

FLAME SPRAY GUN

# SPARE PARTS

MASTER JET / TOP JET / Z JET  
MASTER JET AUTO IV



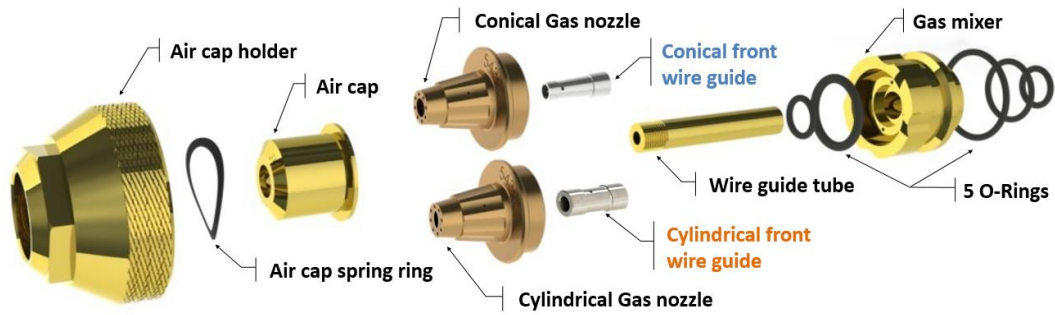
SAINT-GOBAIN COATING SOLUTIONS



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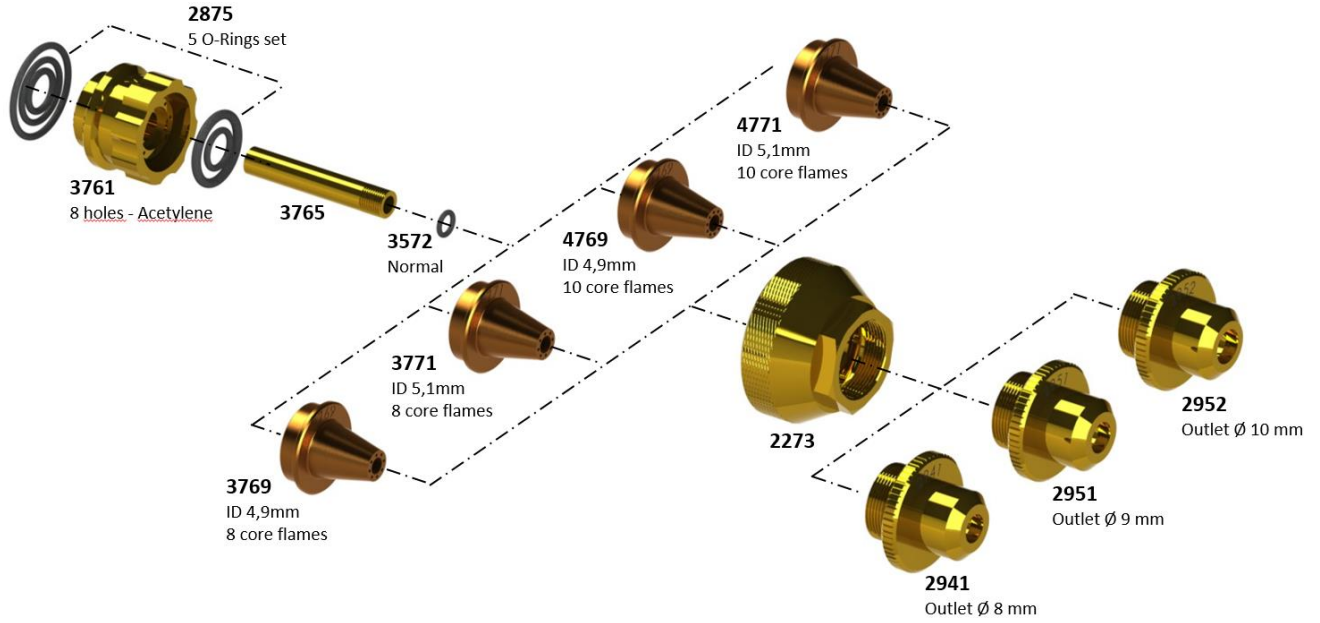
# 1. WIRE spraying – Nozzle chart for ALL GUNS



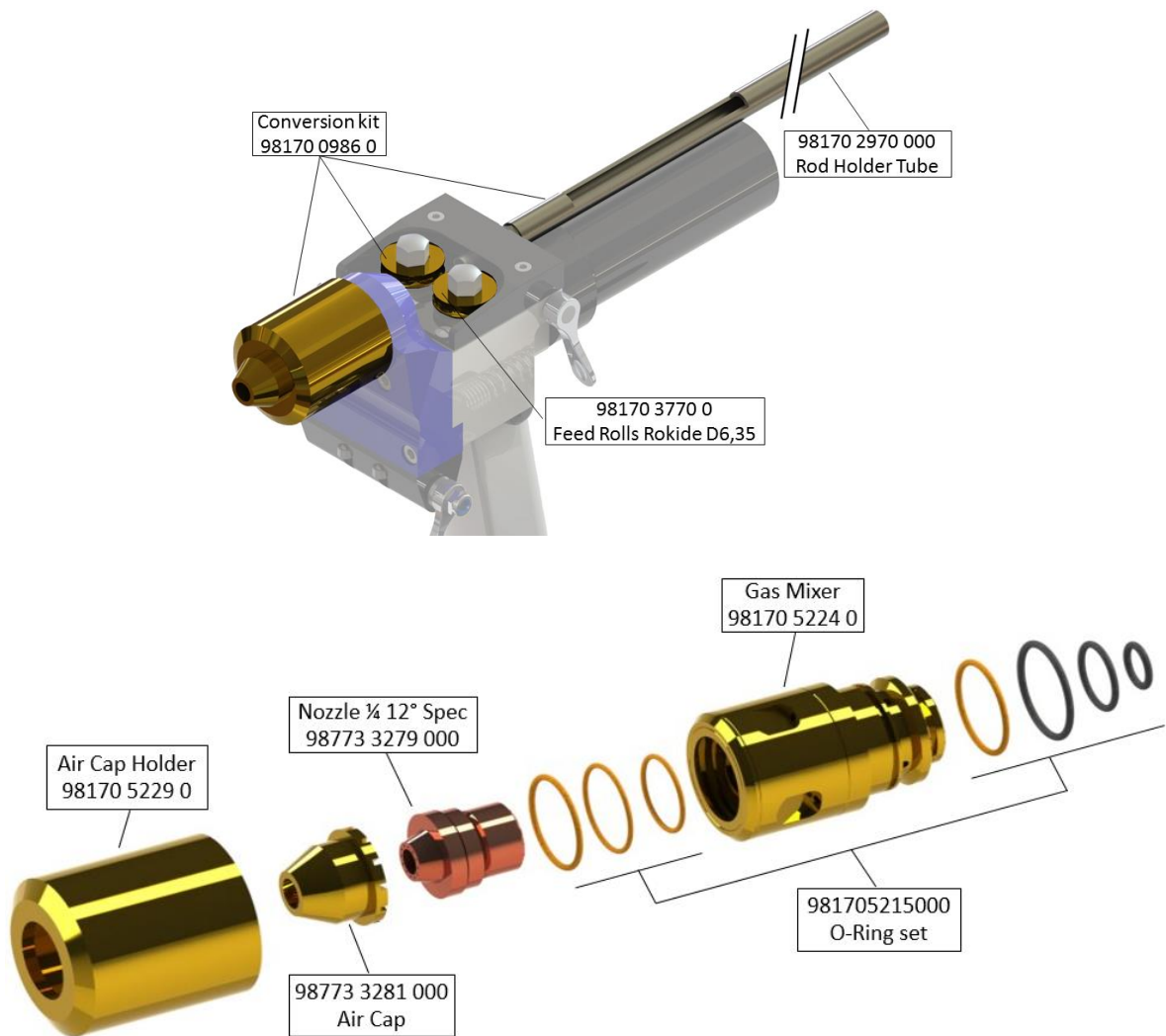
		Ø 1,5 mm (15 ga)	Ø 1,6 mm (1/16 in) (14 ga)	Ø 2 mm (0.08 in)	Ø 2,3 mm (11 ga)	Ø 2,5 mm (0.098 in)	Ø 3 mm (0.118 in)	Ø 3,17 mm (1/8 in)	Ø 4 mm	Ø 4,75 mm (3/16 in)	Ø 5 mm
		5515 5520 (acetylene only)		5520	5520 5530	5530		5531	5540	5550	
OR	CONICAL			5420		4430			4440	5450	
				5315	5316	5320	5323	5325	5330	5331	5340
	CYLINDRICAL			-	5488 <i>acetylene only</i>	-	5489 <i>acetylene only</i>	5490 <i>acetylene only</i>	-		
				-	5391 <i>acetylene only</i>	-	5389 <i>acetylene only</i>	5390 <i>acetylene only</i>	-		
		5230							5231		
		981702875000									
		Acetylene: 5220 (4 holes) Or 3761 (8 holes – not for low melting temperature wires < Ø2mm) Propane: 5221									
		5240									
		5241									
<b>Optional</b>											
		-		5930	5930	5930	5930	5940	-		
		-		5720	5730	5730	5730	5740	-		



## 2. FLEXICORD spraying – Nozzle chart for MASTER JET & TOP JET



## 3. ROD spraying – Nozzle chart for MASTER JET

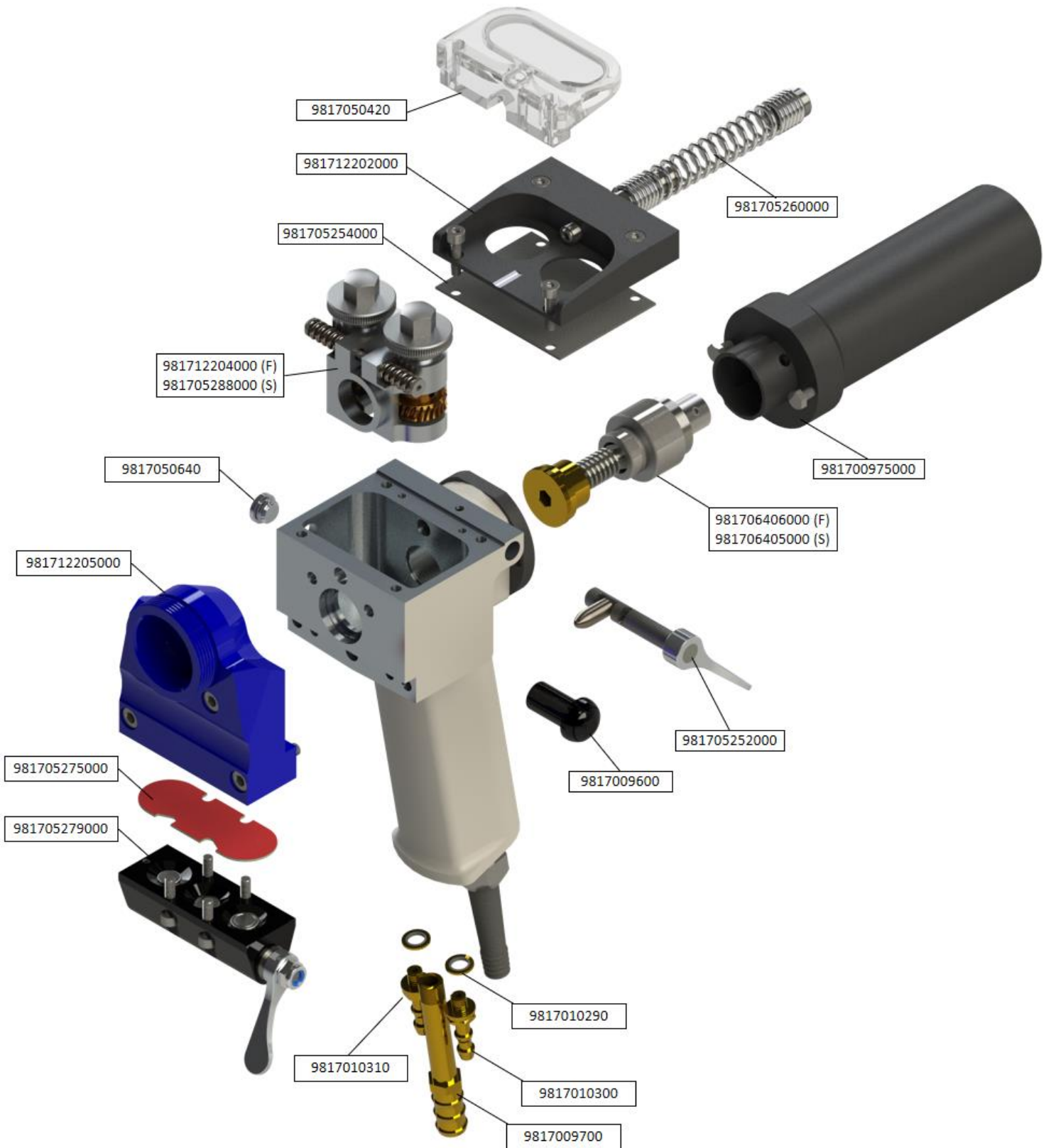


#### 4. ALL GUNS – Spare parts

Picture	Reference	Description	Picture	Reference	Description		
 <b>CONICAL WIRE GUIDE</b>	981706115000	Complete nozzle set $\varnothing$ 1,5	             	981706116000	Complete nozzle set $\varnothing$ 1,6	981712202000	S/A top cover feed rolls + screws
	981706120000	Complete nozzle set $\varnothing$ 2		9817050420	Feed rolls guard		
	981706123000	Complete nozzle set $\varnothing$ 2,3		981705254000	Set of 10 seal plate		
	981706130000	Complete nozzle set $\varnothing$ 3		981705275000	Set of 10 membranes for gas valve		
	981706131000	Complete nozzle set $\varnothing$ 3,17		981712205000	Gun head with pins + screws + O-Rings		
	981706140000	Complete nozzle set $\varnothing$ 4		981705277000	Set of O-Ring for gun head (12x)		
	981706147000	Complete nozzle set $\varnothing$ 4,75		981705279000	S/A gas lever + body (full kit)		
	981706150000	Complete nozzle set $\varnothing$ 5		981705272000	S/A gas valve shaft + spring + ball		
 <b>CYLINDRICAL WIRE GUIDE</b>	981706132000	Complete nozzle set $\varnothing$ 3	981705274000	Set of pistons for gas valve + spring + ball			
	981706133000	Complete nozzle set $\varnothing$ 3,17	981705259000	Set of 2 wire feed rolls + nuts			
	981705213000	Set of 10 O-Ring small front	981705258000	Set of 2 shafts supporting feed roll			
	981705214000	Set of 10 O-Ring big front	981705282000	Feed roll tightening adjustment set			
	981705278000	10x set of 5x O-Ring for gas mixer	9817050640	Lid T/J M/J Z/J (clamp screw)			
	981705260000	S/A rear wire guide spring (with 981705067000 + 981705068000)	981705252000	S/A feed roll opening device			
	981705067000	Spring wire guide d 1.5 & 2 + ring					
	981705068000	Spring wire guide d 3 & 3,17 + ring					

## 5. MASTER-JET 2<sup>®</sup> – Exploded view

The Master Jet<sup>®</sup> gun is supplied in 2 versions: slow “S” and fast “F”.



## 6. MASTER-JET 2<sup>®</sup> – Spare parts

Picture	Reference	Description	Picture	Reference	Description		
 <b>CONICAL WIRE GUIDE</b>	981706115000	Complete nozzle set $\varnothing$ 1,5	             	981706116000	Complete nozzle set $\varnothing$ 1,6	981712202000	S/A top cover feed rolls + screws
	981706120000	Complete nozzle set $\varnothing$ 2		9817050420	Feed rolls guard		
	981706123000	Complete nozzle set $\varnothing$ 2,3		981705254000	Set of 10 seal plate		
	981706130000	Complete nozzle set $\varnothing$ 3		981705275000	Set of 10 membranes for gas valve		
	981706131000	Complete nozzle set $\varnothing$ 3,17		981706405000	S/A worm screw <b>slow</b> speed master reducer		
	981706140000	Complete nozzle set $\varnothing$ 4		981706406000	S/A worm screw <b>fast</b> speed master reducer		
	981706147000	Complete nozzle set $\varnothing$ 4,75		9817062200	Worm screw slow		
	981706150000	Complete nozzle set $\varnothing$ 5		9817062190	Worm screw fast		
	 <b>CYLINDRICAL WIRE GUIDE</b>	981706132000		Complete nozzle set $\varnothing$ 3	981700975000	S/A motor for master jet <sup>®</sup> + cover + flange	
981706133000		Complete nozzle set $\varnothing$ 3,17	981712205000	Gun head with pins + screws + O-Rings			
	981705213000	Set of 10 O-Ring small front	981705277000	Set of O-Ring for gun head (12x)			
	981705214000	Set of 10 O-Ring big front	981705279000	S/A gas lever + body (full kit)			
	981705278000	10x set of 5x O-Ring for gas mixer	981705272000	S/A gas valve shaft + spring + ball			
	981705260000	S/A rear wire guide spring (with 981705067000 + 981705068000)	981705274000	Set of pistons for gas valve + spring + ball			
	981705067000	Spring wire guide d 1.5 & 2 + ring					
	981705068000	Spring wire guide d 3 & 3,17 + ring					

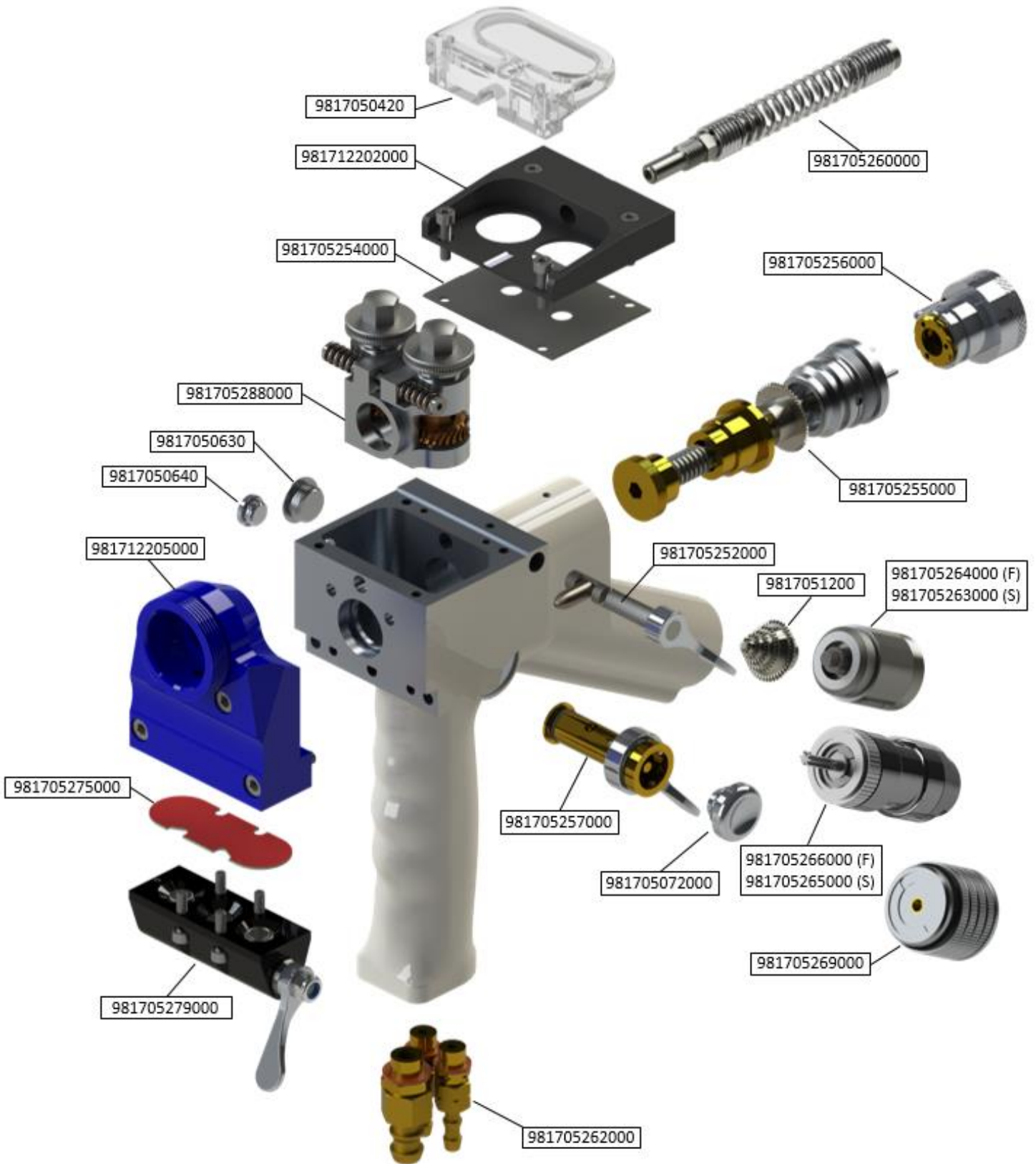
Picture	Reference	Description
	981712204000	S/A full set of clamp <b>(fast)</b>
	981705288000	S/A full set of clamp <b>(slow)</b>
	981705259000	Set of 2 wire feed rolls + nuts
	981705251000	Set of tangent wheel + bearings <b>(slow)</b>
	981705281000	Set of tangent wheel + bearings <b>(fast)</b>
	981705258000	Set of 2 shafts supporting feed roll
	981705282000	Feed roll tightening adjustment set

Picture	Reference	Description
	9817050640	Lid T/J M/J Z/J (clamp screw)
	981705252000	S/A feed roll opening device
	9817009700	Air tail m/j
	9817010300	Gas tail m/j-z/j
	9817010310	Oxygen tail m/j-z/j
	9817010290	Ring
	9817009600	Motor switch m/j
	9817084410	Male connector 6 pins



## 7. TOP JET – Exploded view

The Top jet gun can be supplied with two air motor versions: slow "S" and fast "F".



## 8. TOP JET – Spare parts

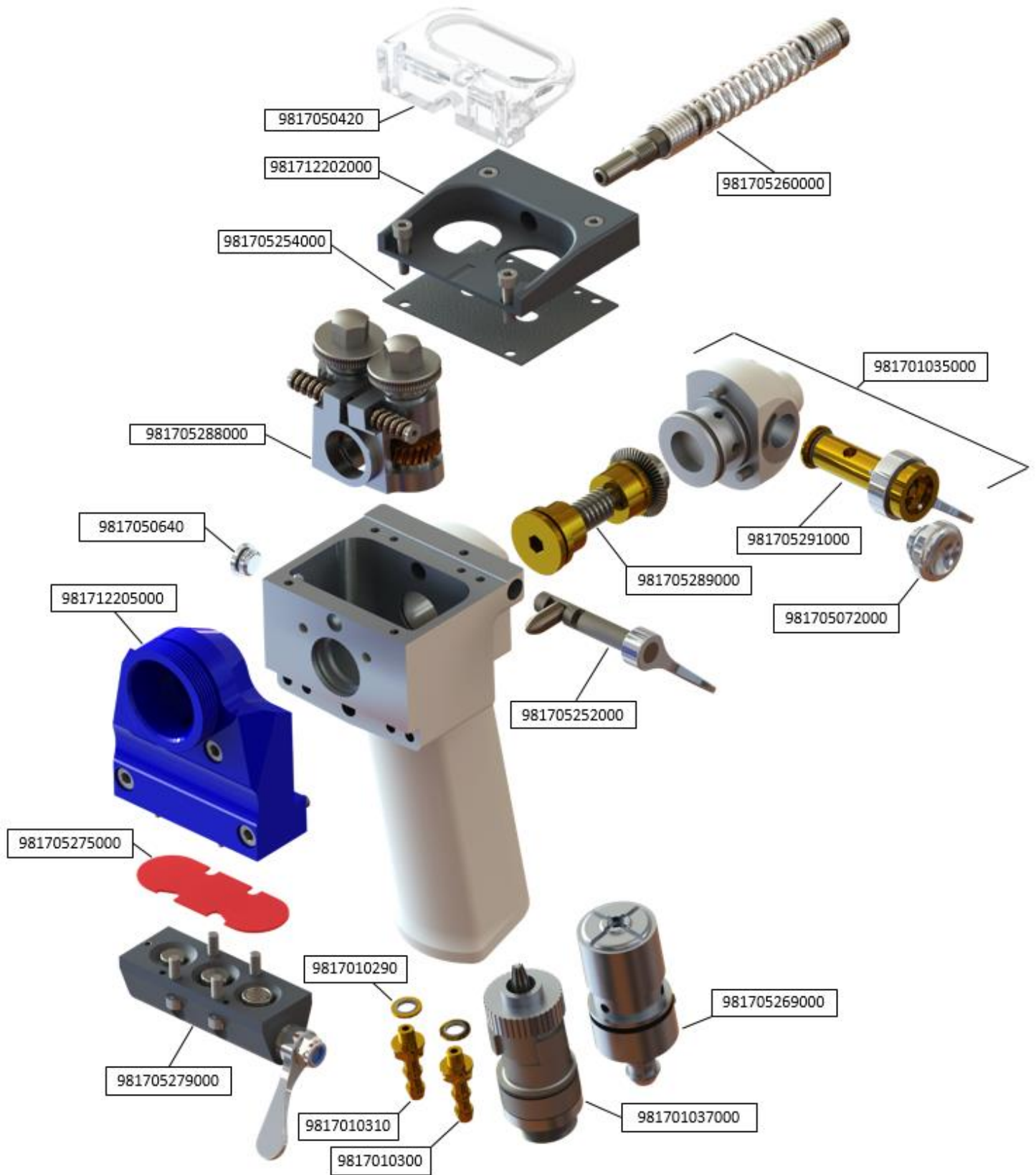
Picture	Reference	Description	Picture	Reference	Description	
 <p>CONICAL WIRE GUIDE</p>	981706115000	Complete nozzle set $\varnothing$ 1,5		9817050420	Feed rolls guard	
	981706116000	Complete nozzle set $\varnothing$ 1,6		981705254000	Set of 10 seal plate	
	981706120000	Complete nozzle set $\varnothing$ 2			981705275000	Set of 10 membranes for gas valve
	981706123000	Complete nozzle set $\varnothing$ 2,3			981712205000	Gun head with pins + screws + O-Rings
	981706130000	Complete nozzle set $\varnothing$ 3				981705277000
	981706131000	Complete nozzle set $\varnothing$ 3,17				981705279000
	981706140000	Complete nozzle set $\varnothing$ 4				981705272000
	981706147000	Complete nozzle set $\varnothing$ 4,75				981705274000
981706150000	Complete nozzle set $\varnothing$ 5			981705288000	S/A full set of clamp	
 <p>CYLINDRICAL WIRE GUIDE</p>	981706132000		Complete nozzle set $\varnothing$ 3		981705259000	Set of 2 wire feed rolls + nuts
	981706133000	Complete nozzle set $\varnothing$ 3,17			981705251000	Set of tangent wheel + bearings
	981705213000	Set of 10 O-Ring small front			981705040	Worm screw TJ
	981705214000	Set of 10 O-Ring big front				
	981705278000	10x set of 5x O-Ring for gas mixer				
	981705260000	S/A rear wire guide spring (with 981705067000 + 981705068000)				
	981705067000	Spring wire guide d 1.5 & 2 + ring				
	981705068000	Spring wire guide d 3 & 3,17 + ring				
	981712202000	S/A top cover feed rolls + screws				

Picture	Reference	Description
	981705258000	Set of 2 shafts supporting feed roll
	981705282000	Feed roll tightening adjustment set
	9817050640	Lid T/J M/J Z/J (clamp screw)
	9817050630	Lid T/J (fixing plug)
	981705252000	S/A feed roll opening device
	9817051200	Conical pinion assembly
	981705267000	S/A Air motor + gear TJ slow
	981705268000	S/A Air motor + gear TJ fast
	981705264000	S/A gear TJ fast 745











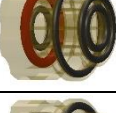









Picture	Reference	Description
	981705263000	S/A gear slow TJ 715
	981705266000	Air motor fast
	981705265000	Air motor slow
	981705255000	S/A shift change device
	981705256000	S/A gear knob
	981705269000	S/A oil tank TJ
	981705072000	Air valve s/a knob + O-ring
	981705257000	S/A air motor control shaft TJ
	981705262000	S/A tails / nuts / fiber seals TJ

## 9. Z JET – Exploded view

To order spare parts refer to the following main block exploded view:



## 10.Z JET – Spare parts

Picture	Reference	Description	Picture	Reference	Description
 <b>CONICAL WIRE GUIDE</b>	981706115000	Complete nozzle set $\varnothing$ 1,5		9817050420	Feed rolls guard
	981706116000	Complete nozzle set $\varnothing$ 1,6		981705254000	Set of 10 seal plate
	981706120000	Complete nozzle set $\varnothing$ 2			
	981706123000	Complete nozzle set $\varnothing$ 2,3		981705275000	Set of 10 membranes for gas valve
	981706130000	Complete nozzle set $\varnothing$ 3			
	981706131000	Complete nozzle set $\varnothing$ 3,17			
	981706140000	Complete nozzle set $\varnothing$ 4		981712205000	Gun head with pins + screws + O-Rings
	981706147000	Complete nozzle set $\varnothing$ 4,75			
981706150000	Complete nozzle set $\varnothing$ 5		981705277000	Set of O-Ring for gun head (12x)	
 <b>CYLINDRICAL WIRE GUIDE</b>	981706132000	Complete nozzle set $\varnothing$ 3		981705279000	S/A gas lever + body (full kit)
	981706133000	Complete nozzle set $\varnothing$ 3,17			
	981705213000	Set of 10 O-Ring small front		981705272000	S/A gas valve shaft + spring + ball
	981705214000	Set of 10 O-Ring big front			
	981705278000	10x set of 5x O-Ring for gas mixer		981705274000	Set of pistons for gas valve + spring + ball
	981705260000	S/A rear wire guide spring (with 981705067000 + 981705068000)		981705288000	S/A full set of clamp
	981705067000	Spring wire guide d 1.5 & 2 + ring			
	981705068000	Spring wire guide d 3 & 3,17 + ring			
	981712202000	S/A top cover feed rolls + screws		981705251000	Set of tangent wheel + bearings
				9817010140	Worm screw + pin Z/J

Picture	Reference	Description
	981705258000	Set of 2 shafts supporting feed roll
	981705282000	Feed roll tightening adjustment set
	9817050640	Lid T/J M/J Z/J (clamp screw)
	981705252000	S/A feed roll opening device
	981701037000	S/A Air motor z jet
	981705291000	S/A oil tank ZJ
	981705289000	S/A Worm screw + flat gear




Picture	Reference	Description
	981705072000	Air valve s/a knob + O-ring
	981705291000	S/A air motor control shaft ZJ
	981701035000	S/A Air motor valve unit
	9817010290	Ring
	9817010300	Gas tail M/J-Z/J
	9817010310	Oxygen tail M/J-Z/J

## 11.GAS CONTROL PANEL 1090 & 1080



9811016640	Pressure gage 0-10 bar	
9811016620	Pressure gage 0-6 bar (oxygen & fuel gas)	
9811010650	Pressure regulator air	
9811010660	Pressure regulator oxygen	
9811010670	Pressure regulator acetylene	
9811010680	Pressure regulator propane	
9817117600	Rotameter oxygen	
9817117610	Rotameter fuel gas (propane & acetylene)	
981101391000	Air filter <i>For 1060 &amp; 1090 gas control panel</i>	
981121101000	Air pressure regulator + filter <i>For Basic flowmeters &amp; 1080</i>	

## 12.Hose package for 1060, 1090, Basic Flowmeter, 1080:

References	Designation	Picture
981101310000	Hoses ace/prop/oxy/air lg. 10m + female couplings	
981701319000	Mini-hose set acetylene/propane lg. 2m + male couplings	
9817051590	Quick arrestors (pair of) oxy/gas female	

## 13.WIRE SPRAYING - Extensions for ALL GUNS

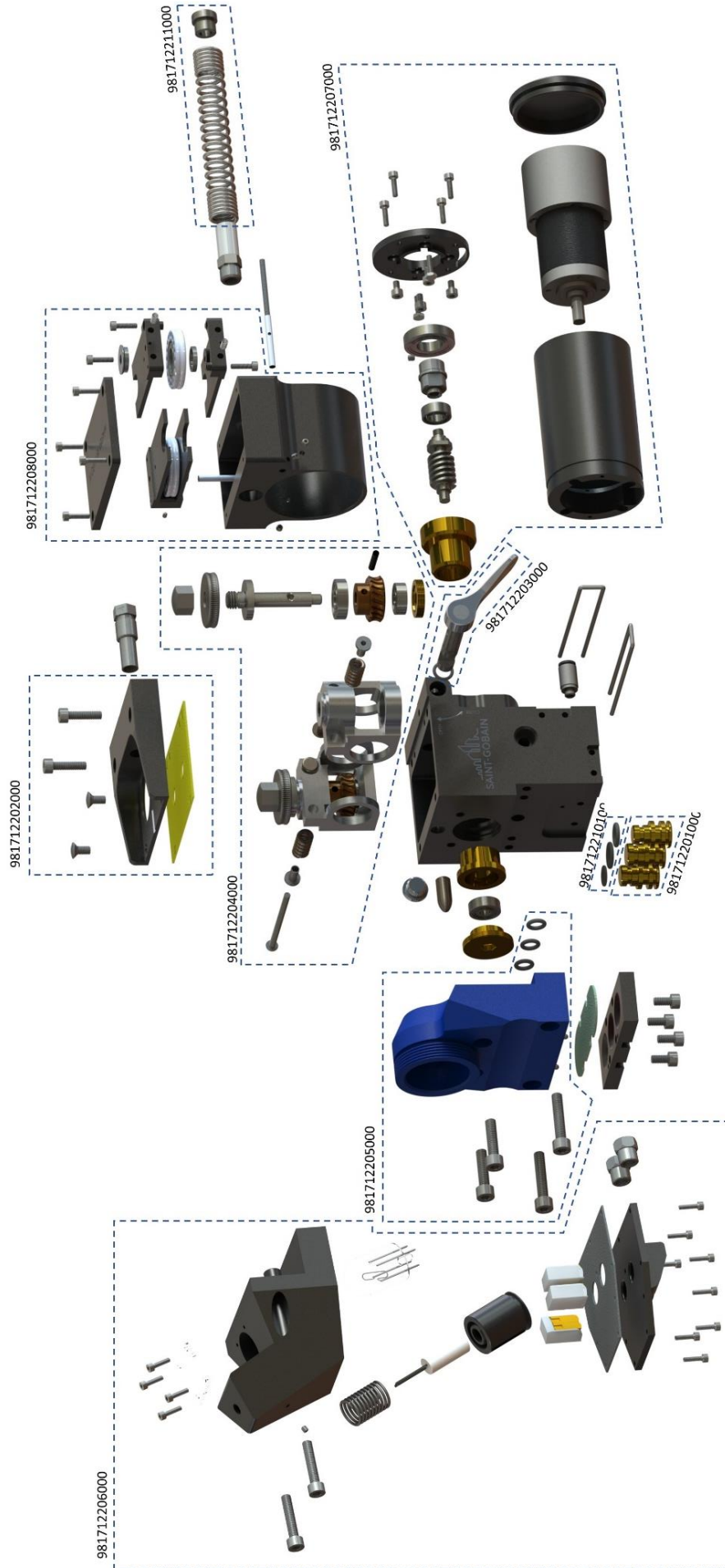


	Reference	Designation
<b>O-rings</b>	981705283000	Set of 3 O-rings (back)
<b>Wire guide tube</b>	9817024270	Short wire guide for extensions
<b>Extensions</b>	981711308000 981711304000 981711307000 981711311000	Extension length 200 mm Extension length 330 mm Extension length 660 mm Extension length 1000 mm
<b>O-rings</b>	981705278000	10 x set of 5 O-rings gas mixer
<b>Gas mixer</b>	9817052210 9817052200	Propane gas mixer Acetylene gas mixer
<b>Wire guide tube</b>	9817024270	Short wire guide for extensions



- Each references include:
- Angle air cap (98170 5730 0)
  - Air cap ring spring (98170 5241 0)








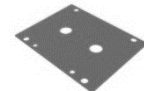


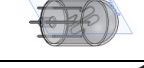





# 14.MASTER JET AUTO IV – Exploded view



## 15.MASTER JET AUTO IV – Spare parts

Picture	Reference	Description
 <b>CONICAL WIRE GUIDE</b>	981706115000	Complete nozzle set Ø 1,5
	981706116000	Complete nozzle set Ø 1,6
	981706120000	Complete nozzle set Ø 2
	981706123000	Complete nozzle set Ø 2,3
	981706130000	Complete nozzle set Ø 3
	981706131000	Complete nozzle set Ø 3,17
	981706140000	Complete nozzle set Ø 4
	981706147000	Complete nozzle set Ø 4,75
981706150000	Complete nozzle set Ø 5	
 <b>CYLINDRICAL WIRE GUIDE</b>	981706132000	Complete nozzle set Ø 3
	981706133000	Complete nozzle set Ø 3,17
	981705213000	Set of 10 O-Ring small front
	981705214000	Set of 10 O-Ring big front
	981705278000	10x set of 5x O-Ring for gas mixer
	981705277000	Set of O-ring for gun head (12x)
	981705252000	S/A feed roll opening device
	981705259000	Set of 2 feed rolls + nuts
	9817050420	Feed rolls guard

Picture	Reference	Description
	981712204000	S/A full set of clamp <b>(fast)</b>
	981705258000	Set of 2 shafts supporting feed roll
	981705282000	Feed roll tightening adjustment set
	981705281000	Set of tangent wheel + bearings
	9817062190	Worm screw
	9817050640	Lid T/J M/J Z/J (clamp screw)
	981712202000	S/A Top cover feed rolls + screws
	981705254000	Set of 10 seal plates
	981705275000	Set of 10 membrane for gas valve
	9817120320	Igniter
	9817045520	Flame sensor
	9817120080	Inductive sensor D3
	9817120120	Wire guide tube N°1 D4,75
	9817120130	Wire guide tube N°1 D3-3,17
	9817120150	Wire guide tube N°1 D1,5-2
	9817120690	Wire guide tube N°2 D4,75
	9817120140	Wire guide tube N°2 D3-3,17
	981712060	Wire guide tube N°2 D1,5-2



