

16E / 16E-H / 16E-P Spray Gun Combustion Wire Spraying


Parts List
PL 96151 EN 01




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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

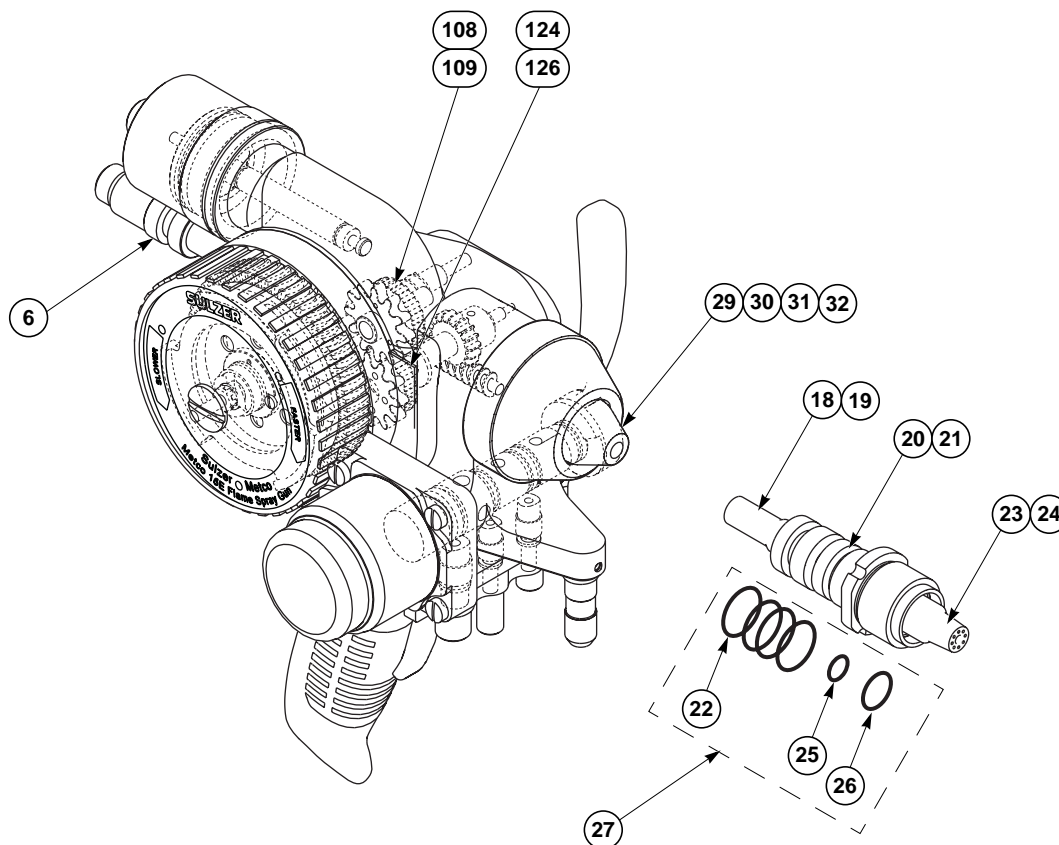
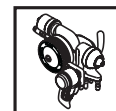
Parts recommended in order to guarantee maximum availability of component. This prevents downtime caused by delay in procurement.



Warranty Disclaimer

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

1 List of Recommended Spare Parts for 16E / 16E-H / 16E-P Spray Gun



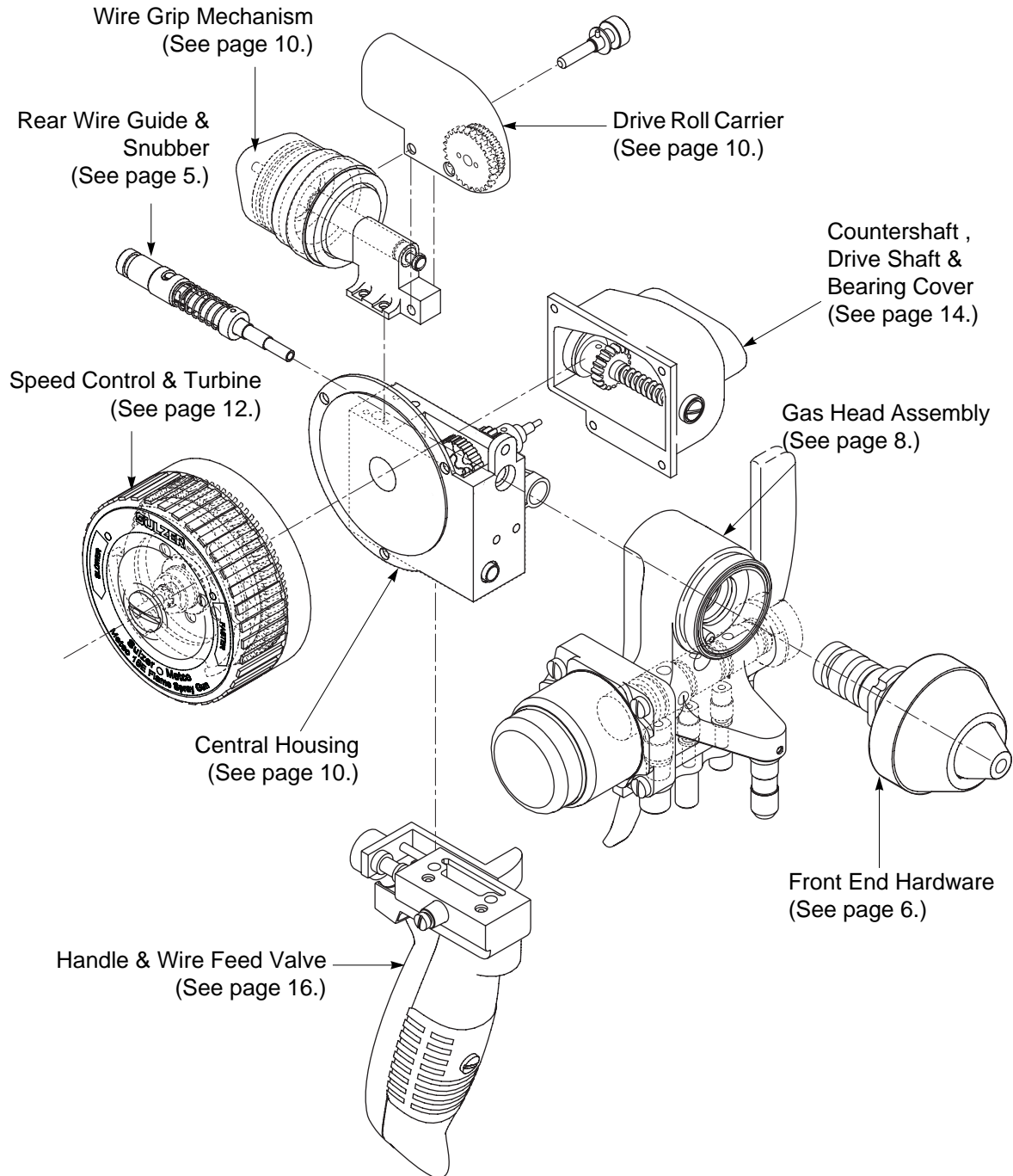
16e_cutaway

Item No.	Description	Qty.	Cat.	Catalog No.	Order No.
6	Snubber Roller	1	C	7E242	1001443
18, 19	Front Wire Guide	1	C	See page 6.	
20, 21	Siphon Plug Assembly	1	C	See page 6.	
22	Siphon Plug O-rings (pkg. 4)	4	C	11E14	1000143
23, 24	Nozzle	1	C	See page 6.	
25	Nozzle O-ring, Small (pkg. 2)	1	W	11E109	1004714
26	Nozzle O-ring, Large (pkg. 2)	1	W	11E108	1000138
27	Siphon Plug & Nozzle Reseal Kit (incl. items 22, 25&26)	1	W	11E190	1000152
29 – 32	Air Cap	1	C	See page 6.	
108, 109	Upper Drive Roll	1	C	See page 10.	
124, 126	Lower Drive Roll	1	C	See page 10.	
191	Krytox®	1	C	16E97041	1070061
192	Gearlube (pkg. 3)	1	C	12E110	1000245

2 Parts List for 16E / 16E-H / 16E-P Spray Gun

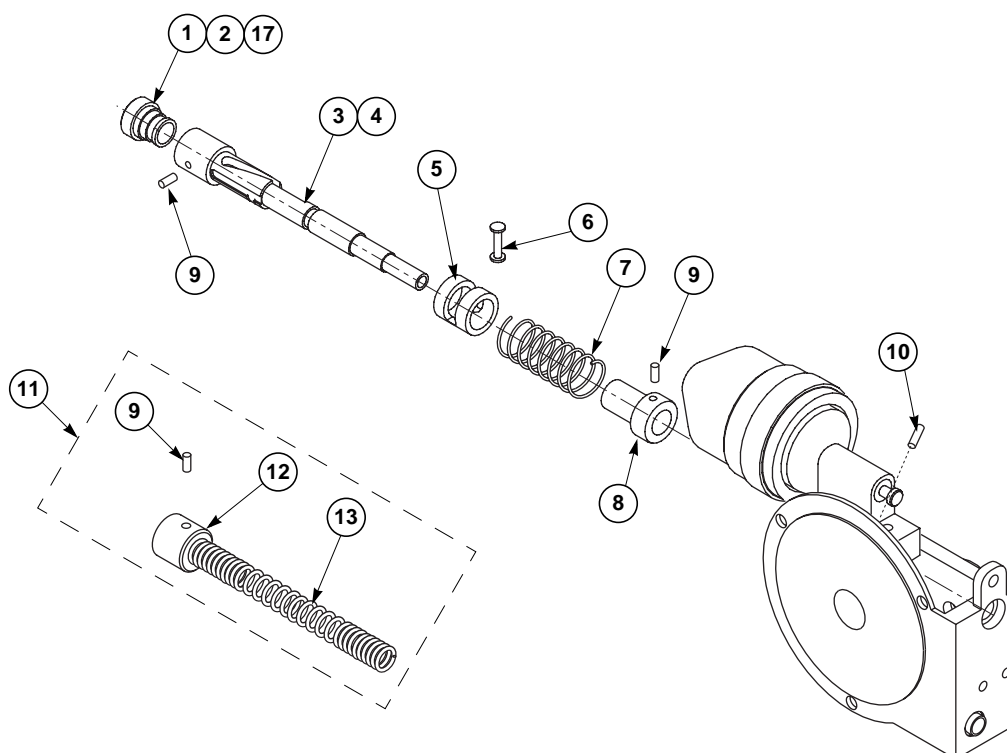
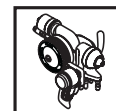
16E Hand Held Wire Gun	(16E)	1069185
16E-H High Speed Wire Gun	(16E-H)	1069186
16E-P Wire Gun - Propane	(16E-P)	1069187

2.1 Overview



16e_subassys

2.2 Rear Wire Guide and Snubber Assembly

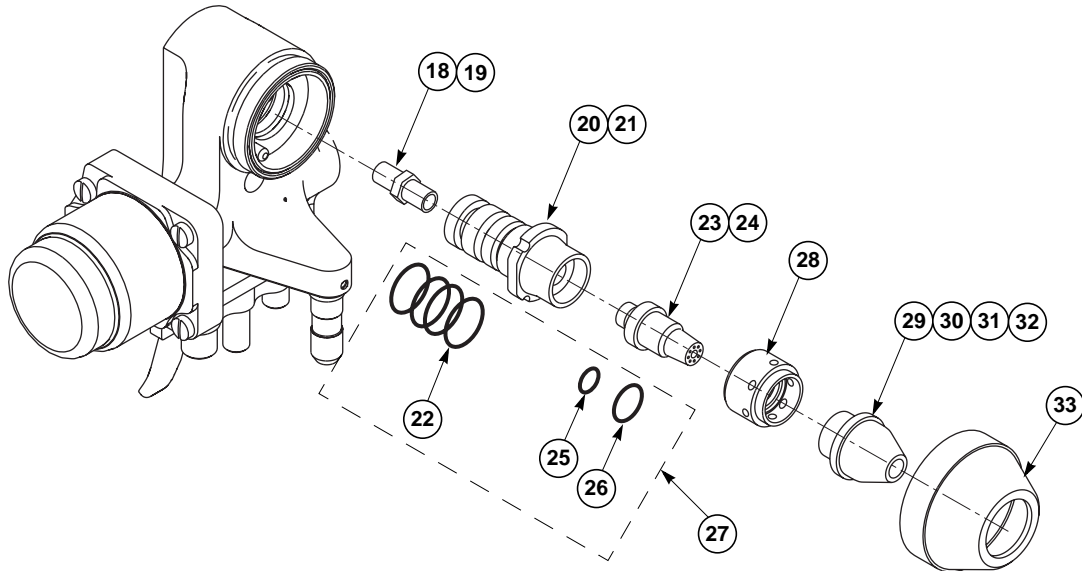


16e_snubber

Item No.	Description	Qty.	Catalog No.	Order No.
1 ^A	Insert, 1/8-11 Ga.	1	10E187-18	1000095
2 ^{B,C}	Insert 3/16-1/8 Ga.	1	10E187-316	1000096
3 ^A	Rear Snubbing Wire Guide, 1/8-11GA	1	12E147	1004735
4 ^{B,C}	Rear Snubbing Wire Guide, 3/16-1/8	1	11E188	1000151
5	Snubber Spring Housing	1	7E243	1001444
6	Roller	1	7E242	1001443
7	Compression Spring	1	7E245	1001445
8	SPRING RETAINER	1	11E241	1000163
9	Hex Set Screw, M4 X 5	3	11E67	1000184
10	Hex Set Screw, M4 X 10	1	11E25	1000164
11	Strain Relief Assembly	1	12E143	1000250
12	Bushing	1	12E144	1000251
13	Spring	1	10E163	1000090
Optional Snubbers				
14	Wire Snubber Assembly, 1/8-11 Ga.	1	12E118-18	1000247
15	Wire Snubber Assembly, 3/16-1/8	1	11E118	1000139
16	Wire Snubber Assebbly, 15 Ga.	1	14E118-15	1000246
17	Wire Guide - Small Gauge	1	14E54075	1041478

- A. 16E
- B. 16E-H
- C. 16E-P

2.3 Front End Hardware



16e_frontend

Item No.	Description	Qty.	Catalog No.	Order No.
18 ^A	Front Wire Guide (1/8" & 11 Ga.)	1	12E23-18	1000258
19 ^{B,C}	Front Wire Guide (3/16" & 1/8")	1	11E23	1000160
20 ^{A,B}	Siphon Plug, Acetylene <i>(incl. item 22)</i>	1	12E2-5	1000259
21 ^C	Siphon Plug, Propane / MPS <i>(incl. item 22)</i>	1	12E2-6	1000260
22	O-Ring, Black Viton, 0.676 x 0.07 in <i>(pkg. 4)</i>	4	11E14	1000143
23 ^{A,B}	Nozzle, Acetylene, 1/8" <i>(incl. items 25&26)</i>	1	12E7-48	1000290
24 ^C	Nozzle, Propane, 3/16" <i>(incl. items 25&26)</i>	1	12E7-43	1000286
25	O-Ring, Black Viton, 0.270 x 0.07 in <i>(pkg. 2)</i>	1	11E109	1004714
26	O-Ring, Black Viton, 0.551 x 0.07 in <i>(pkg. 2)</i>	1	11E108	1000138
27	Siphon Plug & Nozzle Reseal Kit <i>(incl. items 22, 25&26)</i>	1	11E190	1000152
28	Nozzle Nut	1	12E6	1000270
29 ^A	Air Cap, EC	1	8E3-EC	1001570
30 ^B	Air Cap, CH, Non Load	1	3K3-CH	1000664
31 ^C	Air Cap, EA	1	3K3-EA	1000666
32 ^C	Air Cap, AH, Non Load	1	3K3-AH	1000662
33	Air Cap Body	1	11E1	1000134

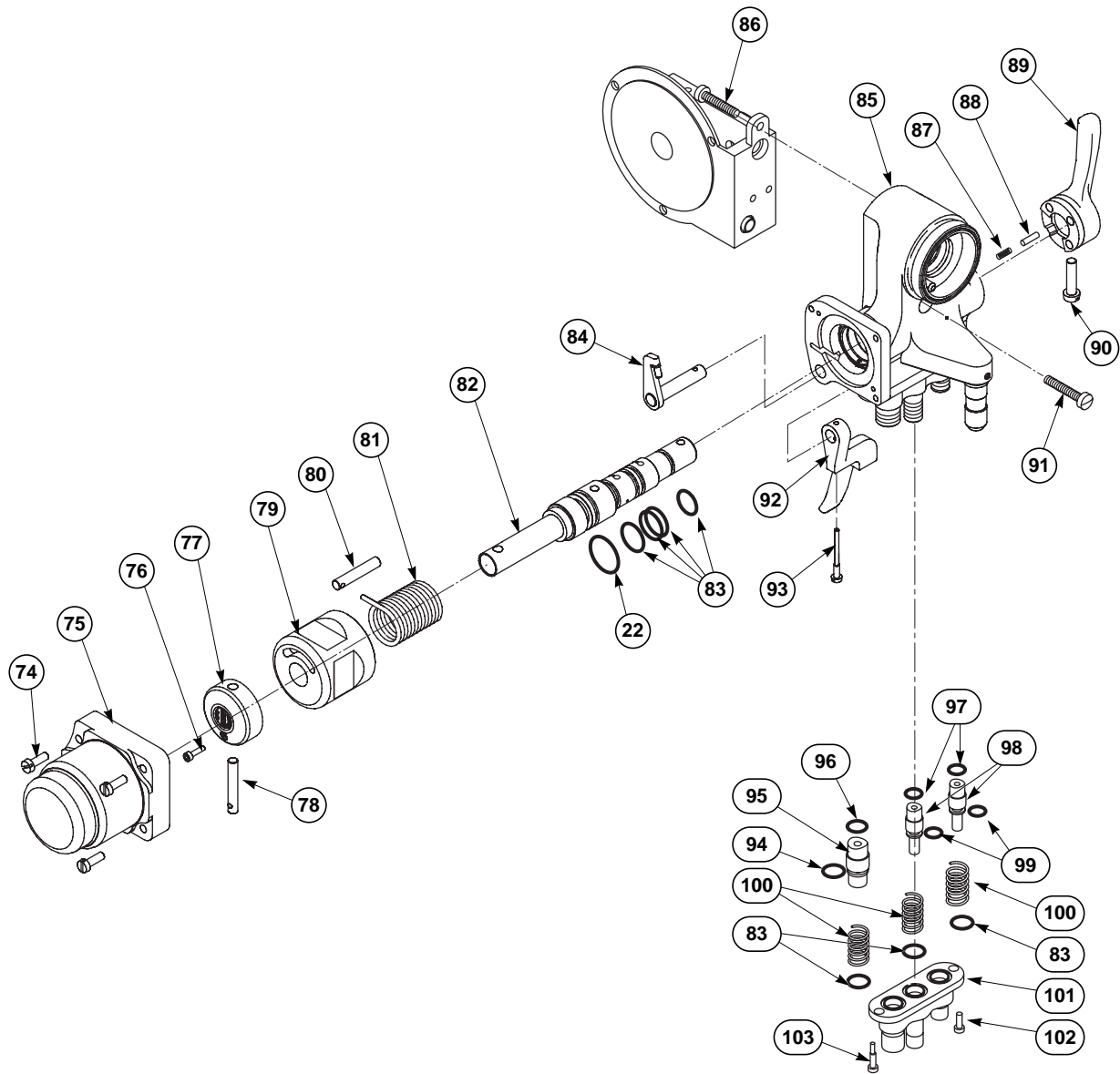
- A. 16E
- B. 16E-H
- C. 16E-P

2.3.1 Optional Front End Parts and Packages (Not Illustrated)



Item No.	Description	Catalog No.	Order No.
Wire Guide			
34	Front Wire Guide (15-20 Ga.)	12E23-15	1000257
Siphon Plug			
35	Small Gauge <i>(incl. item 22)</i>	12E2-7	1000261
36	Propane / MPS, Small Gauge <i>(incl. item 22)</i>	12E2-8	1000262
37	Acetylene, 3/16" <i>(incl. items 19, 20, 22, 28, & 59.)</i>	12E200-1	1000255
38	Acetylene, 1/8" & 11 Ga. <i>(incl. items 18, 20, 22, 23, & 28.)</i>	12E200-2	1000256
Nozzle (Includes o-rings, items 25 & 26.)			
39	5/32" Acetylene	14E7-51	1004756
40	3/16" Acetylene	12E7-42	1000285
41	11 Ga. Acetylene	12E7-35	1000280
42	15 Ga. Acetylene	12E7-29	1000275
43	5/32" Propane	14E7-52	1000320
44	1/8" Propane	12E7-49	1000291
45	11 Ga. Propane	12E7-37	1000282
46	15 Ga. Propane	12E7-31	1000277
47	3/16" MPS	12E7-44	1031129
48	1/8" MPS	12E7-25	1000272
49	11 Ga. MPS	12E7-39	1004743
50	15 Ga. MPS	12E7-33	1000279
51	3/16" Acetylene (Non-Load)	12E7-45	1000287
52	1/8" Acetylene (Non-Load)	12E7-26	1000273
53	11 Ga. Acetylene (Non-Load)	12E7-36	1000281
54	15 Ga. Acetylene (Non-Load)	12E7-30	1000276
55	3/16" Propane (Non-Load)	12E7-46	1000288
56	1/8" Propane (Non-Load)	12E7-27	1000274
57	11 Ga. Propane (Non-Load)	12E7-38	1000283
58	15 Ga. Propane (Non-Load)	12E7-32	1000278
59	3/16" MPS (Non-Load)	12E7-47	1000289
60	1/8" MPS (Non-Load)	12E7-28	1031126
61	11 Ga. MPS (Non-Load)	12E7-40	1031128
62	15 Ga. MPS (Non-Load)	12E7-34	1031127
63	11 Ga. Sprabond	12E7-41	1000284
Air Cap			
64	AM	3K3-AM	1000663
65	CHM Non Load	3K3-CHM	1000665
66	JH Non Load	3K3-JH	1000667
67	MH Non Load	3K3-MH	1000668
68	J	4E3-J	1000835
69	M	4E3-M	1000836
70	C	Y3-C	1002413
71	CD Fan Spray	4E4-CD	1000841
72	AB Fan Spray	Y4-AB	1002414

2.4 Gas Head Assembly

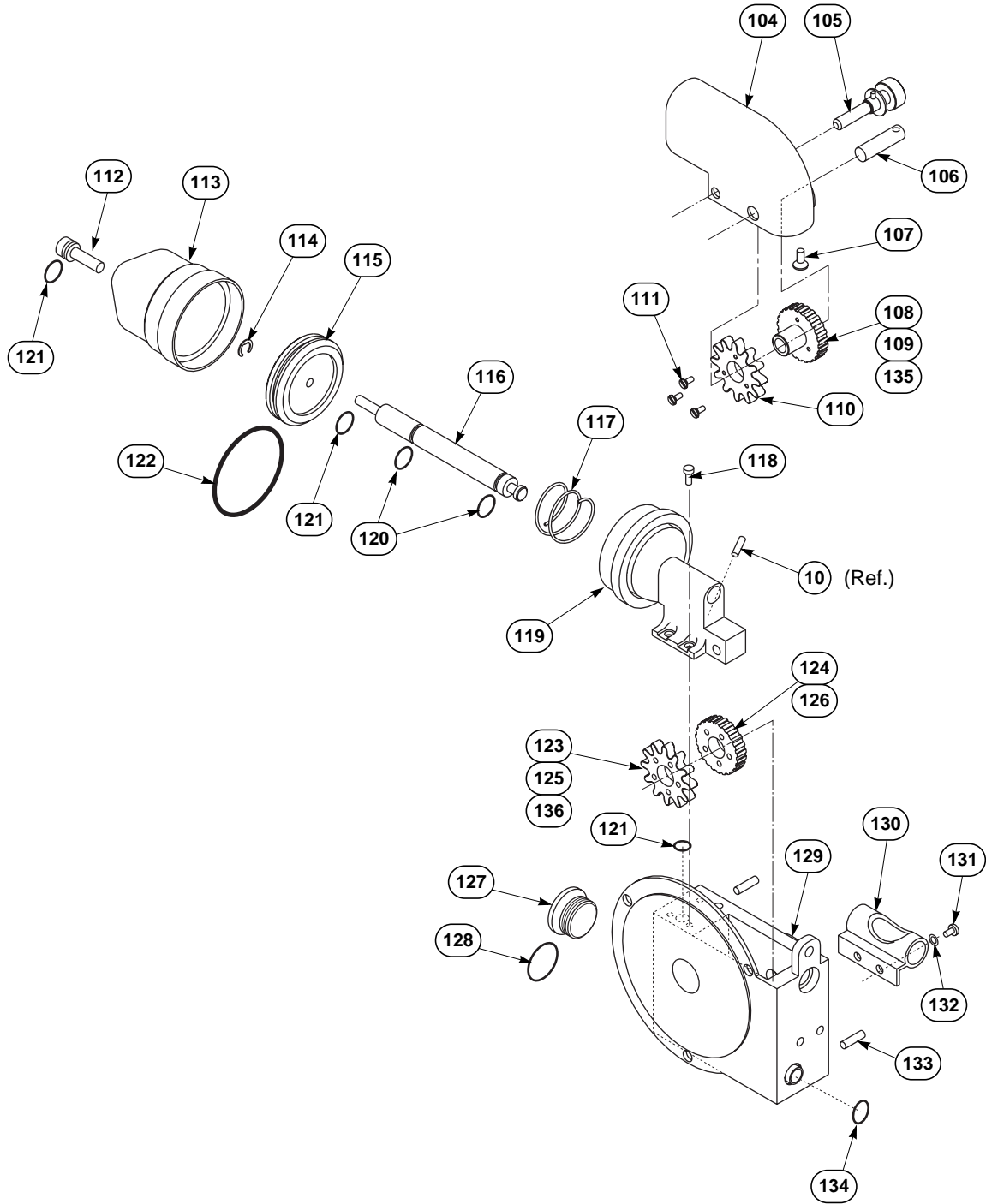


16e_gas_head



Item No.	Description	Qty.	Catalog No.	Order No.
73	16E Gas Head Assembly <i>(Includes items 74-103.)</i>	1	16E93619	1069259
74	Screw	3	—	—
75	Torsion Ring Cover	1	16E95791	1069272
76	Screw, M2.5 x 10mm	1	16E94199	1069269
77	End Cap	1	—	—
78	End Cap Pin	1	16E95740	1069268
79	Torsion Ring	1	16E94190	1069264
80	Spring Bushing	1	16E94188	1069271
81	Torsion Spring	1	16E95743	1069267
82	Valve Core <i>(incl. items 22 & 83)</i>	1	16E93647	1069266
22	O-Ring, Black Viton, 0.676 x 0.07 in <i>(pkg. 4)</i>	1	11E14	1000143
83	O-Ring, Black Viton, 0.489 x 0.07 in	7	2-014V	1000359
84	Pawl & Shaft Assembly	1	16E95907	1069263
85	Gas Head Sub-assembly	1	16E93621	1069265
86	Screw, M5 X 16 <i>(pkg. 5)</i>	1	11E96	1000212
87	Compression Spring	1	3K317	1000660
88	Detent Pin	1	16E94194	1069260
89	Valve Handle	1	16E95750	1069270
90	Screw, M5 X 20mm <i>(pkg. 2)</i>	1	14E34884	1064020
91	Screw, M5 X 35 <i>(pkg. 5)</i>	2	11E97	1000213
92	Safety Handle	1	16E94195	1069261
93	Screw	1	16E95892	1069262
94	O-Ring, Buna-N, 0.301 X 0.070 <i>(pkg. 2)</i>	1	L186	1002023
95	Plunger, Air	1	10E166	1000091
96	O-Ring, PU, 0.239 x 0.70 in	1	3K305	1000656
97	O-Ring, Black Viton, 0.176 x 0.07 in <i>(pkg. 2)</i>	2	3K306	1000657
98	Plunger, Fuel Gas & Oxygen	2	3K303	1000654
99	O-Ring, Buna, 0.239 x 0.07 in	2	4EFC56	1000861
100	Compression Spring <i>(pkg. 3)</i>	3	3K307	1000658
101	Hose Block	1	10E176	1000092
102	Screw, M6 x 0.312	1	11E157	1000147
103	Screw, M6 x 0.333	1	11E179	1000149

2.5 Wire Grip Mechanism, Drive Rolls and Central Housing



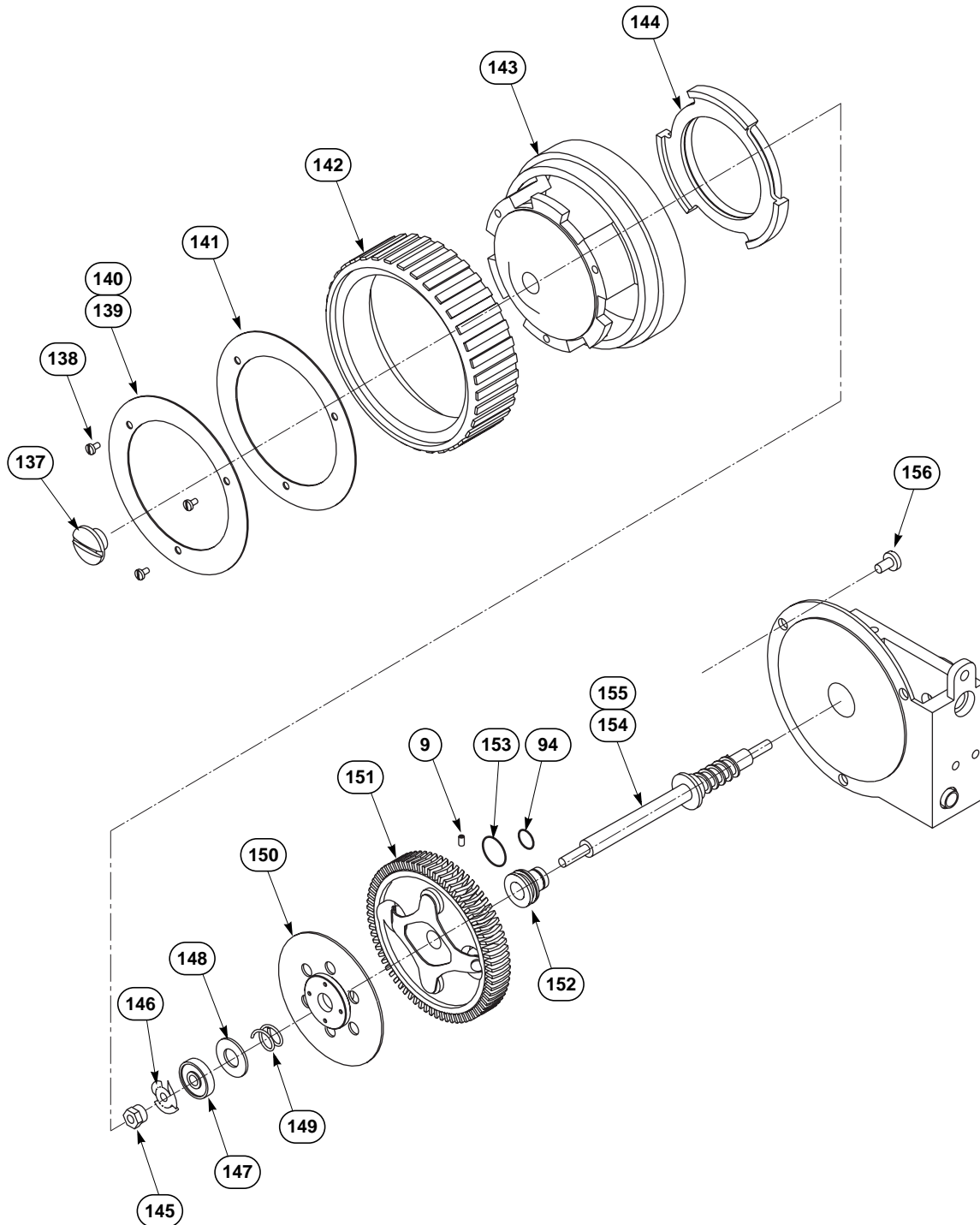
16e_wire_drive



Item No.	Description	Qty.	Catalog No.	Order No.
9	Hex Set Screw, M4 X 5	1	11E67	1000184
104	Drive Roll Carrier	1	11E136	1000142
105	Pivot Pin	1	8E30	1001568
106	Drive Roll Axle	1	11E37	1000174
107	Screw (pkg. 5)	1	11E26	1000165
108 ^A	Upper Drive Roll, 1/8-15 Ga.	1	12E32-18	1000264
109 ^{B,C}	Upper Drive Roll, 3/16-1/8	1	11E32	1000169
110	Upper Drive Gear	1	11E33	1000171
111	Screw	3	11E34	1000173
112	Screw, 10-32 X 1/2	1	7E93	1001447
113	Cylinder	1	14E209	1000314
114	Retaining Ring, 0.187	1	7E189	1001439
115	Piston	1	14E207	1000312
116	Piston Rod	1	7E138	1001437
117	Spring	1	7E177	1001438
118	Screw, M4 X 10 (pkg. 3)	3	11E127	1000140
119	Support Block	1	11E206	1000159
120	O-Ring, Buna, 0.208 x 0.07 in (pkg. 3)	2	7E129	1001434
121	O-Ring, Buna, 0.176 x 0.07 in (pkg. 3)	3	K180	1028632
122	O-Ring, Buna, 0.296 x 0.139 in (pkg. 2)	1	14E208	1000313
123 ^A	Lower Drive Gear	1	4E36	1000833
124 ^A	Lower Drive Roll, 1/8 - 11 Ga.	1	4E35-18	1000832
125 ^{B,C}	Lower Drive Gear, 3/16 - 1/8	1	5E36	1001104
126 ^{B,C}	Lower Drive Roll, 3/16 - 1/8	1	5E35-316	1001103
127	Oil Sight Plug	1	11E10	1000135
128	O-Ring Buna 0.551x0.07 in	1	11E49	1000175
129	Central Housing (incl. items 121 & 130-134)	1	14E59	1000318
130	Housing Pump	1	4E60	1000845
131	Screw, 6-32 X 9/32 (pkg. 5)	2	11E61	1030599
132	Lock Washer (pkg. 6)	2	4E62	1000847
133	Dowel Pin	2	4E63	1000848
134	O-Ring Buna 0.351x0.072 in	1	2KT13	1000503
Optional Drive Rolls				
135	Upper Drive Roller (Small Ga.)		12E32-18G	1000265
136	Lower Drive Roll 15 Ga.		4E35-15	1000831

- A. 16E
- B. 16E-H
- C. 16E-P

2.6 Speed Control and Turbine



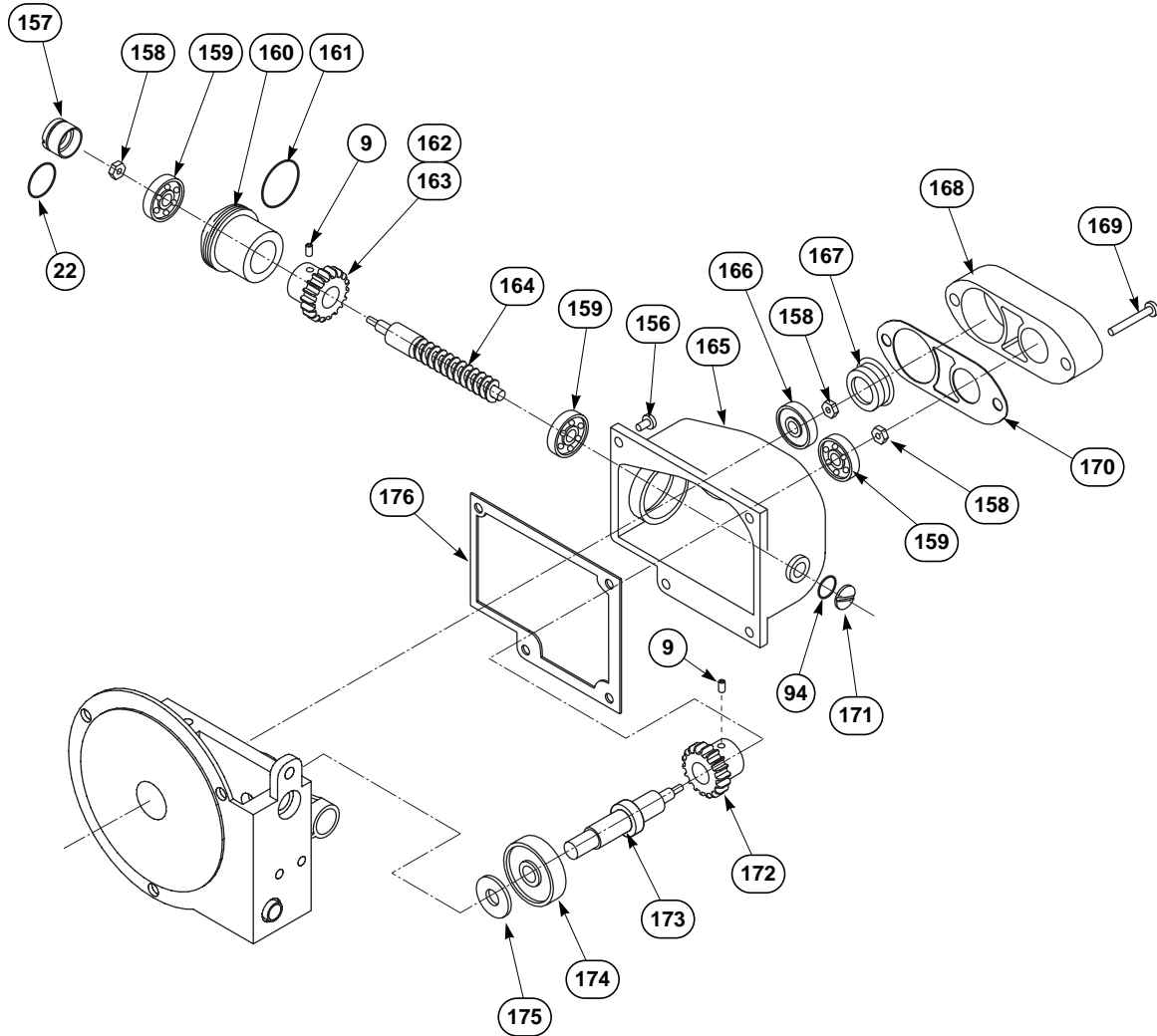
16e_wire_drive



Item No.	Description	Qty.	Catalog No.	Order No.
9	Hex Set Screw, M4 X 5	1	11E67	1000184
94	O-Ring, Buna-N, 0.301 X 0.070 (pkg. 2)	1	L186	1002023
137	Plug	1	11E50	1000177
138	Screw, M3 X 5 (pkg. 5)	3	11E89	1000209
139 ^{A,B}	Nameplate, 16E	1	14E71	1000319
140 ^C	Nameplate, 16E-H	1	14E71-H	1006349
141	Detent Spring	1	4E87	1000859
142	Control Ring	1	8E85	1001578
143	Turbine Cover	1	14E77	1000321
144	Spider Assembly	1	8E86	1001579
145	Shaft Bearing Retainer Nut	1	12E102	1000244
146	Finger Spring	1	8E64	1001574
147	Bearing	1	4E73	1000854
148	Washer	1	8E74	1001575
149	Brake Disc Return Spring	1	4E76	1000855
150	Disc Brake	1	8E78	1001576
151	Turbine Rotor	1	12E54	1000269
152	Turbine Seal	1	14E58074	1042894
153	O-Ring, Buna, 0.489 x 0.07 in (pkg. 6)	1	2M195	1000518
154 ^{A,B}	Turbine Shaft, Standard	1	12E92-S	1000294
155 ^C	Turbine Shaft, High Speed	1	12E92-H	1000293
156	Screw, M5 X 8 (pkg. 10)	3	11E53	1000178

- A. 16E
- B. 16E-P
- C. 16E-H

2.7 Countershaft, Drive Shaft and Bearings



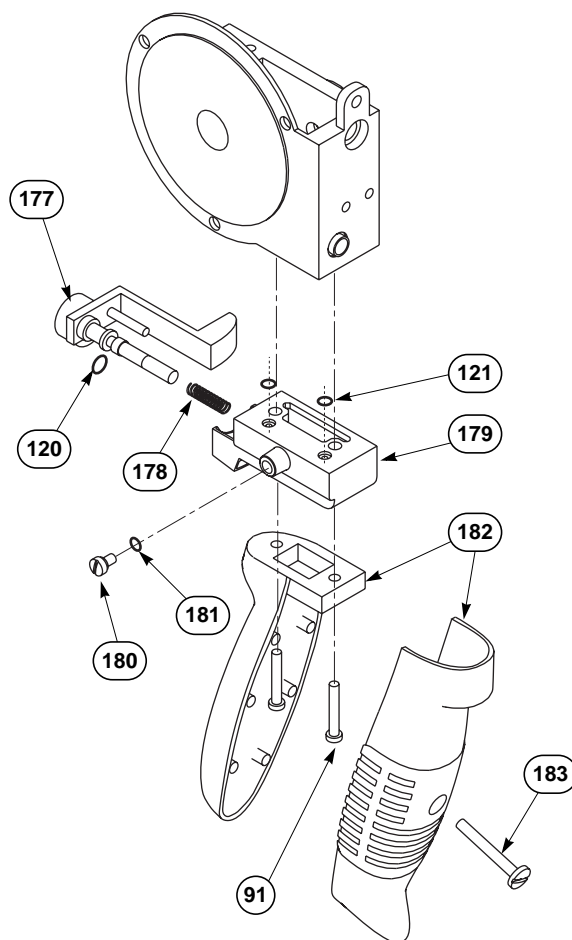
16e_countershaft



Item No.	Description	Qty.	Catalog No.	Order No.
9	Hex Set Screw, M4 X 5	1	11E67	1000184
22	O-Ring, Black Viton, 0.676 x 0.07 in (pkg. 4)	1	11E14	1000143
94	O-Ring, Buna-N, 0.301 X 0.070 (pkg. 2)	1	L186	1002023
156	Screw, M5 X 8 (pkg. 10)	4	11E53	1000178
157	Countershaft Plug	1	4E52	1000843
158	Nut, M5 X .80mm (pkg. 5)	3	11E84	1000207
159	Ball Bearing	3	4E83	1000857
160	Countershaft Bearing Retainer	1	4E51	1000842
161	O-Ring, Buna, 0.864 x 0.07 in (pkg. 3)	1	10E46	1000100
162 ^{A,B}	Countershaft Gear, Standard	1	12E93-S	1000296
163 ^C	Countershaft Gear, High Speed	1	12E93-H	1000295
164	Countershaft	1	11E91	1000210
165	Gear Cover	1	14E56	1000317
166	Ball Bearing	1	14E220	1000315
167	Bearing Follower	1	14E221	1015527
168	Bearing Cover	1	8E47	1005345
169	Screw, M5 X 20mm (pkg. 2)	2	14E34884	1064020
170	Bearing Cover Gasket	1	8E48	1001573
171	Plug	1	10E57	1004665
172	Drive Shaft Gear	1	11E66	1000183
173	Drive Shaft	1	11E65	1000182
174	Drive Shaft Bearing	1	4E69	1000852
175	Drive Shaft Seal	1	4E68	1000851
176	Gear Cover Gasket	1	4E55	1000844

- A. 16E
- B. 16E-P
- C. 16E-H

2.8 Handle and Wire Feed Valve

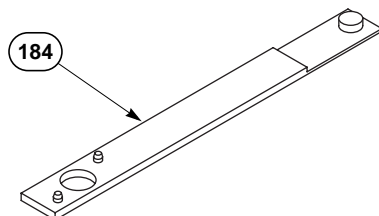
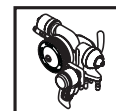


16e_handle

Item No.	Description	Qty.	Catalog No.	Order No.
91	Screw, M5 X 35	2	11E97	1000213
120	O-Ring, Buna, 0.208 x 0.07 in	1	7E129	1001434
121	O-Ring, Buna, 0.176 x 0.07 in	2	K180	1028632
177	Valve Shaft	1	11E131	1000141
178	Valve Shaft Spring	1	9E132	1001615
179	Valve Block	1	11E150	1000146
180	CAM FOLLOWER	1	7E133	1001435
181	O-Ring, Buna, 0.128 x 0.05 in	1	7E134	1001436
182	Handle Assembly	1	5P627	1001186
183	Screw, 10-32 X 1-1/4	1	7M27	1032348

3 Additional Equipment

3.1 Tools and Spares (Supplied)



16e_wrench

Item No.	Description	Qty.	Catalog. No.	Order No.
27	Siphon Plug & Nozzle Reseal Kit <i>(incl. items 22, 25&26)</i>	1	11E190	1000152
184	Drive Roll And Spanner Tool	1	14E55810	1000316
185	Hex Wrench, 3 mm	1	11E140	1000144
186	Hex Wrench, 2 mm	1	11E102	1000137
187	Hex Wrench, 2.5 mm	1	—	—
188	Driver Nut, M5	1	11E100	1000136
189	Wire Cleaning Kit	1	4E114	1000817
190	Round File Lighter	1	4E101	1000813
191	Krytox®	1	16E97041	1070061
192	Gearlube (1oz. Bottle) <i>(pkg. 3)</i>	1	12E110	1000245
193	Ear Plug (2 Plug Package)	6	DJ292	1001833
194	Eye Protectors, Shade 5 Lens	1	10E193	1000097
195	Earmuff-Hearing Protectors	1	DJ294	1035521

3.2 Hoses (Supplied Separately)

Item No.	Description	Qty.	Catalog. No.	Order No.
196	6H Hose Package (4.6 m / 15') <i>(3GF/3AF to gun)</i>	—	6H	1001317
197	Twin Oxygen and Acetylene Hose (Green/Red)	1	6H40	1001318
198	Air Hose (Black)	1	6H50	1001319
199	6HEX Hose Package (4.6 m / 15') <i>(3GF/3AF to gun)</i>	—	6HEX	1001320
200	Oxygen Hose (Blue)	1	6HEX54978	1001321
201	Acetylene Hose (Red)	1	6HEX55000	1001322
202	Propane Hose (Orange)	1	6HEX54990	1068294
198	Air Hose (Black)	1	6H50	1001319
203	7H Hose Package (10.7 m / 35') <i>(3GF/3AF to gun)</i>	—	7H	1033681
204	Twin Oxygen and Acetylene Hose (Green/Red)	1	7H40	1032254
205	Air Hose (Black)	1	7H50	1001451
206	7HEX Hose Package (10.7 m / 35') <i>(3GF/3AF to gun)</i>	—	7HEX	1001453
207	Oxygen Hose (Blue)	1	7HEX54984	1001454
208	Acetylene Hose (Red)	1	7HEX55001	1001455
209	Propane Hose (Orange)	1	7HEX54991	1018741
205	Air Hose (Black)	1	7H50	1001451

3.3 Optional Equipment

Item No.	Description	Qty.	Catalog. No.	Order No.
210	Turbine Cover Repair Kit <i>(includes the following items:)</i>	—	14ERK	1031432
211	Gasket Sealant (4 fl. oz. Can)	1	14E54950	1031434
143	Turbine Cover	1	14E77	1000321
147	Bearing	1	4E73	1000854
165	Gear Cover	1	14E56	1000317
166	Ball Bearing	1	14E220	1000315
170	Bearing Cover Gasket	1	8E48	1001573
175	Drive Shaft Seal	1	4E68	1000851
176	Gear Cover Gasket	1	4E55	1000844
Spray Gun Extensions				
	1 – Foot Extension	—	3XT-1	1000762
	2 – Foot Extension	—	3XT-2	1000771
	3 – Foot Extension	—	3XT-3	1000776