

Product Data Sheet

Metco 5PT-II-1 / 5PT-II-2 Extension Modules for the Metco 5P-II Combustion Powder Flame Spray Gun

Metco™ 5PT-II series extension modules are a cost effective accessory designed to increase the functionality of the Metco 5P-II Powder Combustion Gun by permitting the coating of interior bore diameters and surfaces.

Each of these extension modules is of rugged and sturdy construction. They are designed for use with the Metco 5P-II gun; replacing the Metco 5P-II gun air cap, nozzle assembly, siphon plug assembly, and seal in a manner identical to standard Metco 5P-II gun hardware.

1 General Description

Extension modules have a gas tube assembly with a standard nozzle for spraying at angle of 80°. Inside diameters as small as 127 mm (5 in) can be coated, depending on the required spray distance for the specific material being applied. Hardware for spraying at 45° or 0° are optionally available.

Air passages through the extension module provide a shield of air around the flame to cool the workpiece and the extension, thus reducing the chance of overheating and eliminating the need to interrupt spraying for auxiliary cooling.

Extension modules are available in three standard lengths:

5PT-II-1:	305 mm	(1 ft)
5PT-II-2:	610 mm	(2 ft)
5PT-II-3:	910 mm	(3 ft)

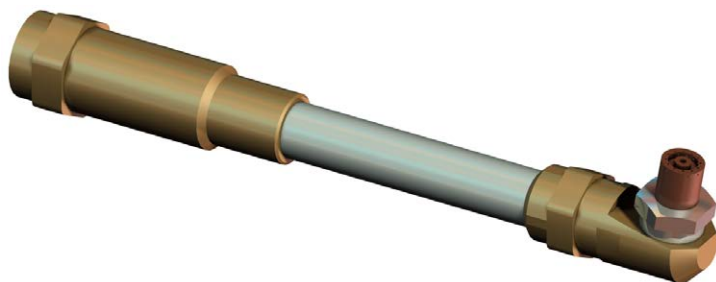
2 Features and Benefits

- Cost effective: Extends the capability of an existing Metco 5P-II powder combustion gun
- Rugged design: Built for long service life with limited maintenance
- Choice of fuel gas: Allows spray operations to choose between acetylene and hydrogen
- Integrated cooling: Allows continuous spraying without the need to cool the workpiece and extension
- O-ring seals between nozzle and siphon plug: Ensures safe and reliable operation without the risk of backfire and simplifies gun maintenance
- Choice of tube assemblies: Permits coating application at different angles
- Simple to maintain: Uses the same nozzle and siphon plug assemblies as the Metco 5P-II series guns

3 Accessories and Options

Oerlikon Metco offers a variety of options that allow configuration of the Metco 5P-II gun equipped with an extension module for use in a wide number of coating applications and to suit specific production requirements. These include hoses, nozzles, siphon plugs, metering valves and air caps. Customers should choose the correct parts for their specific coating application and spray requirements.

For a complete list of optional parts and spare parts, please refer to the parts lists section of the reference manual.



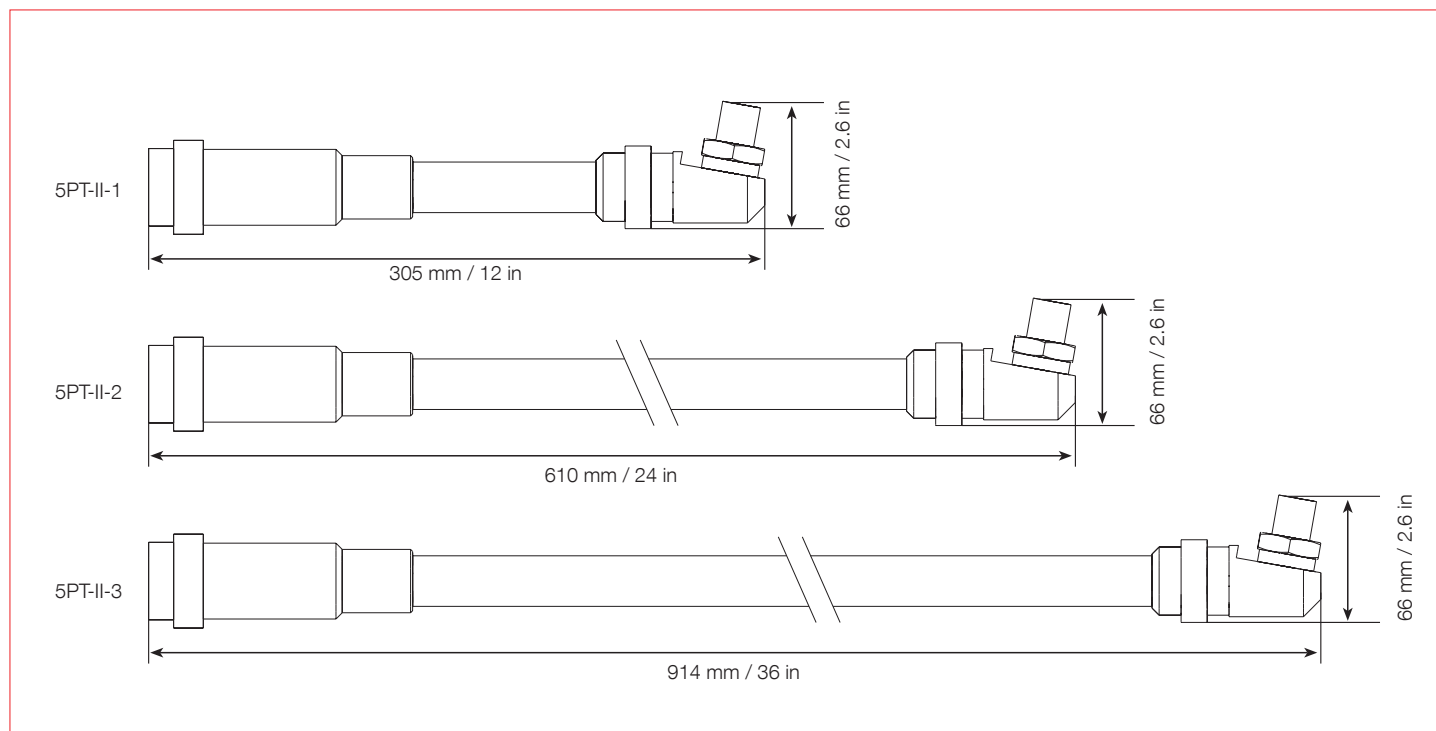
5PT-II-1 Extension Module with Standard 80° Spray Head



Optional 45° Spray Head

4 Technical Data

4.1 Dimensions



4.2 Specifications

Process Gases

Fuel Gas Acetylene or hydrogen

Oxygen

Air Requirements

Flow	approx.	94 NLPM	210 SCFH
Pressure		2.4 to 2.8 bar	35 to 40 psi
Quality		clean, dry and oil-free	

Application

Minimum bore size*	127 mm	5 in
Spray angles	standard: 80°, optional: 45° or 0°	

* Dependant on specific coating application, spray angle and coating material applied

Information is subject to change without prior notice.