



Plasma Powders & Systems, Inc.  
WireJet-98 (14E Type) - Spare Parts List



# WireJet-98 Metalizing Gun



**Plasma Powders & Systems, Inc.**  
**WireJet-98 (14E Type) – Spare Parts List**

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# Plasma Powders & Systems, Inc. WireJet-98 (14E Type) – Spare Parts List

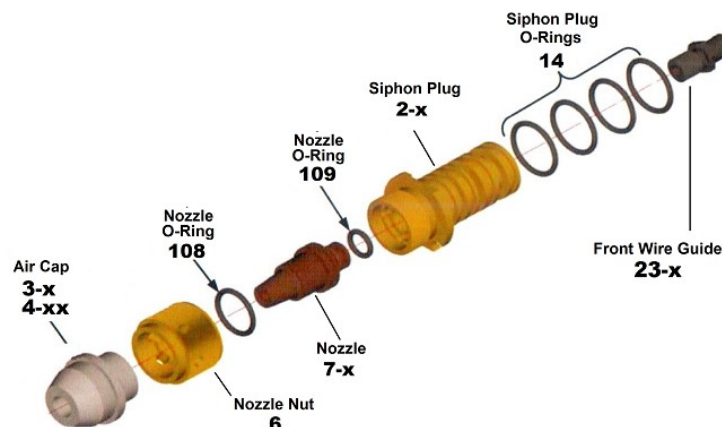
## Section 1: Part Lists - Diagrams

### 1.1 Plasma Powders Nozzles

Part No.	Description	Part No.	Description	Part No.	Description
98-7-26	ACET 1/8 N/L	98-7-30	ACET 15G 1.5MM N/L	98-7-43	PROP 3/16
98-7-27	PROP 1/8 N/L	98-7-32	PROP 15G N/L	98-7-44	MPS 3/16
98-7-29	ACET 15G 4 HOLE	98-7-35	ACET 11G 2.5MM	98-7-44P	PROP 3/16
98-7-29-15-10	ACET 15G 10 HOLE	98-7-36	ACET 11G N/L	98-7-45	ACET 3/16 N/L
98-7-29-15-6	ACET 15G 6 HOLE	98-7-37	PROP 11G	98-7-46N/L	PROP 3/16 N/L
98-7-29-15-8	ACET 15G 8 HOLE	98-7-38	PROP 11G N/L	98-7-48	ACET 1/8
98-7-29-20GA	ACET 20G	98-7-41	ACET 11G	98-7-49	PROP 1/8
		98-7-42	ACET 3/16	98-7-SPL	ACET 1/8 4 HOLE

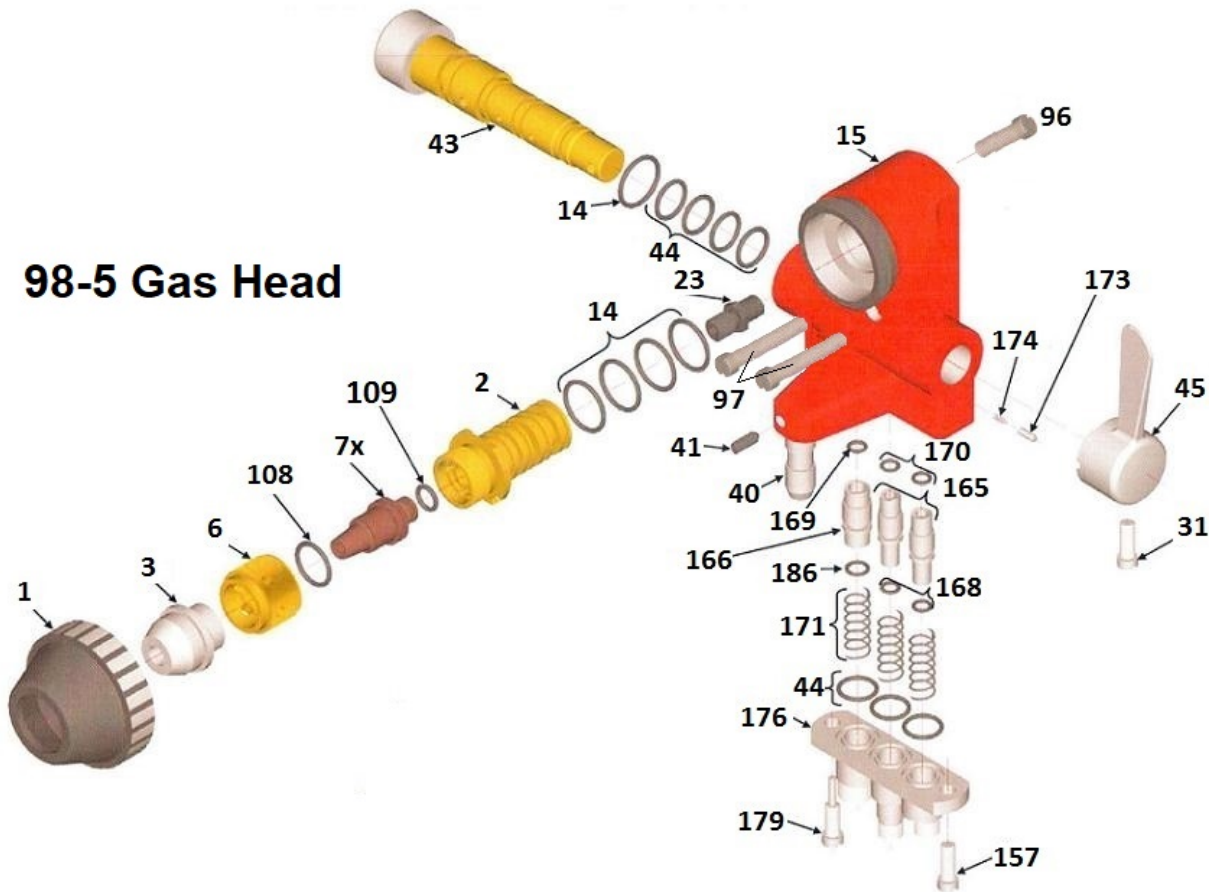
### 1.2 Plasma Powders Air Cap, Siphon Plug, Front Wire Guides

Part No.	Description	Part No.	Description
98-3-AH	Air Cap 3/16" N/L	98-2-5	SIPHON PLUG ACET 3/16" - 11 Ga.
98-3-C	Air Cap	98-2-6	SIPHON PLUG PROP 3/16" - 11 Ga.
98-3-CH	Air Cap 1/8" N/L	98-2-7	SIPHON PLUG ACET 15GA.
98-3-EA	Air Cap 3/16"	98-2-8	SIPHON PLUG PROP 1/16"
98-3-EC	Air Cap 1/8"		
98-3-J	Air Cap 11Ga.	98-23-1/8	FRONT WIRE GUIDE 1/8"
98-3-JH	Air Cap 11Ga. N/L	98-23-3/16	FRONT WIRE GUIDE 3/16"
98-3-M	Air Cap 15Ga.	98-23-15GA	FRONT WIRE GUIDE 15 GAUGE
98-3-MH	Air Cap 15Ga. N/L		
98-3-N	Air Cap	98-6	Nozzle Nut
98-4-AB	Air Cap Fan Spray 1/8"	98-14	O-Rings: Siphon Plug PK/6
98-4-CD	Air Cap Fan Spray 3/16"	98-108	O-Ring: Nozzle Large
		98-109	O-Ring: Nozzle Small



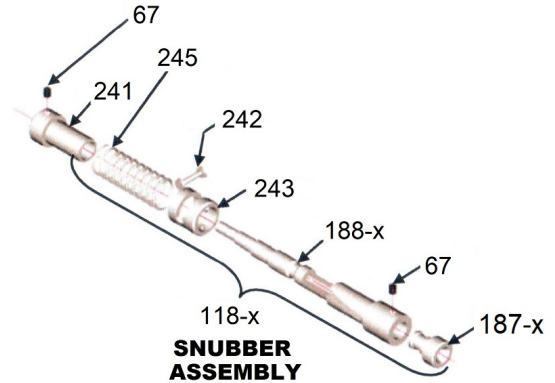
**1.3 Gas Head/Hose Connection Block/Valve Core**

Part No	Description	Part No	Description
98-1	Air Cap Body	98-97	Gas Head Mount Screw, Front PK/5
98-2-x	See Siphon Plugs (Section 1.2)	98-157	Hose Connection Block Mount Screw
98-3-x	See Air Caps (Section 1.2)	98-165	Plunger (Fuel Gas & Oxygen)
98-5	Gas Head Assembly	98-166	Plunger (Air)
98-7-xx	See Nozzles (Section 1.1)	98-168	O-Ring: Fuel & Oxy Plungers
98-14	O-Ring: Siphon Plug/Valve Core PK/6	98-169	O-Ring: Air Plunger Seal
98-15	Gas Head Body (includes 98-40, 98-41)	98-170	O-Ring: Fuel & Oxy Plunger Seal
98-23-x	See Front Wire Guide (Section 1.2)	98-171	Plunger Spring PK/3
98-31	Valve Handle Screw PK/5	98-173	Detent Pin
98-40	Mounting Stud	98-174	Detent Pin Spring
98-41	Mounting Stud Roll Pin	98-176	Hose Connection Block
98-43	Valve Core (With O-Rings)	98-179	Valve Core Stop Screw
98-44	O-Ring: Valve Core/Hose Connection Block PK/7	98-184	O-Ring Set – Complete, PK/36
98-45	Valve Handle	98-186	O-Ring: Air Plunger
98-96	Gas Head Mount Screw, Rear PK/5		

**98-5 Gas Head**


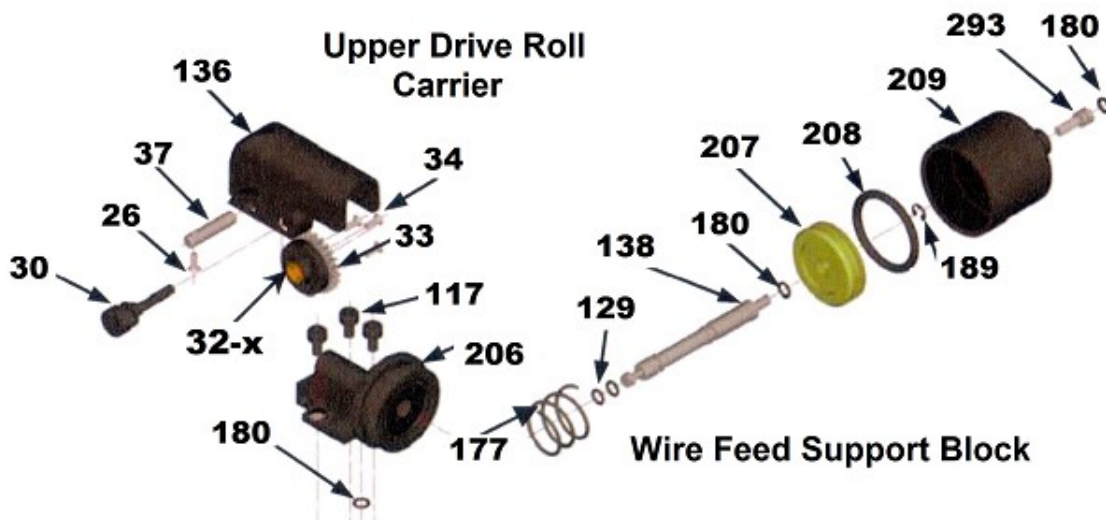
### 1.4 Rear Wire Guide & Snubber Assembly

Part No	Description
98-67	Set Screw PK/2
98-118-x	Snubber Assembly (15G, 1/8", 3/16")
98-187-x	Guide Insert (15G, 1/8", 3/16")
98-188-x	Snubbing Rear Guide (15G, 1/8", 3/16")
98-241	Spring Retainer
98-242	Roller
98-243	Snubber Spring Housing
98-245	Spring



### 1.5 CAM, Support Block Assembly & Upper Drive Roll Carrier

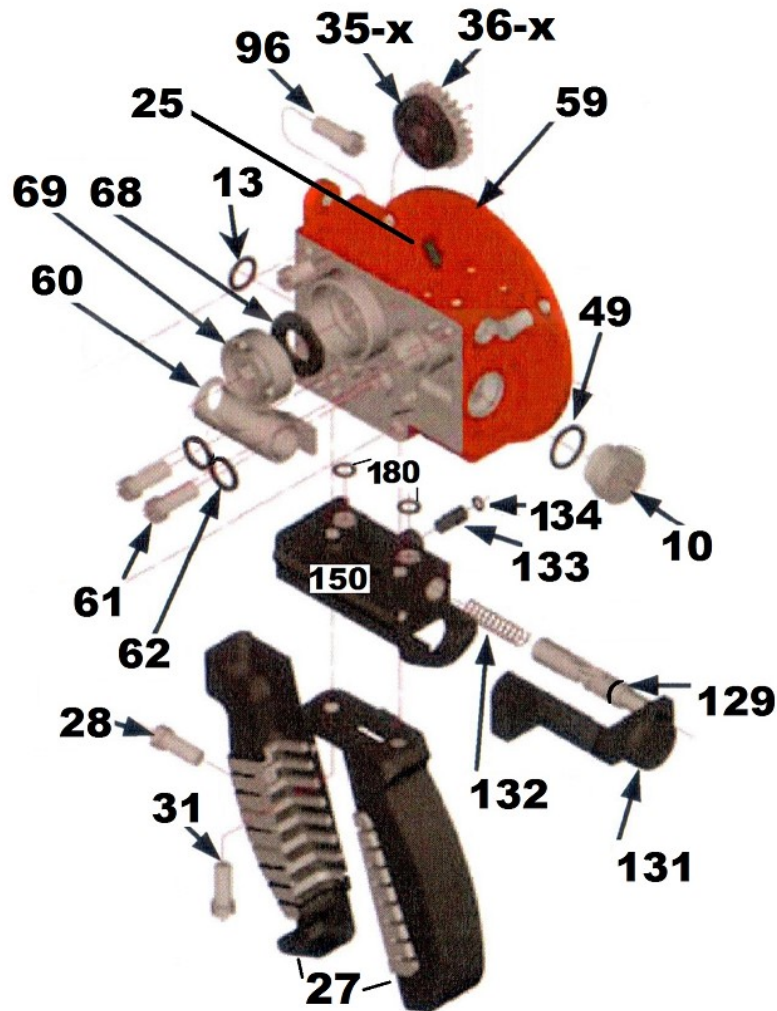
Part No	Description	Part No	Description
98-26	Upper Drive Roll Axle Screw PK/5	98-138	Piston Rod
98-30	Drive Roll Carrier Pivot Pin	98-177	Piston Rod Return Spring
98-32-x	Upper Drive Roll (15G, 1/8", 3/16")	98-180	O-Ring: Tension Adjustment Screw PK/2
98-33	Upper Drive Roll Gear	98-189	Retainer Lock Ring PK/2
98-34	Upper Drive Roll Gear Screw PK/5	98-206	Cylinder Support Block
98-37	Upper Drive Roll Axle	98-207	Piston
98-117	Screws: Support Block Mount (PK/3)	98-208	O-Ring: Piston PK/3
98-129	O-Ring: Piston Rod Seal (PK/2)	98-209	Cylinder Cap
98-136	Upper Drive Roll Carrier	98-293	Piston Stop Screw





### 1.6 Central Housing, Lower Rolls & Gears

Part No	Description	Part No	Description
98-10	Oil Sight Plug	98-62	Pump Housing Lock Washer PK/5
98-13	O-Ring: Gas head to Body	98-63	Gear Cover Positioning Dowel Pin PK/5
98-25	Set Screw: Snubber Assembly PK/5	98-68	O-Ring: Drive Shaft Seal PK/2
98-27	Torch Handle	98-69	Bearing: Drive Shaft Right
98-28	Screw: Handle Cover PK/2	98-96	Screw: Gas head Mount (Rear)
98-31	Screw: Handle Mount PK/5	98-129	O-Ring: Piston Rod PK/3
98-35-x	Lower Drive Roll (15G, 1/8", 3/16")	98-131	Valve Shaft (Trigger)
98-36-x	Lower Drive Gear (15G, 1/8", 3/16")	98-132	Valve Shaft Spring
98-49	O-Ring: Oil Sight Plug PK/2	98-133	Cam Follower Screw
98-53	Gear Cover Screw PK/10	98-134	O-Ring: Cam Follower Screw
98-59	Central Housing	98-150	Wire Grip Valve Block
98-60	Pump Housing	98-180	O-Ring: Wire Grip Valve Block PK/2
98-61	Pump Housing Screw PK/5		



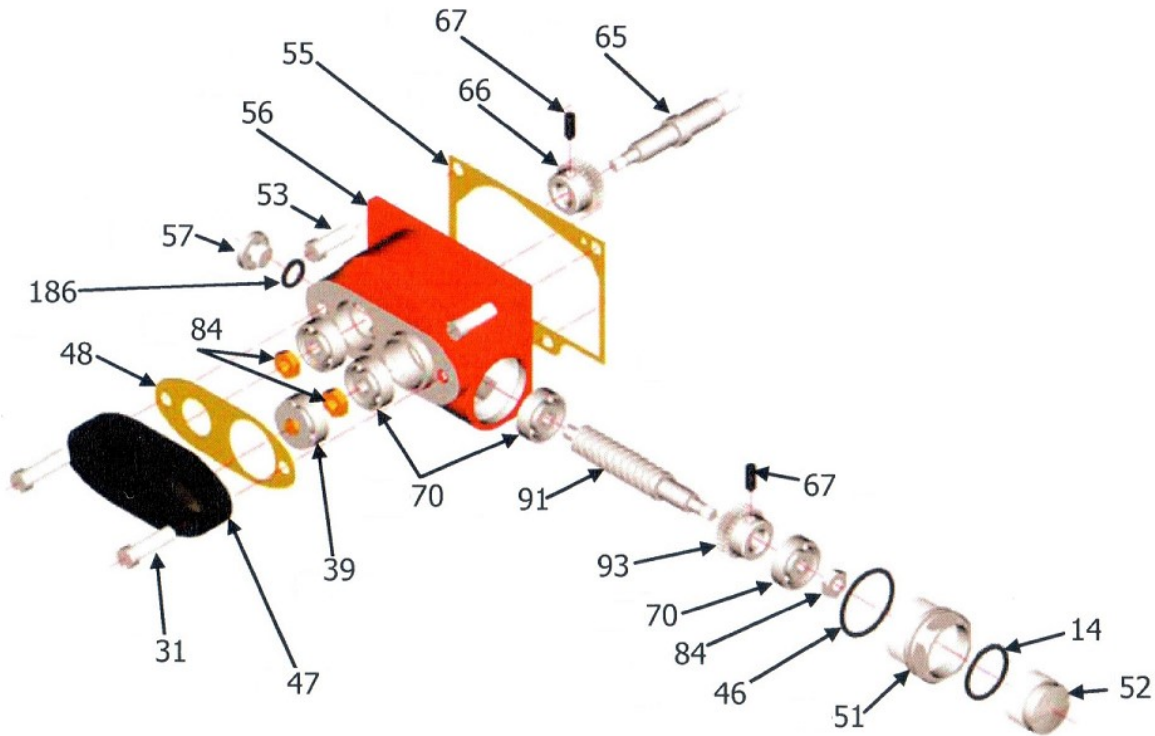
**1.7 Turbine & Speed Control Assembly**

Part No	Description	Part No	Description
98-50	Grease Plug Screw	98-81	Oil Seal Sleeve
98-54	Turbine Rotor (Inc. 67 Set Screw)	98-82	Oil Seal Washer PK/2
98-64	Finger Spring	98-85	Speed Control Ring
98-67	Set Screw PK/2	98-86	Spider Assembly
98-71	Control Ring Name Plate	98-87	Control Ring Detent
98-73	Turbine Bearing Right	98-89	Ring Name Plate Screw PK/5
98-74	Brake Disc Return Spring Washer	98-92-H	Turbine Shaft – High Speed
98-76	Brake Disc Return Spring	98-92-S	Turbine Shaft – Standard Speed
98-77	Turbine Cover	98-102	Turbine Bearing Nut – Right
98-78	Brake Disc	98-160	Oil Seal Assembly (Inc. 79,80,82,283)
98-79	O-Ring: Oil Seal PK/5	98-283	Oil Seal Spring
98-80	Oil Seal Bobbin		



**1.8 Transmission, Cover & Countershaft Assembly**

Part No	Description	Part No	Description
98-14	O-Ring: Retainer Plug PK/6	98-57	Bearing Plug Screw
98-31	Bearing Cover Screw PK/5	98-65	Drive Shaft
98-39	Bearing Follower (Not Shown)	98-66	Drive Shaft Gear
98-46	O-Ring: Bearing Retainer PK/2	98-67	Set Screw PK/2
98-47	Bearing Cover	98-70	Countershaft & Drive Shaft Bearings
98-48	Bearing Cover Gasket	98-84	Counter/Drive Shaft Nut PK/5
98-51	Bearing Retainer – Rear	98-91	Countershaft
98-52	Retainer/Bearing Plug – Rear	98-93-H	Countershaft Gear – High Speed
98-53	Trans Cover Screws PK/5	98-93-S	Countershaft Gear – Standard Speed
98-55	Transmission Gear Cover Gasket	98-186	O-Ring: Plug Screw
98-56	Transmission Gear Cover		





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

Part No	Description	Part No	Description
98-101	Lighter	98-114	Cleaning Wire Kit
98-103	Drive Roll Tool	98-124	Tool Post
98-110	Gear Lube PK/3	98-55810	Spanner Wrench
98-111	Valve Lube		



**114 Wire Cleaning Kit**



**101 Spark Lighter**



**124 Tool Post**



**55810 Spanner**



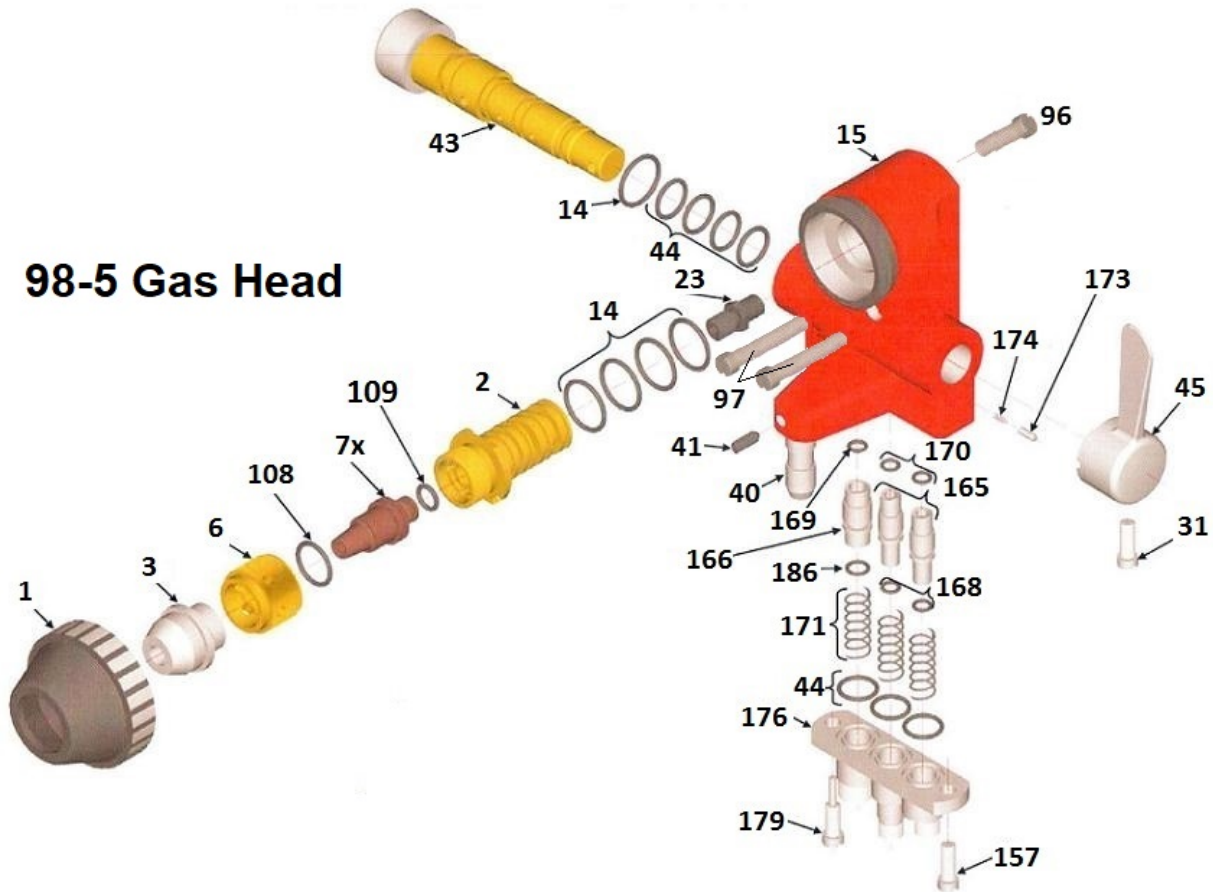
**110 Gear Lube**



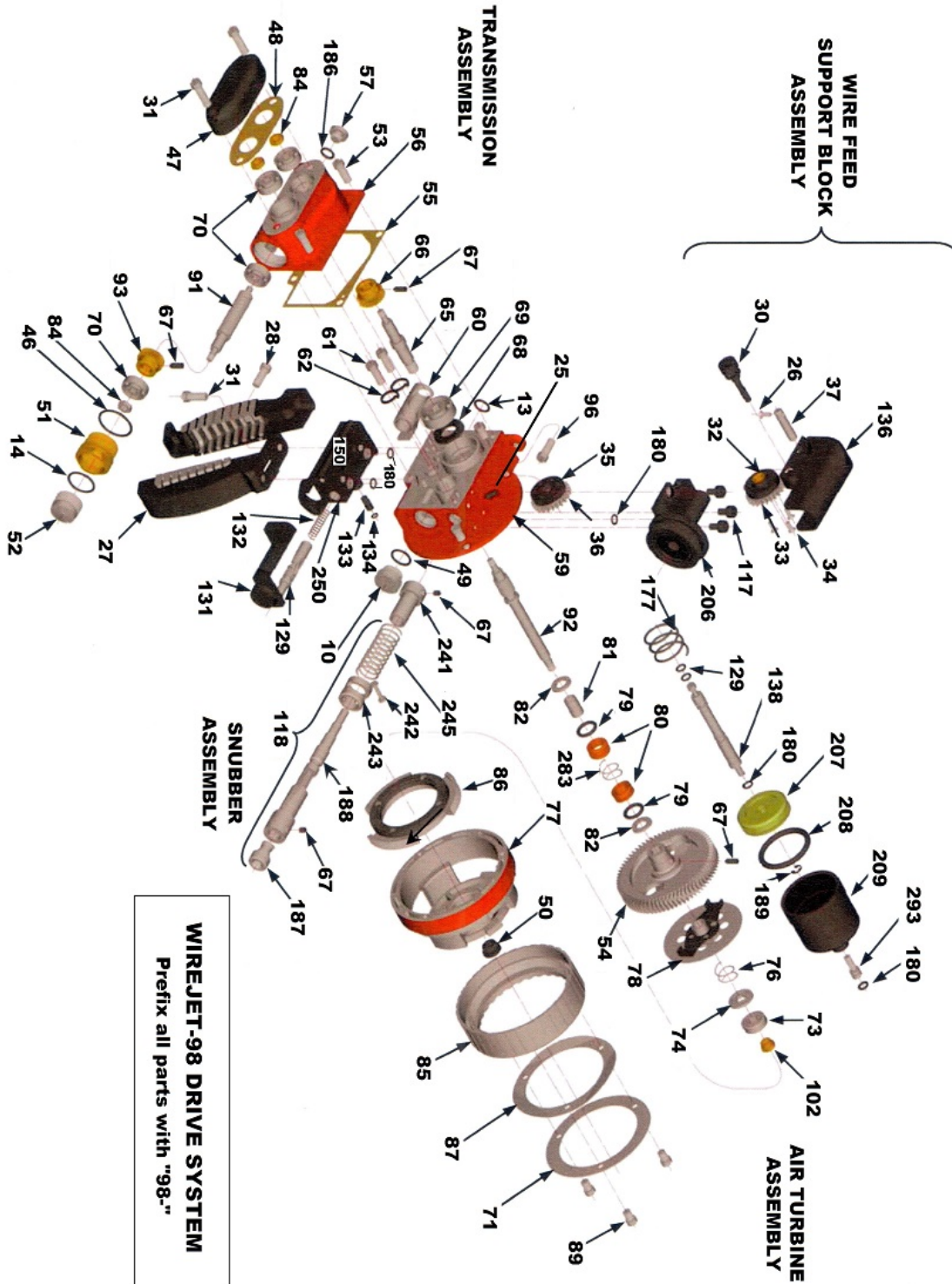
**111 Valve Lube**

**1.10 Exploded Views**

**98-5 Gas Head**



**Wire Drive**





## Plasma Powders & Systems, Inc. WireJet-98 (14E 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. WireJet-98 (14E Type) – Spare Parts List

### Section 3: 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"	98-23-3/16	98-118-3/16	98-24-3/16 & 98-187-3/16	98-32-3/16	98-35-3/16	98-36-3/16
1/8" & 11Ga.	98-23-1/8	98-118-1/8	98-24-1/8	98-32-1/8	98-35-1/8	98-36-1/8
15 Ga.	98-23-15	98-118-15	98-24-15	98-32-1/8	98-35-15	98-36-1/8

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 98-33 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	98-7-42	98-2-5	98-3-EA	98-7-45	98-2-5	98-3-AH
	1/8	98-7-48	98-2-5	98-3-EC	98-7-26	98-2-5	98-3-CH
	11 Ga.	98-7-35	98-2-5	98-3-J	98-7-36	98-2-5	98-3-JH
	15 Ga.	98-7-29	98-2-7	98-3-M	98-7-30	98-2-7	98-3-JH or MH
Propane or Natural Gas	3/16	98-7-43	98-2-6	98-3-EA	98-7-46	98-2-6	98-3-AH
	1/8	98-7-49	98-2-6	98-3-EC	98-7-27	98-2-6	98-3-CH
	11 Ga.	98-7-37	98-2-6	98-3-J	98-7-38	98-2-6	98-3-JH
	15 Ga.	98-7-31	98-2-8	98-3-M	98-7-32	98-2-8	98-3-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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