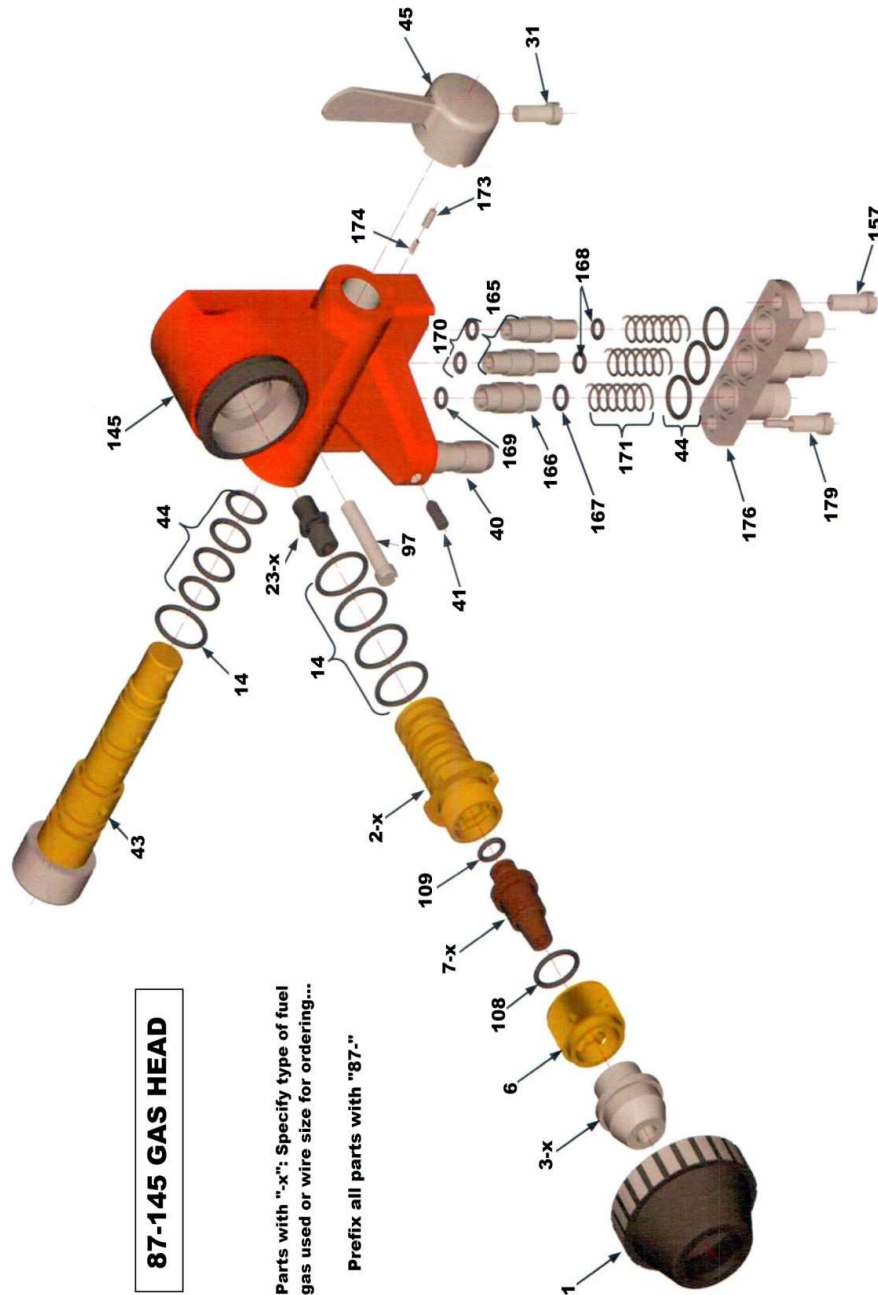


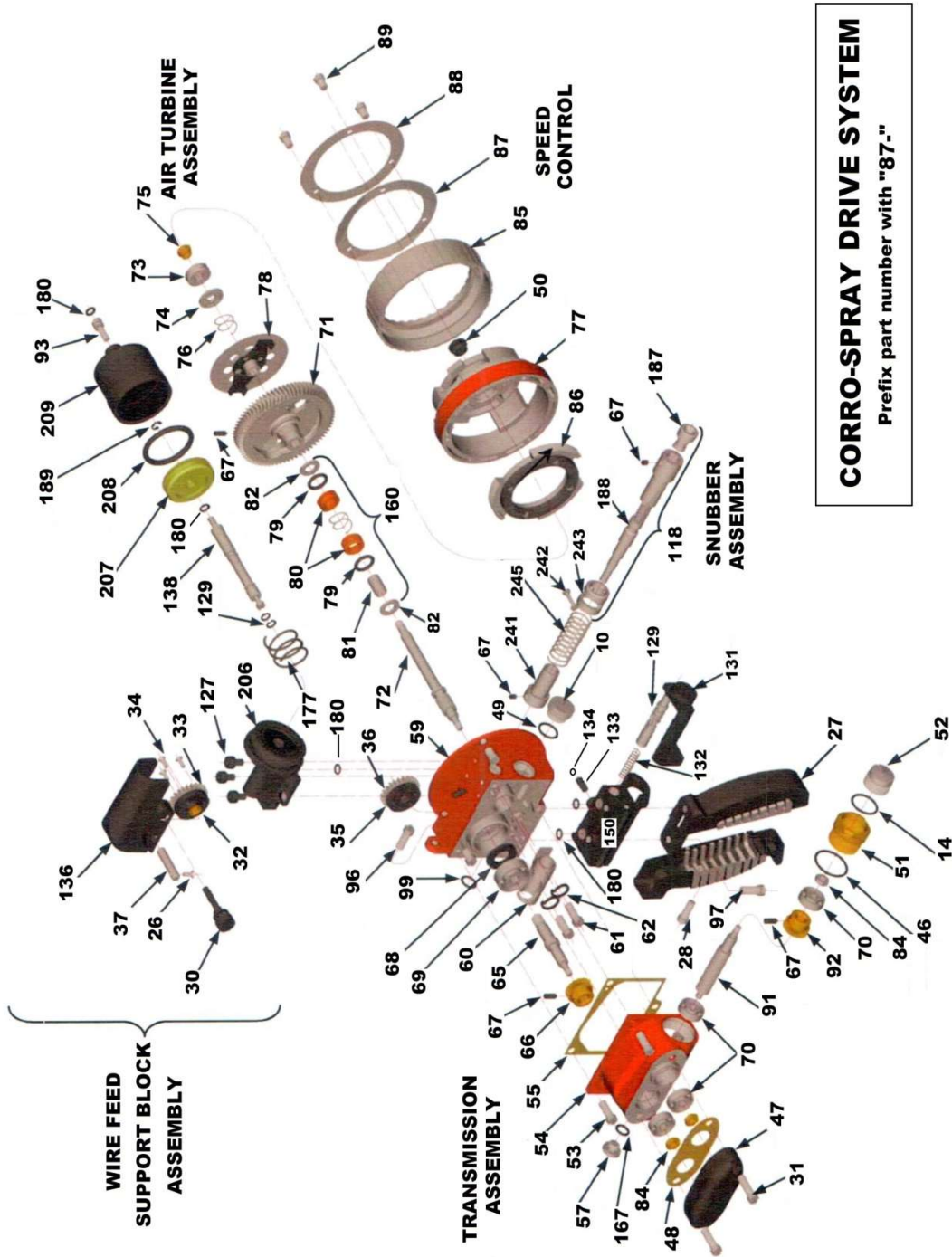
111 Valve Lube



110 Gear Lube

1.10 CORROSPRAY/11E Exploded Views (Complete)





**CORRO-SPRAY DRIVE SYSTEM**  
 Prefix part number with "87-"



**Plasma Powders & Systems, Inc.**  
**CORROSPRAY (11E Type) – Spare Parts List**

**Section 2: Routine Maintenance**

Maintenance Operation	Interval Hrs.	Remarks
Clean outside of Gun	<8	After Each Use is best
Clean off drive rolls	8	Brush off & blow out dirt & chips
Clean air cap	8	Wipe out soot. Keep interior smooth.
Clean nozzle jets	16	Use nozzle cleaning wire kit.
Clean siphon plug jets and bleeder holes	40	Use nozzle cleaning wire kit.
Oil upper drive roll axle	40	Machine Oil - 2 drops
Oil upper drive roll carrier hinge	40	Machine Oil - 1 drop.
Lube gear case	80	Gear lube - Makeup level.
Clean turbine brake disc and shoe.	200	Wipe down with cleaning solvent do not lubricate
Clean / re-lube speed control ring thread.	200	Valve lube
Clean and lube gas head valve	500	Apply thin film of valve lube.
Complete overhaul	1000	Wash out and replace all lubricants, O-rings.

**General:**

***Do not lay the torch on the Speed control side for long periods. Oil will seep through the seals and get into the Speed Control area. It's always best to store the torch in an upright position.***

***Soft wire spray (Zinc, Babbitt, Tin) will require more frequent cleaning due to dust and metal flakes gathering in the drive roll and wire passage areas.***

***When the Valve Lever gets jumpy or harder to move, remove the Valve Core, clean & lubricate.***

***Keep your Air Cap bore clean and smooth. Edges & Burs will accumulate coating material and cause problems.***



**Plasma Powders & Systems, Inc.**  
**CORROSPRAY (11E Type) – Spare Parts List**

**Section 3: Hardware Selection Guide**

**3.1 Gas Head Hardware Selection**

Fuel Gas	Wire Size	Standard			Non-Loading		
		Nozzle	Siphon Plug	Air Cap	Nozzle	Siphon Plug	Air Cap
Acetylene	3/16	87-7-7	87-2-3	87-3-AH	87-7-8	87-2-3	87-3-AH
	1/8	87-7-13	87-2-3	87-3-CH	87-7-14	87-2-3	87-3-CH
Propane – Nat. Gas	3/16	87-7-9	87-2-4	87-3-AH	87-7-10	87-2-4	87-3-AH
	1/8	87-7-15	87-2-4	87-3-CH	87-7-16	87-2-4	87-3-JH

**3.2 Wire Guides/Drive Rolls**

Wire Size	Wire Guides			Drive Rolls		Drive Gears	
	Front Guide	Snubber	Plain Rear Guide	Upper	Lower	Lower	Upper
3/16"	87-23-3/16	87-118-3/16	87-24-3/16	87-32-3/16	87-35-3/16	87-36-3/16	87-33
1/8"	87-23-1/8	87-118-1/8	87-24-1/8	87-32-1/8	87-35-1/8	87-36-1/8	87-33

Notes:

1. For individual parts to the Rear Guide & Snubber Assembly, see part list.
2. Don't use the plain Rear Guide for start/stop operation for wire under 3/16".





**Plasma Powders & Systems, Inc.**  
**CORROSPRAY (11E Type) – Spare Parts List**

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