



Plasma Powders & Systems, Inc.
WireJet-96 (12E Type) - Spare Parts List



WireJet-96 Metalizing Gun



Plasma Powders & Systems, Inc.
WireJet-96 (12E Type) – Spare Parts List

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Plasma Powders & Systems, Inc.

WireJet-96 (12E Type) – Spare Parts List

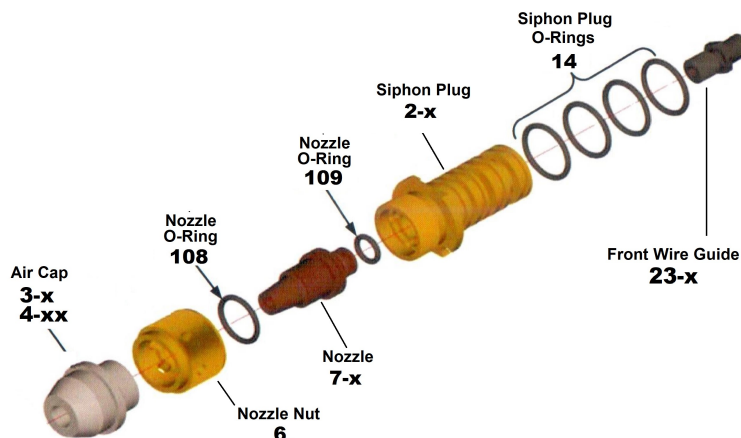
Section 1: Part Lists - Diagrams

1.1 Plasma Powders Nozzles

Part No.	Description	Part No	Description	Part No.	Description
96-7-26	ACET 1/8 N/L	96-7-30	ACET 15G 1.5MM N/L	96-7-43	PROP 3/16
96-7-27	PROP 1/8 N/L	96-7-32	PROP 15G N/L	96-7-44	MPS 3/16
96-7-29	ACET 15G 4 HOLE	96-7-35	ACET 11G 2.5MM	96-7-44P	PROP 3/16
96-7-29-15-10	ACET 15G 10 HOLE	96-7-36	ACET 11G N/L	96-7-45	ACET 3/16 N/L
96-7-29-15-6	ACET 15G 6 HOLE	96-7-37	PROP 11G	96-7-46N/L	PROP 3/16 N/L
96-7-29-15-8	ACET 15G 8 HOLE	96-7-38	PROP 11G N/L	96-7-48	ACET 1/8
96-7-29-20GA	ACET 20G	96-7-41	ACET 11G	96-7-49	PROP 1/8
		96-7-42	ACET 3/16	96-7-SPL	ACET 1/8 4 HOLE

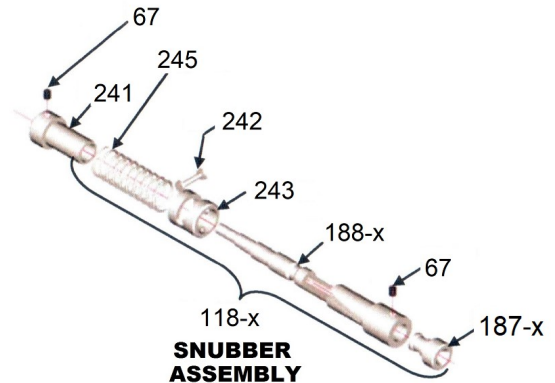
1.2 Plasma Powders Air Cap, Siphon Plug, Front Wire Guides

Part No.	Description	Part No.	Description
96-3-AH	Air Cap 3/16" N/L	96-2-5	SIPHON PLUG ACET 3/16" - 11 Ga.
96-3-C	Air Cap	96-2-6	SIPHON PLUG PROP 3/16" - 11 Ga.
96-3-CH	Air Cap 1/8" N/L	96-2-7	SIPHON PLUG ACET 15GA.
96-3-EA	Air Cap 3/16"	96-2-8	SIPHON PLUG PROP 1/16"
96-3-EC	Air Cap 1/8"		
96-3-J	Air Cap 11Ga.	96-23-1/8	FRONT WIRE GUIDE 1/8"
96-3-JH	Air Cap 11Ga. N/L	96-23-3/16	FRONT WIRE GUIDE 3/16"
96-3-M	Air Cap 15Ga.	96-23-15GA	FRONT WIRE GUIDE 15 GAUGE
96-3-MH	Air Cap 15Ga. N/L		
96-3-N	Air Cap	96-6	Nozzle Nut
96-4-AB	Air Cap Fan Spray 1/8"	96-14	O-Rings: Siphon Plug PK/6
96-4-CD	Air Cap Fan Spray 3/16"	96-108	O-Ring: Nozzle Large
		96-109	O-Ring: Nozzle Small

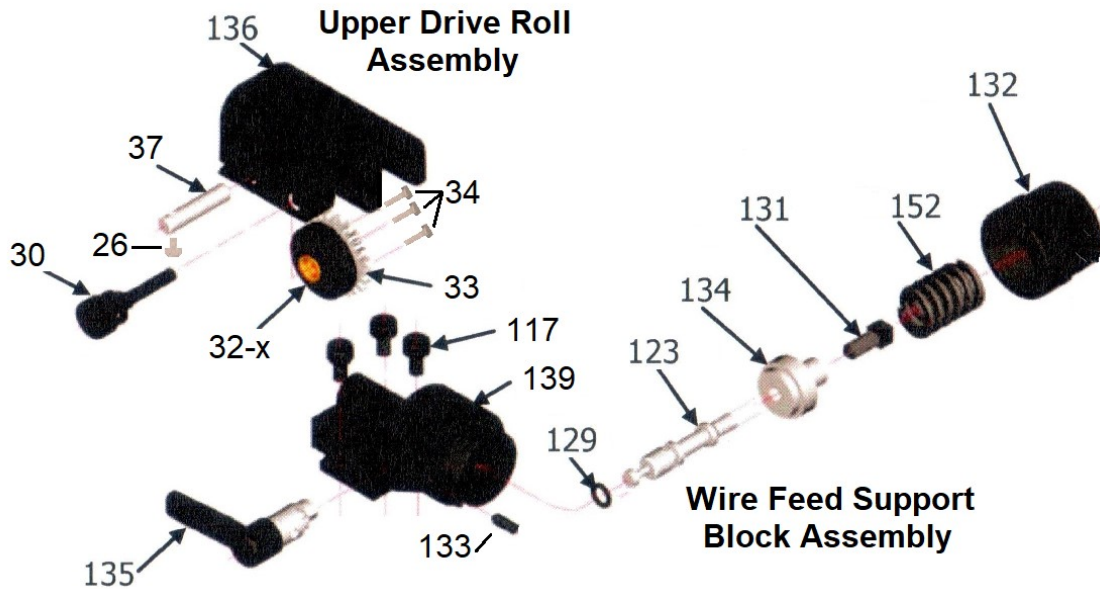


1.4 Rear Wire Guide & Snubber Assembly

Part No	Description
96-67	Set Screw PK/2
96-118-x	Snubber Assembly (15G, 1/8", 3/16")
96-187-x	Guide Insert (15G, 1/8", 3/16")
96-188-x	Snubbing Rear Guide (15G, 1/8", 3/16")
96-241	Spring Retainer
96-242	Roller
96-243	Snubber Spring Housing
96-245	Spring



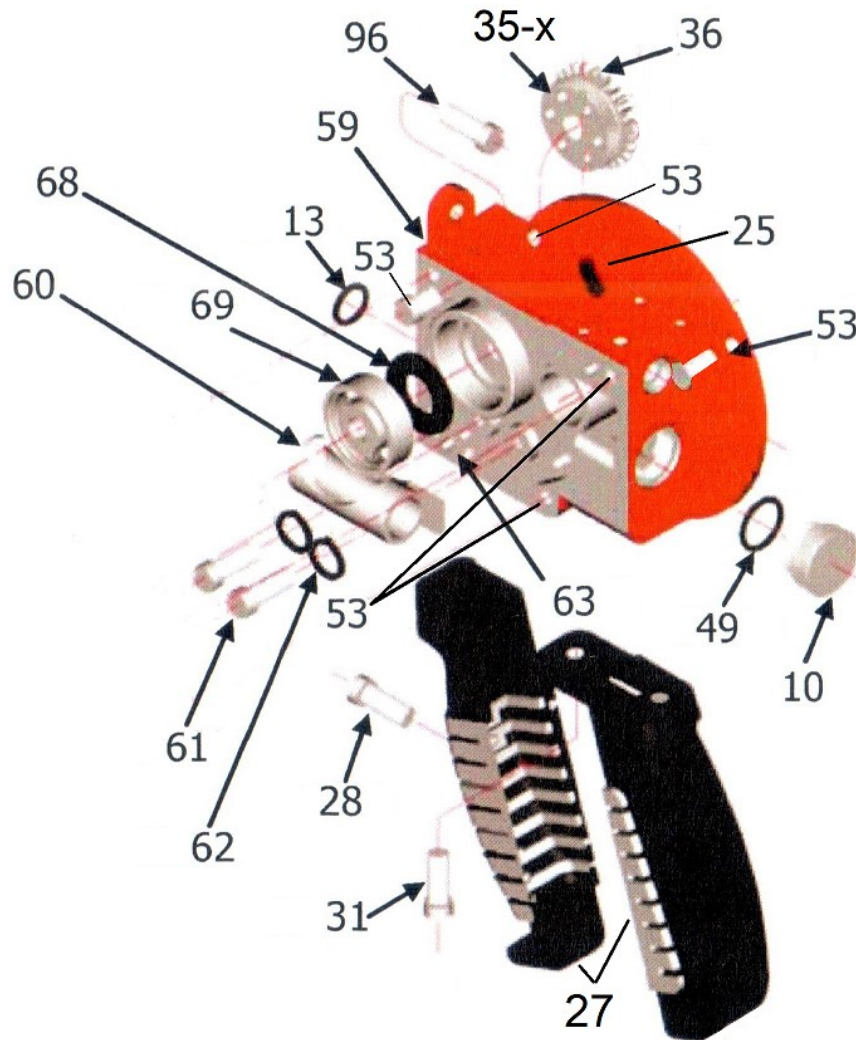
1.5 CAM, Support Block Assembly & Upper Drive Roll Carrier



Part No	Description	Part No	Description
96-26	Upper Drive Roll Axle Screw PK/5	96-131	Push rod length set screw
96-30	Drive Roll Carrier Pivot Pin	96-132	Spring Cap
96-32-x	Upper Drive Roll (15G, 1/8", 3/16")	96-133	Cam Assembly Set Screw
96-33	Upper Drive Roll Gear	96-134	Cam Follower
96-34	Upper Drive Roll Gear Screw PK/5	96-135	Cam Assembly
96-37	Upper Drive Roll Axle	96-136	Upper Drive Roll Carrier
96-117	Screws: Support Block Mount (PK/3)	96-139	Support Block
96-123	Push Rod	96-152	Spring
96-129	O-Ring: Push Rod Seal (PK/2)		

1.6 Central Housing, Lower Rolls & Gears

Part No	Description	Part No	Description
96-10	Oil Sight Plug	96-53	Gear Cover Screw PK/10
96-13	O-Ring: Gas head to Body	96-59	Central Housing
96-25	Set Screw: Snubber Assembly PK/5	96-60	Pump Housing
96-27	Torch Handle	96-61	Pump Housing Screw PK/5
96-28	Screw: Handle Cover PK/2	96-62	Pump Housing Lock Washer PK/5
96-31	Screw: Handle Mount PK/5	96-63	Gear Cover Positioning Dowel Pin PK/5
96-35-x	Lower Drive Roll (15G, 1/8", 3/16")	96-68	O-Ring: Drive Shaft Seal PK/2
96-36-x	Lower Drive Gear (15G, 1/8", 3/16")	96-69	Bearing: Drive Shaft Right
96-49	O-Ring: Oil Sight Plug PK/2		





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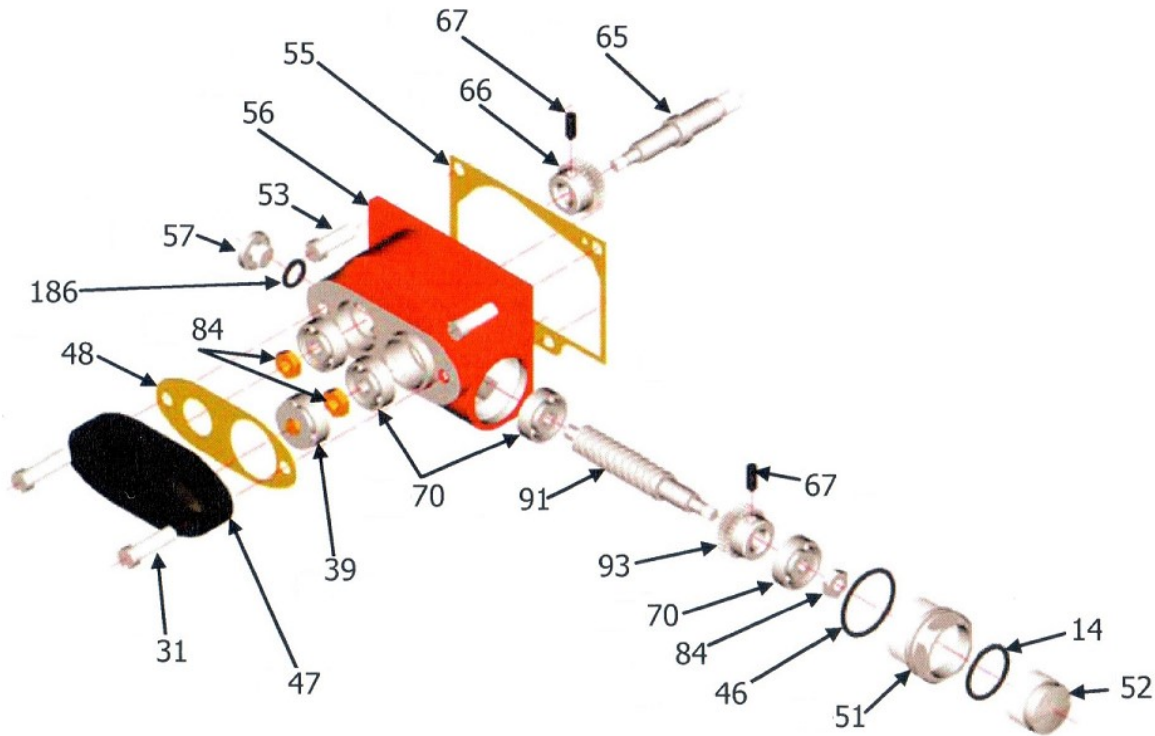
1.7 Turbine & Speed Control Assembly

Part No	Description	Part No	Description
96-50	Grease Plug Screw	96-81	Oil Seal Sleeve
96-54	Turbine Rotor (Inc. 67 Set Screw)	96-82	Oil Seal Washer PK/2
96-64	Finger Spring	96-85	Speed Control Ring
96-67	Set Screw PK/2	96-86	Spider Assembly
96-71	Control Ring Name Plate	96-87	Control Ring Detent
96-73	Turbine Bearing Right	96-89	Ring Name Plate Screw PK/5
96-74	Brake Disc Return Spring Washer	96-92-H	Turbine Shaft – High Speed
96-76	Brake Disc Return Spring	96-92-S	Turbine Shaft – Standard Speed
96-77	Turbine Cover	96-102	Turbine Bearing Nut – Right
96-78	Brake Disc	96-160	Oil Seal Assembly (Inc. 79,80,82,283)
96-79	O-Ring: Oil Seal PK/5	96-283	Oil Seal Spring
96-80	Oil Seal Bobbin		



1.9 Transmission, Cover & Countershaft Assembly

Part No	Description	Part No	Description
96-14	O-Ring: Retainer Plug PK/6	96-57	Bearing Plug Screw
96-31	Bearing Cover Screw PK/5	96-65	Drive Shaft
96-39	Bearing Follower (Not Shown)	96-66	Drive Shaft Gear
96-46	O-Ring: Bearing Retainer PK/2	96-67	Set Screw PK/2
96-47	Bearing Cover	96-70	Countershaft & Drive Shaft Bearings
96-48	Bearing Cover Gasket	96-84	Counter/Drive Shaft Nut PK/5
96-51	Bearing Retainer – Rear	96-91	Countershaft
96-52	Retainer/Bearing Plug – Rear	96-93-H	Countershaft Gear – High Speed
96-53	Trans Cover Screws PK/5	96-93-S	Countershaft Gear – Standard Speed
96-55	Transmission Gear Cover Gasket	96-186	O-Ring: Plug Screw
96-56	Transmission Gear Cover		



1.11 Tools & Lubricants/ Tool Post Fixture

Part No	Description	Part No	Description
96-101	Lighter	96-114	Cleaning Wire Kit
96-103	Drive Roll Tool	96-124	Tool Post
96-110	Gear Lube PK/3	96-55810	Spanner Wrench
96-111	Valve Lube		



114 Wire Cleaning Kit



101 Spark Lighter



124 Tool Post



55810 Spanner

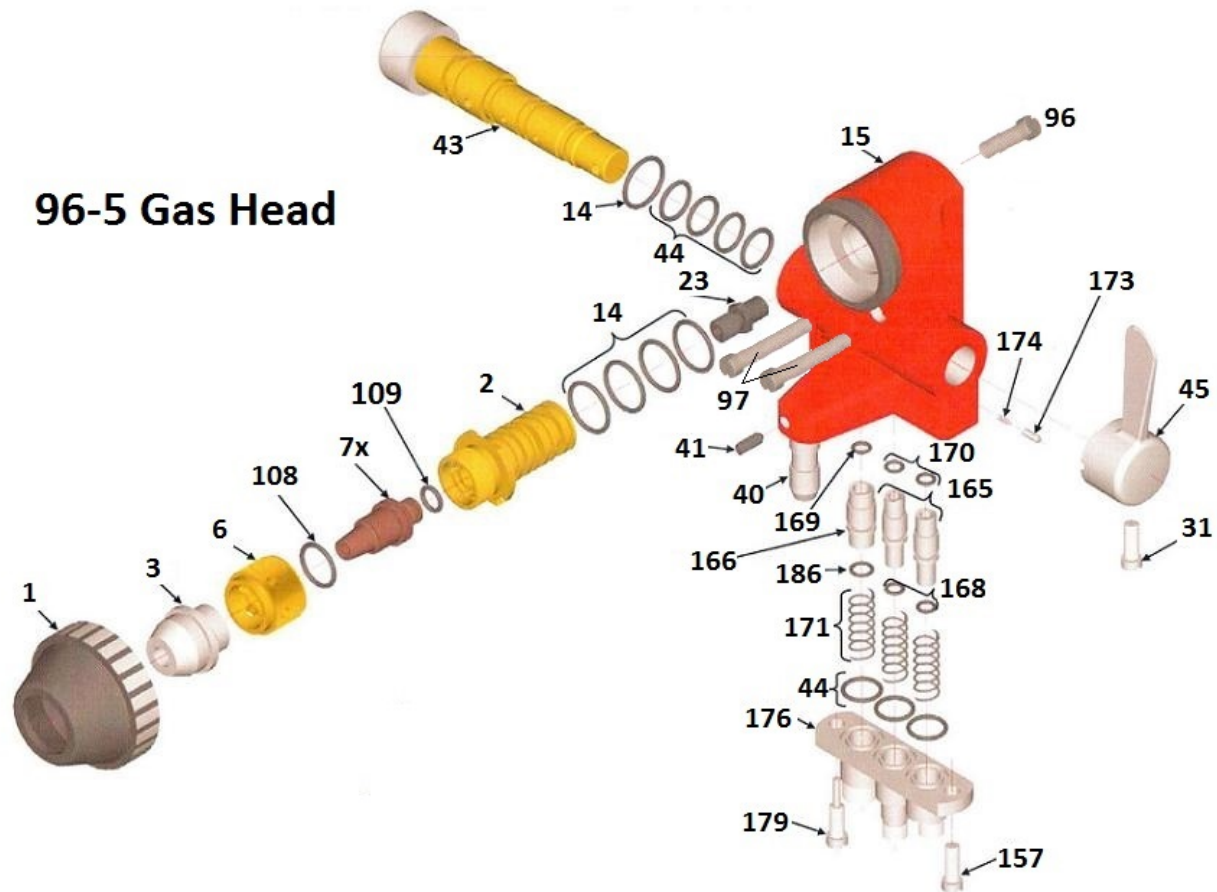


111 Valve Lube

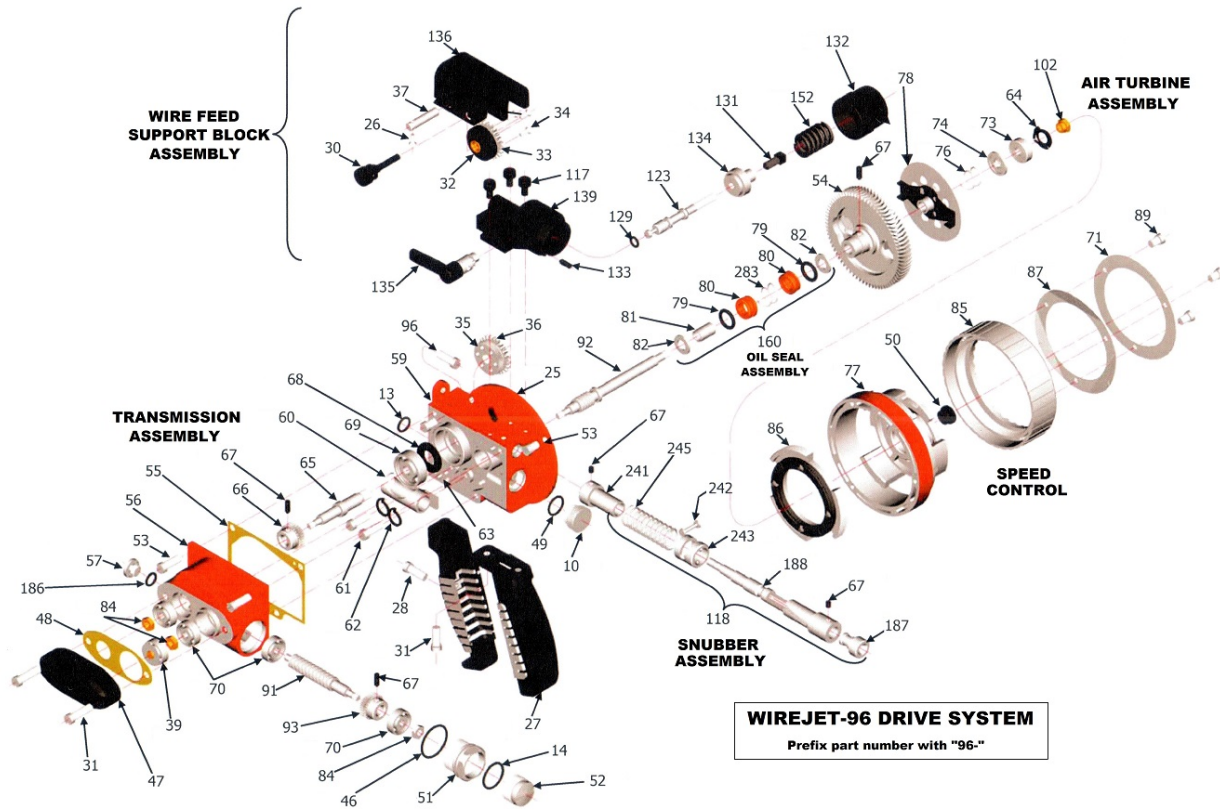


110 Gear Lube

1.12 Exploded Views



Wire Drive





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Section 3: 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.



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Section 4: Hardware Selection Guide

Wire Guide and Drive Rolls

Wire Size	Wire Guides			Drive Rolls		Lower Drive Roll Gears
	Front Guide	Rear Guide & Snubber Assembly	Plain Rear Guide	Upper	Lower	
3/16"	96-23-3/16	96-118-3/16	96-24-3/16 & 96-187-3/16	96-32-3/16	96-35-3/16	96-36-3/16
1/8" & 11Ga.	96-23-1/8	96-118-1/8	96-24-1/8	96-32-1/8	96-35-1/8	96-36-1/8
15 Ga.	96-23-15	96-118-15	96-24-15	96-32-1/8	96-35-15	96-36-1/8

Notes:

1. For individual parts to the Rear Guide & Snubber Assembly, see part list.
2. *Never* use the plain Rear Guide for start/stop operation.
3. Use Upper Drive Roll Gear 96-33 for ALL setups.

Gas Head Hardware Selection

Fuel Gas	Wire Size	Standard			Non-Loading		
		Nozzle	Siphon Plug	Air Cap	Nozzle	Siphon Plug	Air Cap
Acetylene	3/16	96-7-42	96-2-5	96-3-EA	96-7-45	96-2-5	96-3-AH
	1/8	96-7-48	96-2-5	96-3-EC	96-7-26	96-2-5	96-3-CH
	11 Ga.	96-7-35	96-2-5	96-3-J	96-7-36	96-2-5	96-3-JH
	15 Ga.	96-7-29	96-2-7	96-3-M	96-7-30	96-2-7	96-3-JH or MH
Propane or Natural Gas	3/16	96-7-43	96-2-6	96-3-EA	96-7-46	96-2-6	96-3-AH
	1/8	96-7-49	96-2-6	96-3-EC	96-7-27	96-2-6	96-3-CH
	11 Ga.	96-7-37	96-2-6	96-3-J	96-7-38	96-2-6	96-3-JH
	15 Ga.	96-7-31	96-2-8	96-3-M	96-7-32	96-2-8	96-3-JH or MH

Standard/Non Loading Air Cap Equivalency Chart - Acetylene and Propane

Standard Air Cap	Equivalent Non-Loading Air Cap
EA	AH
EC	CH
J	JH
M	JH
C	CH



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