

SULZER

Sulzer Metco

14E / 14E-H / 14E-P Spray Gun Wire Combustion

**Parts List
PL 40887 EN 05**



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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.

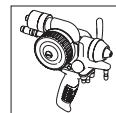


Warranty Disclaimer

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

Document no.	Version	Reason for revision	Date
PL 40887 EN 05	5	3XT removed	02/2005
PL 40887 EN 04	4	Add new seal and 14E-P (ECN 11840)	09/2004
57924,a	3	Change of standard parts for 14E-H	10/2003
958143-22	2	Correction of art. #, assignment of standard and optional parts	11/2002
958143-21	1	New parts list	08/2002

Spray Gun



14E Complete Spray Gun	(14E)	1000309
14E-H Complete Spray Gun (high speed, zinc and babbitt only)	(14E-H)	1000323
14E-P Complete Spray Gun (3/16" propane)	(14E-P)	1036964

1 List of recommended spare parts

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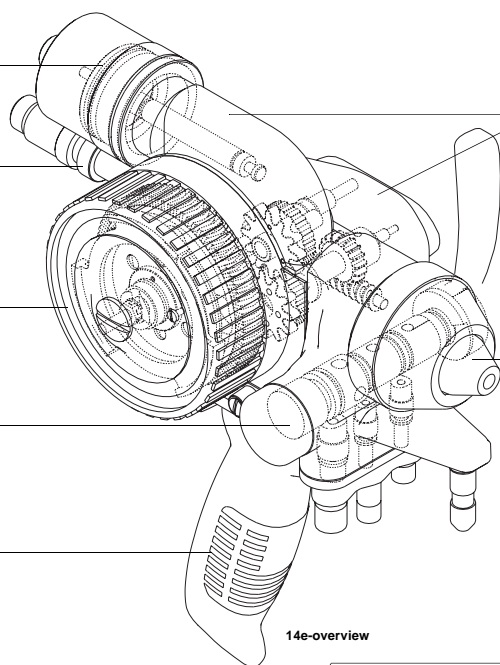
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1 List of recommended spare parts for 14E / 14E-H / 14E-P Spray Gun

Parts depending on parameters

Designation	Qty	Cat	Old Art. no.	Art. no.
Air cap	1	C	See page 5	
Siphon plug assembly	1	C	See page 5	
Nozzle	1	C	See page 7	
Front wire guide	1	C	See page 9	
Upper drive roll	1	C	See page 14	
Lower drive roll	1	C	See page 14	

Illustrated parts

Pos.	Designation	Qty	Cat	Old Art. no.	Art. no.
1, 13, 95	Siphon plug O-rings (pkg. of 4)	4	C	14E14	1000143
2	Nozzle O-ring, small (pkg. of 2)	1	W	14E109	1004714
3	Nozzle O-ring, large (pkg. of 2)	1	W	14E108	1000138
10	Snubber roller	1	C	14E242	1001443

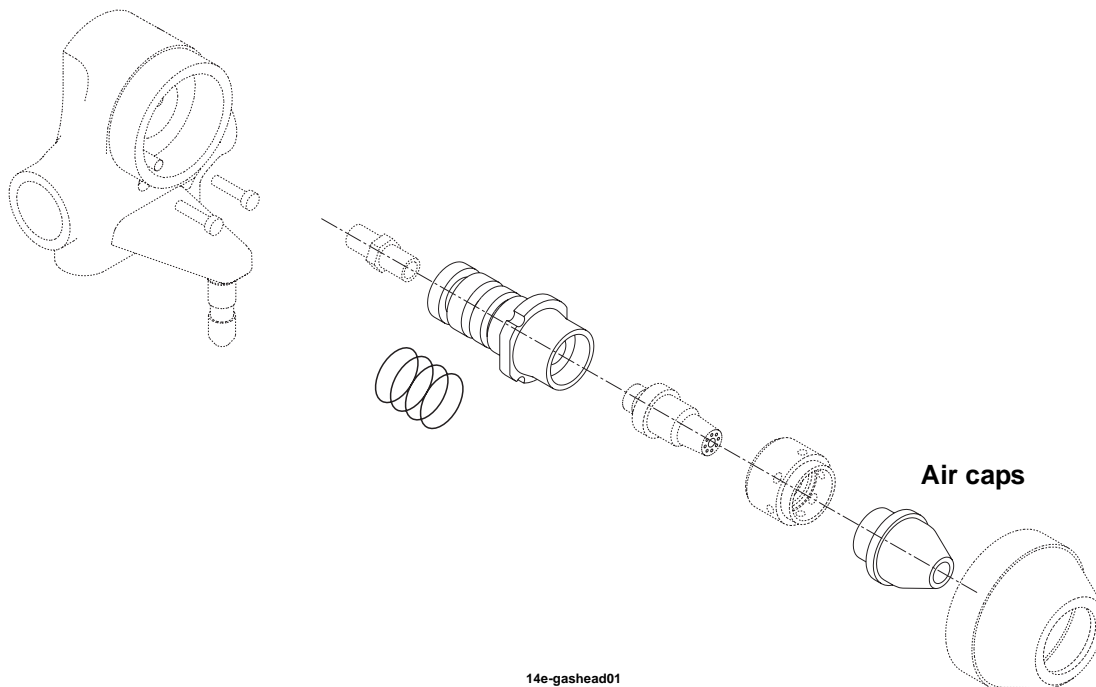
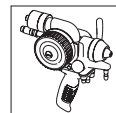
(For illustration, see respective position in section 3)

Tools and miscellaneous

Designation	Qty	Cat	Old Art. no.	Art. no.
Gearlube (pkg. of 3)	1	W	14E110	1000245
Valvelube (pkg. of 3)	1	W	14E111	1000816
Siphon plug and nozzle O-ring package	1	W	14E190	1000152

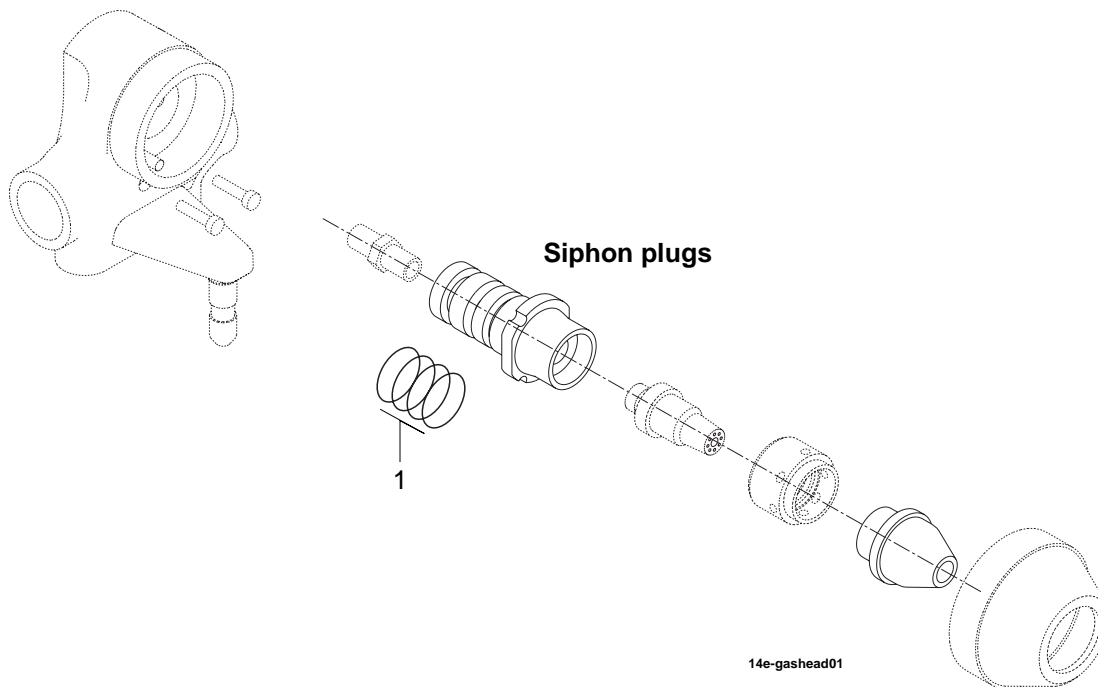
2 Parts list for 14E / 14E-H / 14E-P Spray Gun

2.1 Air caps



Designation	Old Art. no.	Art. no.
Air Caps "Standard"		
Standard with 14E		
EC 1/8"	14E3-EC	1001570
C 1/8" (bond coat)	14E3-C	1002413
Standard with 14E-P		
EA 3/16"	14E3-EA	1000666
Option		
J 11 Ga. / 15 Ga.	14E3-J	1000835
M 15 Ga.	14E3-M	1000836
AM 3/16" MPS	14E3-AM	1000663
Air Caps "Non-load"		
Standard with 14E-H		
CH Non-Load 1/8"	14E3-CH	1000664
Standard with 14E-P		
AH Non-Load 3/16"	14E3-AH	1000662
Option		
JH Non-Load 11 Ga.	14E3-JH	1000667
MH Non-Load 15 Ga.	14E3-MH	1000668
AHM Non-Load 3/16" MPS	14E3-AHM	--
CHM Non-Load 1/8" MPS	14E3-CHM	1000665
Air Caps "Fan Spray" (Option)		
AB Fan Spray 3/16"	14E4-AB	1002414
CD Fan Spray 1/8"	14E4-CD	1000841

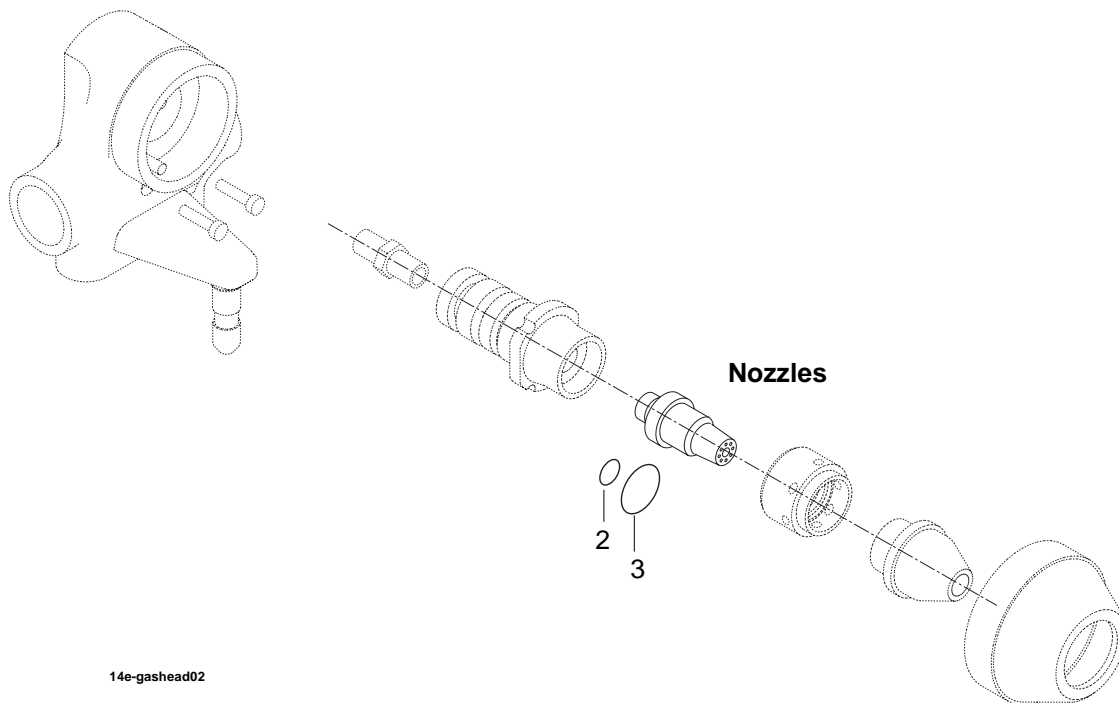
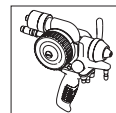
2.2 Siphon plugs



Pos	Designation	Qty	Old Art. no.	Art. no.
1	Siphon plug O-ring	4	14E14	1000143
--	Reseal kit (O-rings siphon plug, nozzle) <i>includes pos. 1, 2, 3</i>	1	14E190	1000152

Siphon plugs				
Standard with 14E				
	Siphon plug large gauge - Acetylene		14E2-5	1000259
Standard with 14E-H				
	Siphon plug large gauge - Acetylene		14E2-5	1000259
Standard with 14E-P				
	Siphon plug large gauge - Propane/MPS		14E2-6	1000260
Option				
	Siphon plug small gauge - Acetylene		14E2-7	1000261
	Siphon plug small gauge - Propane/MPS		14E2-8	1000262

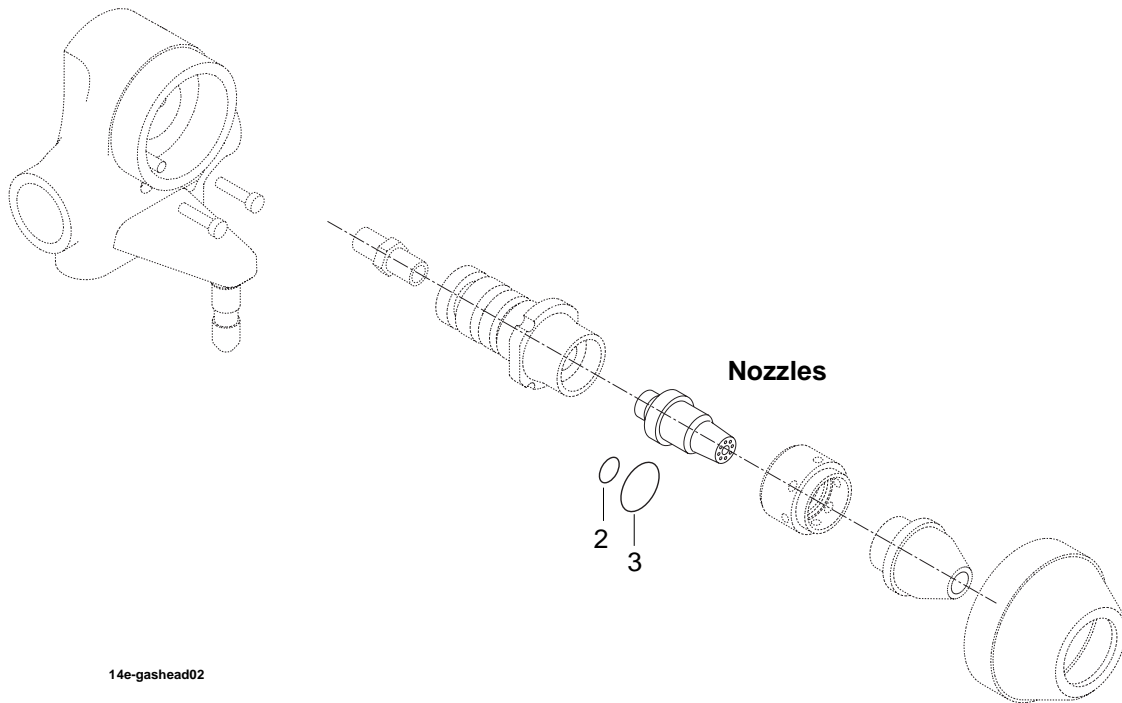
2.3 Nozzles



Pos	Designation	Qty	Old Art. no.	Art. no.
2	O-ring	1	14E109	1004714
3	O-ring	1	14E108	1000138
--	Reseal kit (O-rings siphon plug, nozzle) <i>includes pos. 1, 2, 3</i>	1	14E190	1000152

Nozzles				
Standard with 14E				
1/8"	Acetylene		14E7-48	1000290
Standard with 14E-H				
1/8"	Acetylene		14E7-48	1000290
Standard with 14E-P				
3/16"	Propane		14E7-43	1000286
Option				
5/32"	Acetylene		14E7-51	1004756
3/16"	Acetylene		14E7-42	1000285
11 Ga.	Acetylene		14E7-35	1000280
15 Ga.	Acetylene		14E7-29	1000275
5/32"	Propane		14E7-52	1000320
1/8"	Propane		14E7-49	1000291
11 Ga.	Propane		14E7-37	1000282
15 Ga.	Propane		14E7-31	1000277
3/16"	MPS		14E7-44	1031129
1/8"	MPS		14E7-25	1000272
11 Ga.	MPS		14E7-39	1004743
15 Ga.	MPS		14E7-33	1000279

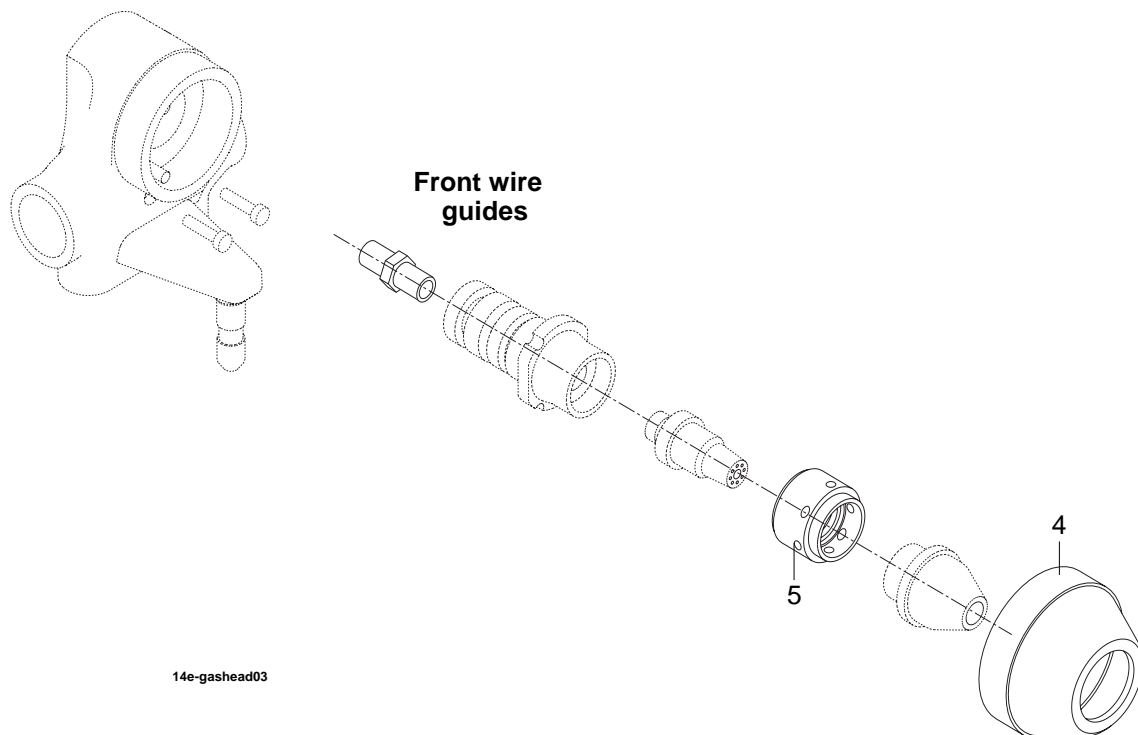
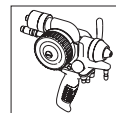
Additional nozzles listed on next page



Pos	Designation	Qty	Old Art. no.	Art. no.
2	O-ring	1	14E109	1004714
3	O-ring	1	14E108	1000138
--	Reseal kit (O-rings siphon plug, nozzle) <i>includes pos. 1, 2, 3</i>	1	14E190	1000152

Nozzles (Option)				
	3/16"	Acetylene (Non-Load)	14E7-45	1000287
	1/8"	Acetylene (Non-Load)	14E7-26	1000273
	11 Ga.	Acetylene (Non-Load)	14E7-36	1000281
	15 Ga.	Acetylene (Non-Load)	14E7-30	1000276
	3/16"	Propane (Non-Load)	14E7-46	1000288
	1/8"	Propane (Non-Load)	14E7-27	1000274
	11 Ga.	Propane (Non-Load)	14E7-38	1000283
	15 Ga.	Propane (Non-Load)	14E7-32	1000278
	3/16"	MPS (Non-Load)	14E7-47	1000289
	1/8"	MPS (Non-Load)	14E7-28	1031126
	11 Ga.	MPS (Non-Load)	14E7-40	1031128
	15 Ga.	MPS (Non-Load)	14E7-34	1031127
	11 Ga.	Sprabond	14E7-41	1000284

2.4 Front wire guides, assemblies



Pos.	Designation	Qty	Old Art. no.	Art. no.
4	Air cap body	1	14E1	1000134
5	Nozzle nut	1	14E6	1000270

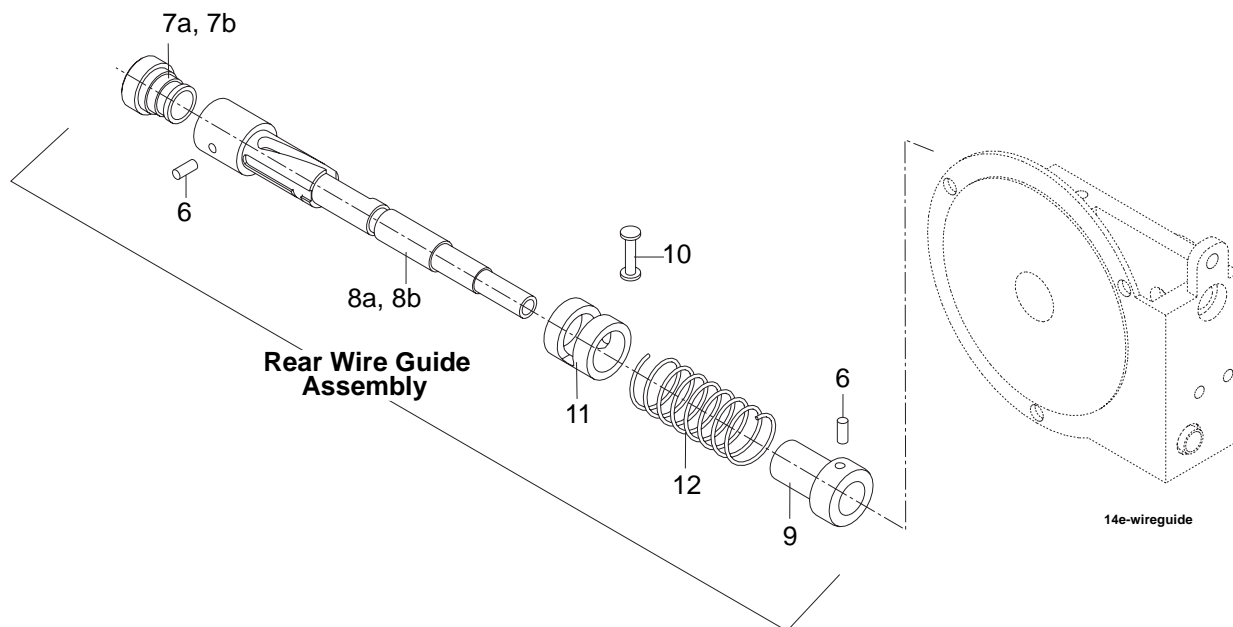
Front wire guides

Standard with 14E				
	Front wire guide 1/8" - 11 Ga.		14E23-1/8	1000258
Standard with 14E-H				
	Front wire guide 3/16" - 1/8"		14E23-3/16	1000160
Standard with 14E-P				
	Front wire guide 3/16" - 1/8"		14E23-3/16	1000160
Option				
	Front wire guide 15 Ga.		14E23-15	1000257

Siphon plug assemblies (option)

Siphon plug assembly 3/16" Acetylene <i>includes:</i>			14E200-1	1000255
	Siphon plug large gauge with O-rings		14E2-5	1000259
	Front wire guide 3/16" - 1/8"		14E23-3/16	1000160
	Nozzle assembly		14E7-42	1000285
	Nozzle nut		14E-6	1000270
Siphon plug assembly 1/8" Acetylene <i>includes:</i>			14E200-2	1000256
	Siphon plug large gauge with O-rings		14E2-5	1000259
	Front wire guide 1/8" - 11 Ga.		14E23-1/8	1000258
	Nozzle assembly		14E7-48	1000290
	Nozzle nut		14E-6	1000270

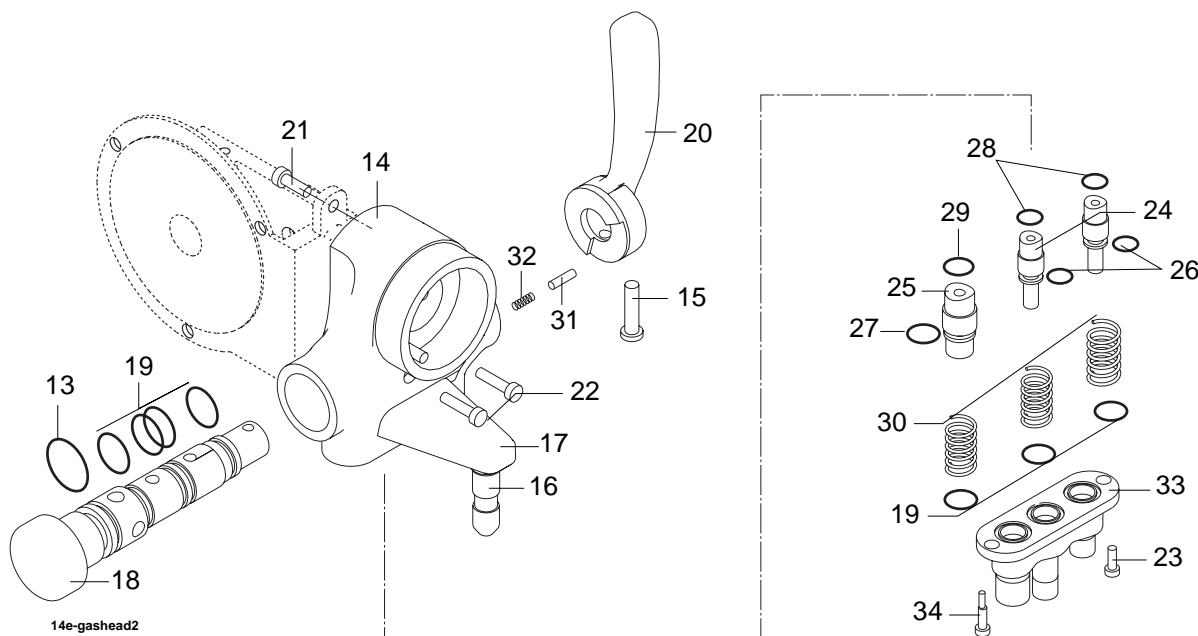
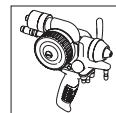
2.5 Rear wire guides and snubber assemblies



Designation	Old Art. no.	Art. no.
Rear wire guide assemblies		
Standard with 14E		
Rear wire guide and snubber assembly 1/8" - 11 Ga.	14E118-1/8	1000247
Standard with 14E-H		
Rear wire guide and snubber assembly 3/16" - 1/8"	14E118-3/16	1000139
Standard with 14E-P		
Rear wire guide and snubber assembly 3/16" - 1/8"	14E-P WIRE GUIDE	1036971
Option		
Rear wire guide and snubber assembly 15 Ga.	14E118-15	1000246

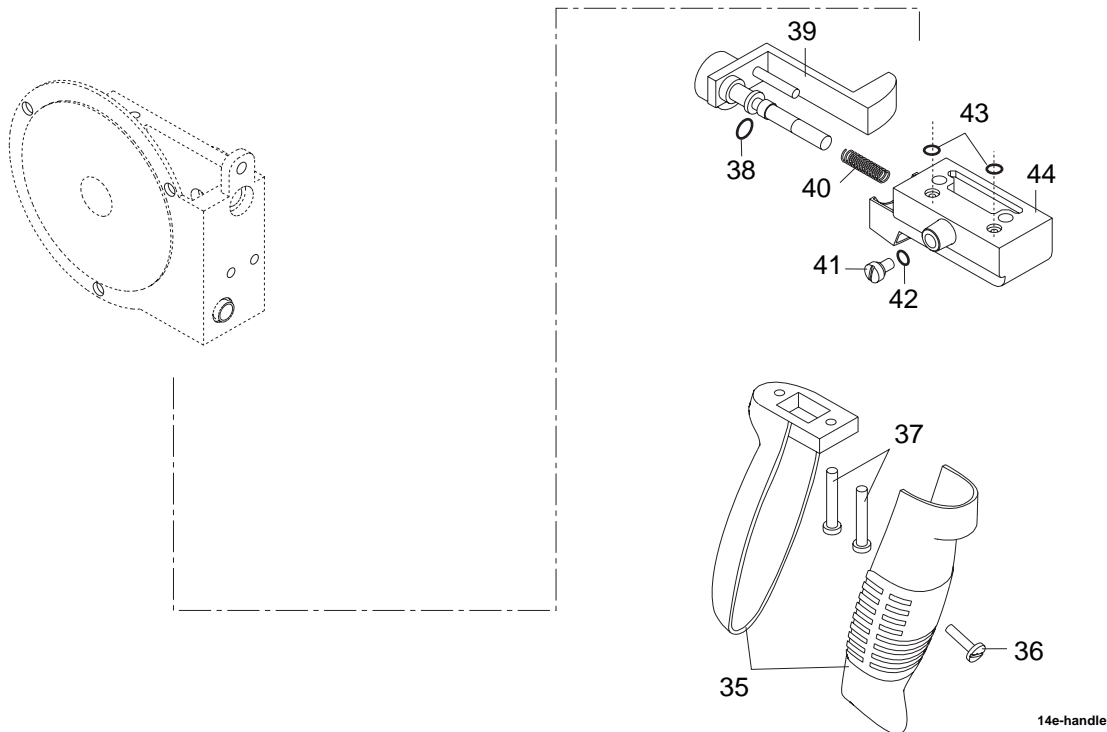
Pos.	Designation	Qty	Old Art. no.	Art. no.
6	Set screw (pkg. of 2)	2	14E67	1000184
7a	Guide insert 1/8" - 11 Ga. standard with 14E	1	14E187-1/8	1000095
7b	Guide insert 3/16" - 1/8" standard with 14E-H/14E-P	1	14E187-3/16	1000096
8a	Snubbing rear guide 1/8" - 11 Ga.	1	14E188-1/8	1004735
8b	Snubbing rear guide 3/16" - 1/8"	1	14E188-3/16	1000151
9	Spring retainer	1	14E241	1000163
10	Roller	1	14E242	1001443
11	Snubber spring housing	1	14E243	1001444
12	Spring	1	14E245	1001445

2.6 Gas head assembly



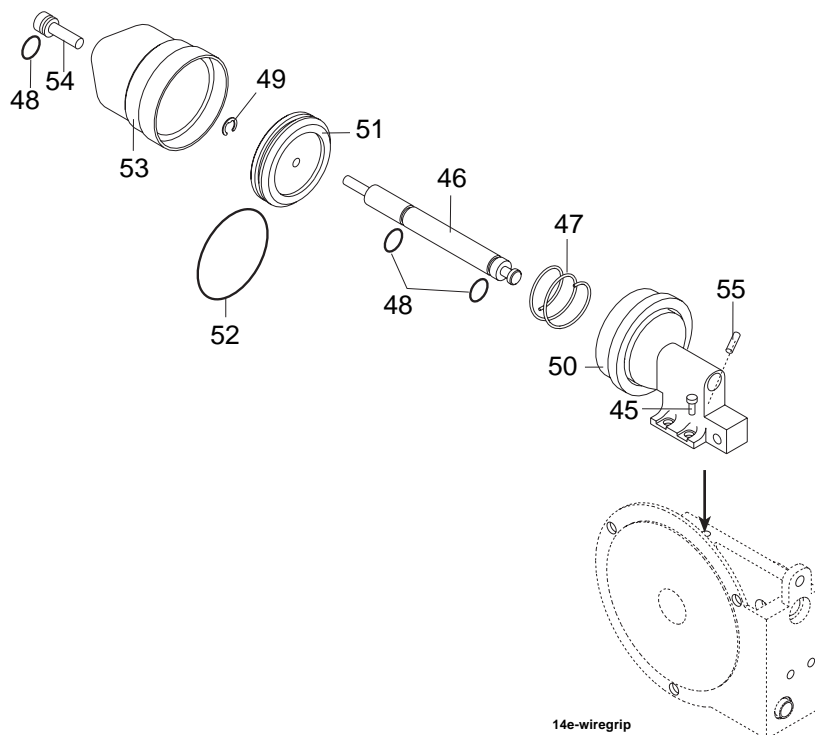
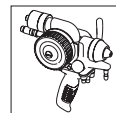
Pos.	Designation	Qty	Old Art. no.	Art. no.
	Gas head assembly	1	14E5	1000268
13	Valve core O-ring (pkg. of 3)	1	14E14	1000143
14	Gas head sub-assembly (incl. pos. 16, 17)	1	14E15	1000253
15	Valve handle screw M5x18 (pkg. of 5)	1	14E31	1000167
16	Mounting stud	1	14E40	1001571
17	Mounting stud roll pin (pkg. of 3)	1	14E41	1001572
18	Valve core	1	14E43	1000266
19	Valve core and hose connection block O-rings (pkg. of 6)	7	14E44	1001787
20	Valve handle assembly	1	14E45	1000267
21	Gas head mounting screw, rear M5x16 (pkg. of 5)	1	14E96	1000212
22	Gas head mounting screw, front M5x35 (pkg. of 5)	2	14E97	1000213
23	Hose connection block mounting screw	1	14E157	1000147
24	Plunger (fuel gas and oxygen)	2	14E165	1000654
25	Plunger (air)	1	14E166	1000091
26	Plunger O-ring (fuel gas and oxygen) (pkg. of 2)	2	14E168	1000861
27	Plunger O-ring (air) (pkg. of 2)	1	14E186	1002023
28	Plunger seal O-ring (fuel gas and oxygen) (pkg. of 2)	2	14E170	1000657
29	Plunger seal O-ring (air)	1	14E169	1000656
30	Plunger spring (pkg. of 3)	3	14E171	1000658
31	Detent pin	1	14E173	1000659
32	Detent pin spring	1	14E174	1000660
33	Hose connection block	1	14E176	1000092
34	Valve core stop screw	1	14E179	1000149
--	Gas head valve O-ring package Includes Pos. 13, 19, 26, 27, 28, 29	--	14E184	1000254

2.7 Handle and wire feed valve



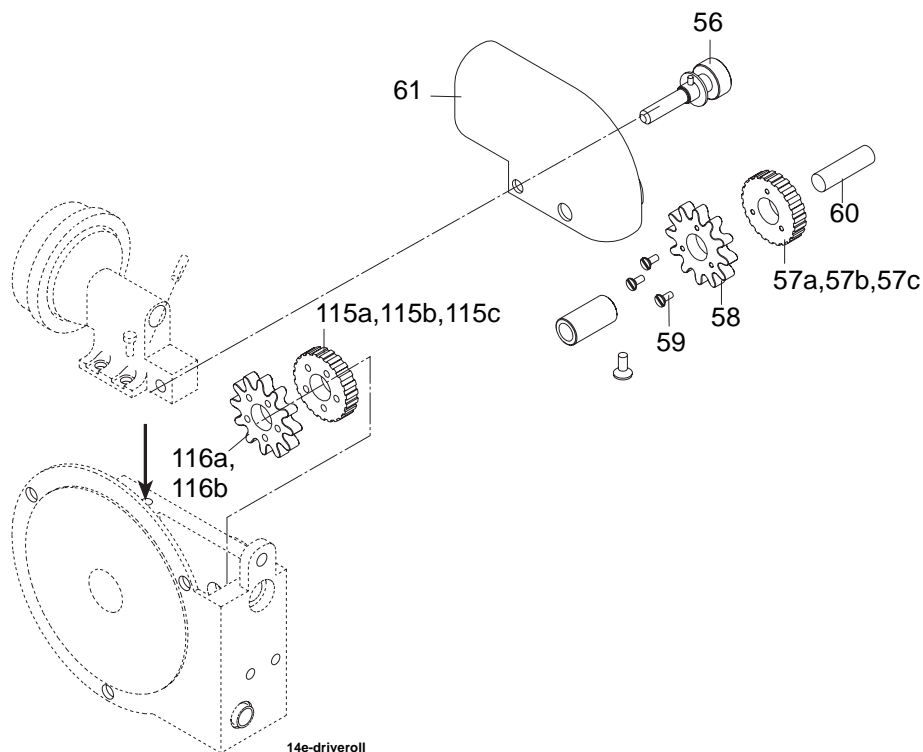
Pos.	Designation	Qty	Old Art. no.	Art. no.
35	Gun handle (includes pos. 36)	1	14E27	1001186
36	Gun handle screw (pkg. of 5)	1	7M 27	1032348
37	Gun handle mounting screw (pkg. of 5)	2	14E31	1000167
38	Valve shaft seal O-ring (pkg. of 3)	1	14E129	1001434
39	Valve shaft assembly (includes pos. 38)	1	14E131	1000141
40	Valve shaft spring	1	14E132	1001615
41	Cam follower screw (includes pos. 42)	1	14E133	1001435
42	Cam follower O-ring	1	14E134	1001436
43	O-ring	2	14E180	1028632
44	Wire feed valve block (includes pos. 43)	1	14E250	1000146

2.8 Wire grip mechanism



Pos.	Designation	Qty	Old Art. no.	Art. no.
45	Support block mounting screw M4x10 (pkg. of 3)	3	14E117	1000140
46	Piston rod	1	14E138	1001437
47	Piston return spring	1	14E177	1001438
48	O-ring (pkg. of 3)	2	14E180	1028632
49	Retainer ring (pkg. of 3)	1	14E189	1001439
50	Cylinder support block	1	14E206	1000311
51	Piston	1	14E207	1000312
52	Piston O-ring (pkg. of 3)	1	14E208	1000313
53	Cylinder	1	14E209	1000314
54	Piston stop screw	1	14E293	1001447
55	Screw M4x10	1	14E25	1000164

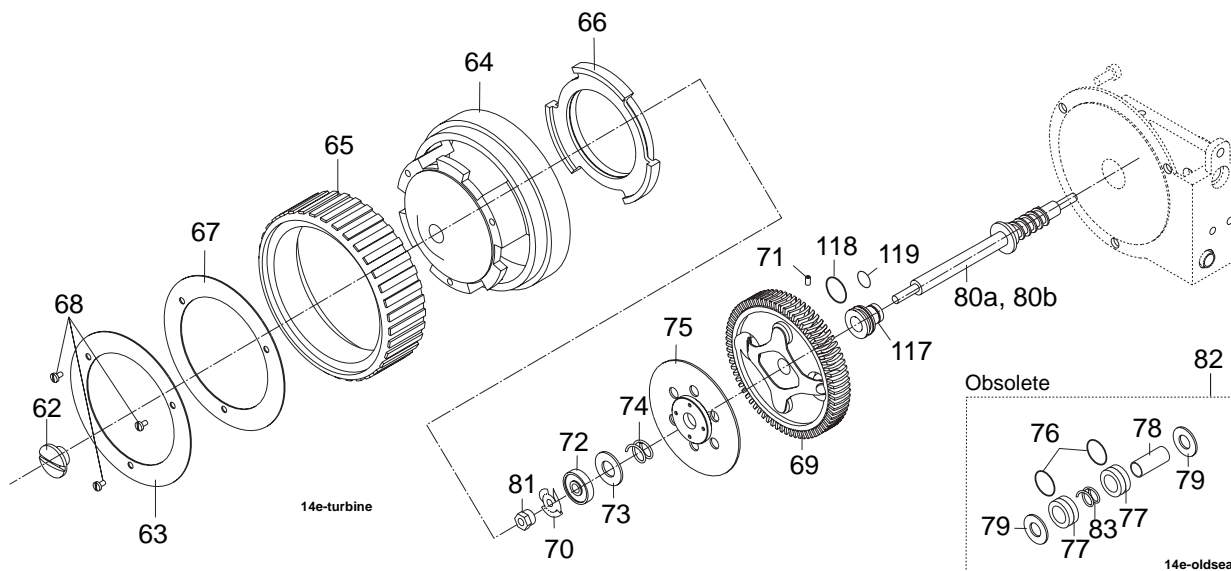
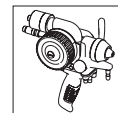
2.9 Drive roll carrier, upper and lower drive rolls and gears



Pos.	Designation	Qty	Old Art. no.	Art. no.
56	Drive roll carrier pivot pin	1	14E30	1001568
57a	Upper drive roll 3/16" - 1/8"	standard with 14E-H/14E-P	14E32-3/16	1000169
57b	Upper drive roll 1/8" - 15 Ga.	standard with 14E	14E32-1/8	1000264
57c	Upper drive roll 18 Ga.		14E32-18	1000265
58	Upper drive gear	1	14E33	1000171
115a	Lower drive roll 3/16" - 1/8"	standard with 14E-H/14E-P	14E35-3/16	1001103
115b	Lower drive roll 1/8" - 11 Ga.	standard with 14E	14E35-1/8	1000832
115c	Lower drive roll 15 Ga.		14E35-15	1000831
116a	Lower drive gear 3/16" - 1/8"	standard with 14E-H/14E-P	14E36-3/16	1001104
116b	Lower drive gear 1/8" - 20 Ga.	standard with 14E	14E36-1/8	1000833
59	Upper drive gear screw (pkg. of 5)	1	14E34	1000173
60	Upper drive roll axle	1	14E37	1000174
--	Upper drive roll axle screw M3x6 (pkg. of 5)	1	14E26	1000165
61	Drive roll carrier	1	14E136	1000142

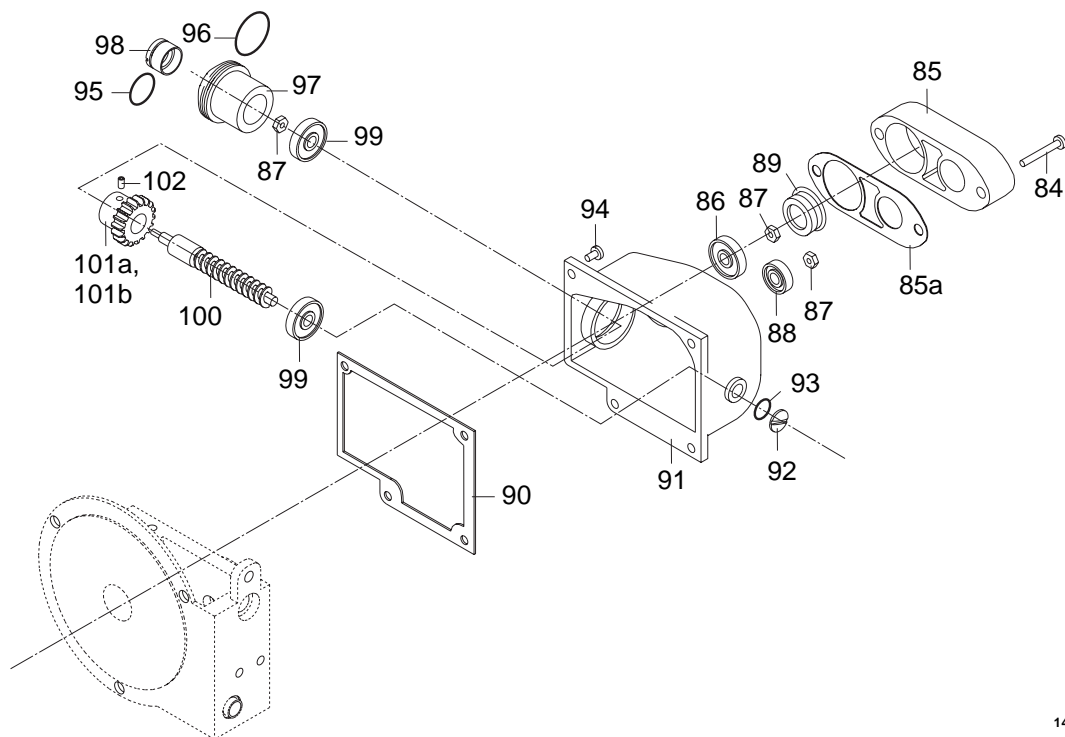
2.10 Turbine

Speed control assembly / Turbine shaft assembly



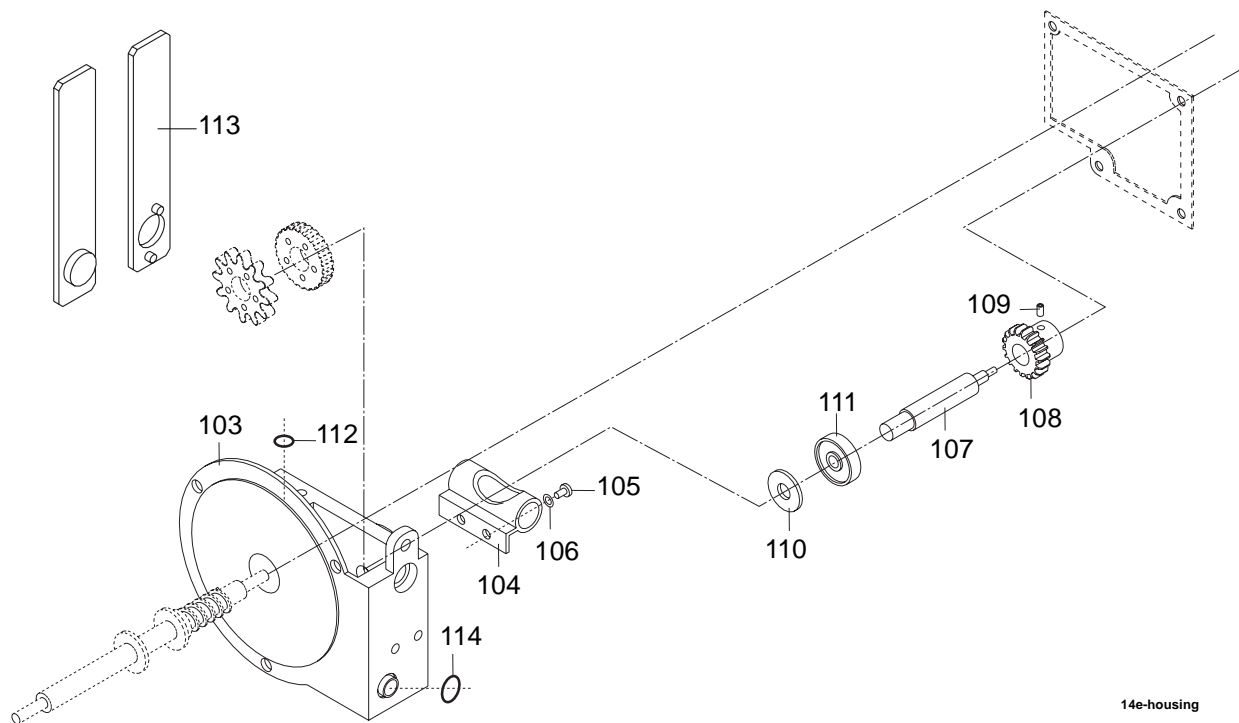
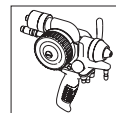
Pos.	Designation	Qty	Old Art. no.	Art. no.
Speed control assembly				
62	Grease plug screw	1	14E50	1000177
63	Controle ring nameplate	1	14E71	1000319
64	Turbine cover	1	14E77	1000321
--	Turbine cover screw		14E53	1000178
65	Control ring	1	14E85	1001578
66	Spider assembly	1	14E86	1001579
67	Detent spring	1	14E87	1000859
68	Nameplate screw M3x5	3	14E89	1000209
Turbine shaft assembly				
69	Turbine rotor (incl. pos. 71)	1	14E54	1000269
70	Finger spring (pkg. of 2)	1	14E64	1001574
71	Set screw M4x5 (pkg. of 2)	1	14E67	1000184
72	Turbine bearing - right	1	14E73	1000854
73	Return spring washer	1	14E74	1001575
74	Brake disc return spring	1	14E76	1000855
75	Brake disc	1	14E78	1001576
80a	Turbine shaft, standard	standard with 14E/14E-P	14E92-S	1000294
80b	Turbine shaft, high speed	standard with 14E-H	14E92-H	1000293
81	Turbine bearing nut - right	1	14E102	1000244
117	Turbine seal package (incl. pos. 118, 119) - replaces pos. 82	1	14E58074	1042894
118	O-ring (pkg. of 5)	1	14E79	1001577
119	O-ring	1	K137	1006359
82	Oil seal assembly - OBSOLETE FROM Aug. 2004 - includes:	1	14E160	1000148
76	Oil seal O-ring (pkg. of 5)	2	14E79	1001577
77	Oil seal bobbin	2	14E80	1000202
78	Oil seal sleeve	1	14E81	1000203
79	Oil seal washer	2	14E82	1000205
83	Oil seal spring	1	14E283	1000206

Transmission gear / Countershaft assembly



Pos.	Designation	Qty	Old Art. no.	Art. no.
Transmission gear				
84	Bearing cover screw M5x18 (pkg. of 5)	2	14E31	1000167
85	Bearing cover	1	14E47	1005345
85a	Bearing cover gasket	1	14E48	1001573
86	Drive shaft bearing - left	1	14E70	1000857
87	Turbine bearing nut - left and drive shaft nut	2	14E84	1000207
88	Turbine bearing - left	1	14E220	1000315
89	Bearing follower	1	14E221	1015527
90	Transmission gear cover gasket	1	14E55	1000844
91	Transmission gear cover	1	14E56	1000317
92	Plug screw - Front bearing retainer	1	14E57	1004665
93	Plug screw O-ring	1	14E186	1002023
94	Cover screw	4	14E53	1000178
Countershaft assembly				
95	Retainer plug O-ring (pkg. of 3)	1	14E14	1000143
96	Bearing retainer O-ring (pkg. of 3)	1	14E46	1000100
97	Bearing retainer	1	14E51	1000842
98	Retainer plug	1	14E52	1000843
99	Countershaft bearing - front and rear; Drive shaft bearing - left	2	14E70	1000857
100	Countershaft	1	14E91	1000210
101a	Countershaft gear, standard	standard with 14E/14E-P	14E93-S	1000296
101b	Countershaft gear, high speed	standard with 14E-H	14E93-H	1000295
102	Set screw (pkg. of 2)	1	14E67	1000184

Central housing / Drive shaft assembly



14e-housing

Pos.	Designation	Qty	Old Art. no.	Art. no.
Speed control assembly				
103	Central housing - includes pos. 104, 105, 106, 114 and art. no. 1000848 (from section "miscellaneous items")	1	14E59	1000318
104	Pump housing	1	14E60	1000845
105	Pump housing mounting screw	2	14E61	1030599
106	Pump housing lock washer	2	14E62	1000847
107	Drive shaft	1	14E65	1000182
108	Drive shaft gear	1	14E66	1000183
109	Set screw (pkg. of 2)	1	14E67	1000184
110	Drive shaft seal (pkg. of 6)	1	14E68	1000851
111	Drive shaft bearing - right	1	14E69	1000852
112	O-ring (pkg. of 3)	1	14E180	1028632
113	Special spanner wrench (both sides to be used)	1	14E104	1000316
114	O-ring (pkg. of 2)	2	14E13	1000503

2.11 Tools and lubricants, miscellaneous items

Designation	Qty	Old Art. no.	Art. no.
Tools			
Socket wrench	1	14E100	1000136
Spanner wrench (Page 17 for illustration)	1	14E104	1000316
Screw driver	1	14E105	1000814
Adjustable wrench	1	14E106	1000815
Gearlube (pkg. of 3)	1	14E110	1000245
Valvelube (pkg. of 3)	1	14E111	1000816
Cleaning wire kit	1	14E114	1000817
Hex key 3mm	1	14E202	1000137
Hex key 2mm	1	14E240	1000144
Lighter	1	14E101	1000813
Miscellaneous items			
Lighter flints (pkg. of 12)	--	14E183	1000823
Dowel pin for positioning gear cover	1	14E63	1000848
Set screw for rear wire guide (pkg. of 5)	1	14E25	1000164
Oil sight plug assembly (incl. art. no. 1000175)	1	14E10	1000135
Oil sight plug O-ring	1	14E49	1000175
Drive shaft nut	1	14E84	1000207
Tool post fixture assembly	1	14E124	1001340
Eye protectors	1	14E193	1000097
Hearing protectors	1	14E194	--
Ear plugs	1	14E292	1001833
Safety package (incl. eye protectors, hearing protectors, ear plugs)	1	14E197	1015366
Replacement lens - shade 4	--	14E195	1000098
Replacement cover plate - plastic	--	14E196	1000099

2.12 Optional equipment

Designation	Old Art. no.	Art. no.
Hose unit (US)	7H	1033681
Hose unit (CE)	7HEX	1001453
Air hose unit	HA	1001973
Air cleaner unit	4AC	1000811
Wire grip mechanism <i>includes:</i>	14EWGM	1000324
Set screw	14E67	1000184
O-ring	14E129	1001434
O-ring	14E180	1028632
Spring	9301	1022804
Mounting screw	21362	1023756
Support block	24908	1023957
Cap	25105	1023975
Cam follower	25112	1023977
Push rod	25113	1023978
Locking screw	25114	1023979
Cam assembly	25123	1000249
Spacer	54947	1028127