

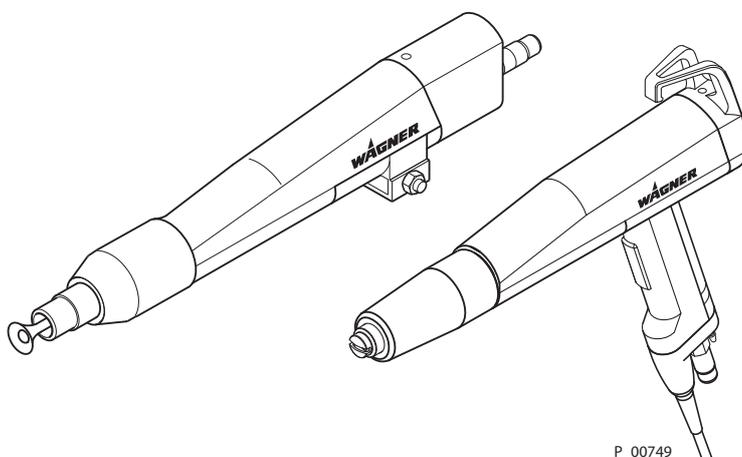


Translation of the original
Service manual

C4/T3 Guns

Version 08/ 2011

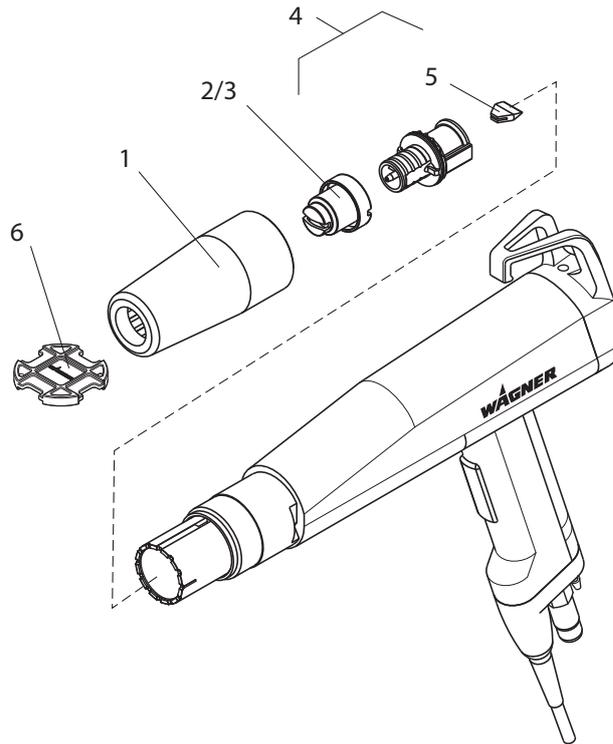
Powder Coating Guns
Manual / Automatic



P_00749

CE 0102

5.2 PEM-C4 CORONA MANUAL GUN

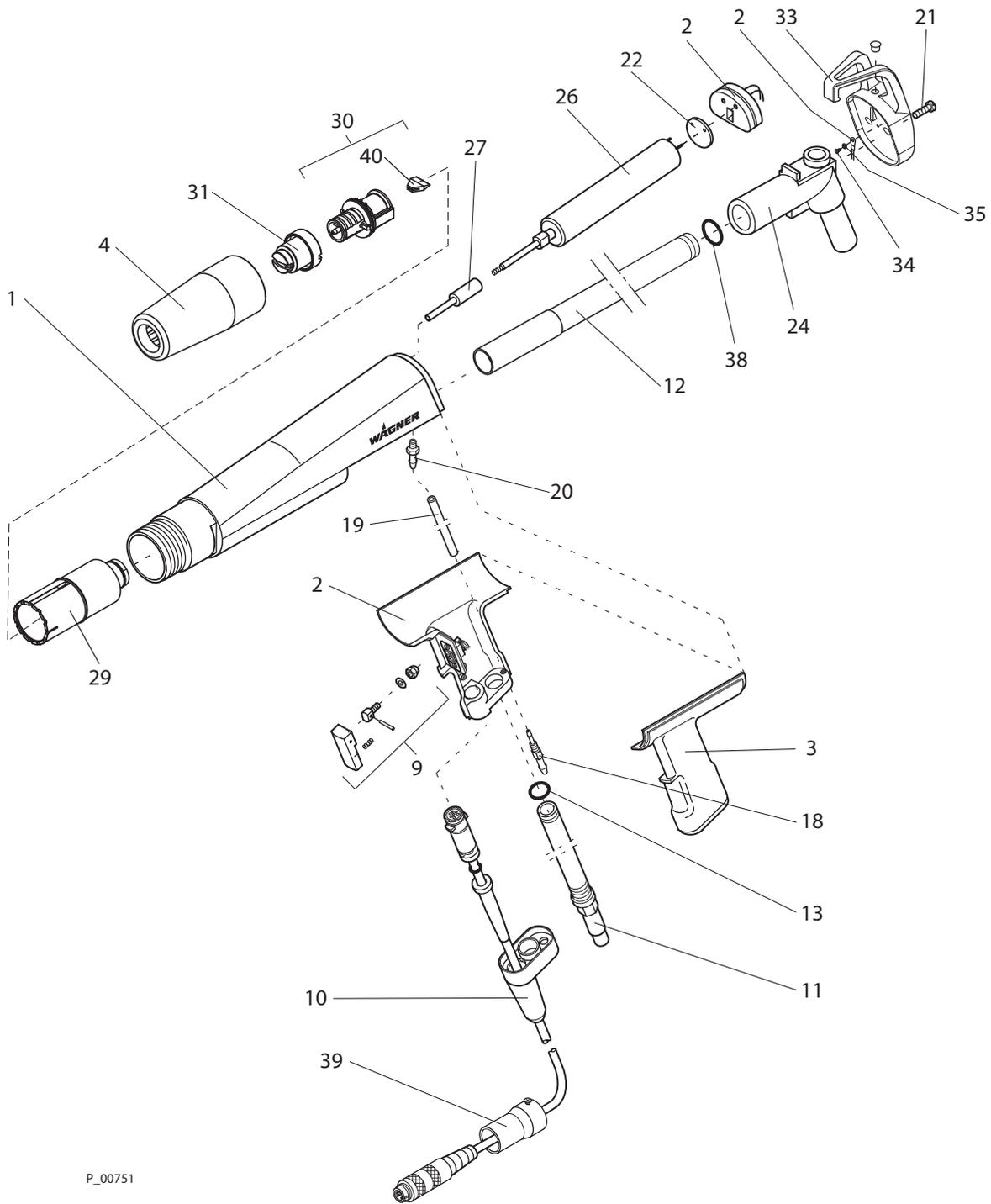


P_00710

PEM-C4 HiCoat manual gun

Item	K	Quantity	Order No.	Designation
--		1	390001	PEM-C4 HiCoat Corona manual gun
1		1	390311	Outer nut
2	◆	1	390324	F1 fan spray nozzle
3	◆	1	390325	F2 fan spray nozzle
4	◆ ★	1	390915	Electrode holder
5	◆	1	390310	Protective wedge
6		1	390342	Adjustment tool for fan spray nozzles

- ◆ Wearing part
- Not part of the standard equipment but available as a special accessory.
- ★ only available as a set



P_00751

PEM-C4 HiCoat manual gun

Item	K	Quantity	Order No.	Designation
1		1	390346	PEM spray gun housing rework
2	★	1	351985	Handle (right half), complete **
3		1	259387	Handle (left half)
4		1	390311	Outer nut
9		1	351905	PEM trigger
		1	259310	Bearing bolt
		1	259451	Bearing bolt, reworked
		1	9930804	Straight pin
		1	9994284	Compression spring
		1	9910126	Hexagon nut
		1	9920130	Washer
10		1	351652	Corona manual spray gun cable
11	◆	1	351618	PEM powder tube handle
12		1	390909	C4 powder tube (PEM)
13	◆	1	9971316	O-ring 11.6x1.2
18	◆	1	351777	Hose nipple
19		1	9982076	Hose Ø 3 mm; 0.12 inches, 0.12m; 4.72 inches
20		1	9985717	Threaded fitting
21		2	9907194	Fillister head cap screw
22	◆	1	259331	Sealing washer
24	◆	1	351764	Bend
26	◆	1	259900	PEA/PEM cascade
27		1	351320	Cable reinforcement
29		1	390204	C4 nozzle body
30	◆	1	390915	F electrode holder (complete)
31	◆	1	390324	F1 fan spray nozzle
33		1	390967	PEM-C4 cover plate
34		1	9907008	PT screw
35			9922020	Serrated lock washer
38	◆	1	9971331	O-ring
39		1	351627	Protective sleeve plug (complete)
40	◆	1	390310	Protective wedge

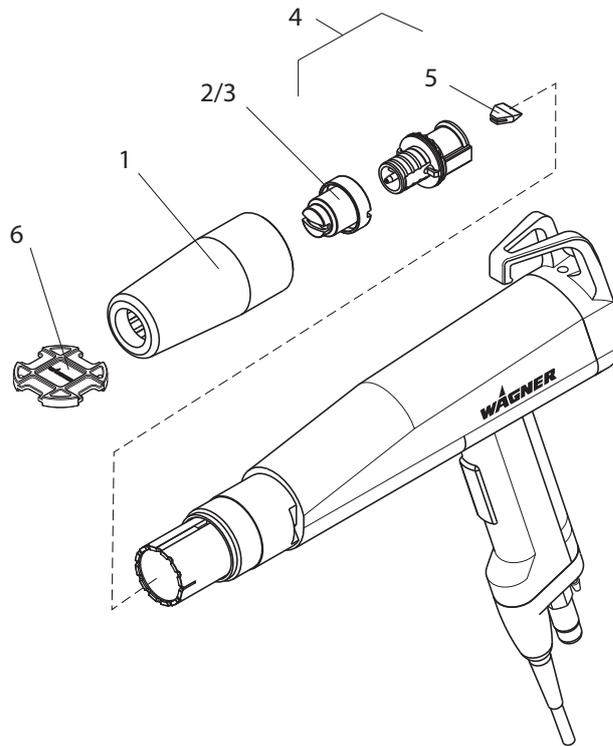
◆ Wearing part

● Not part of the standard equipment but available as a special accessory.

★ only available as a set

** The handle should only be replaced as a complete module. Repair is not possible.

5.3 PEM-C4R HICOAT CORONA MANUAL GUN

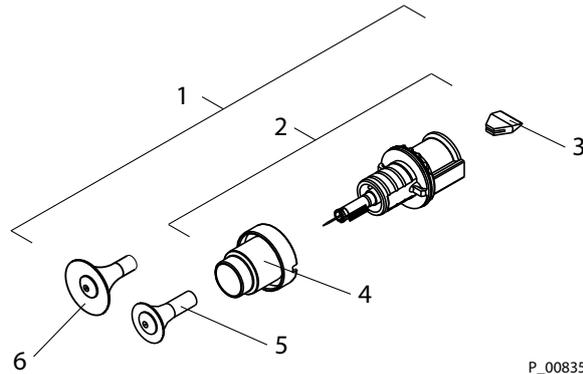


P_00710

PEM-C4R HiCoat manual gun

Item	K	Quantity	Order No.	Designation
--		1	390002	PEM-C4R HiCoat Corona manual gun
1		1	390311	Outer nut
2	◆	1	390324	F1 fan spray nozzle
3	◆	1	390325	F2 fan spray nozzle
4	◆ ★	1	390915	F electrode holder
5	◆	1	390310	Protective wedge
6		1	390342	Adjustment tool for fan spray nozzles

- ◆ Wearing part
- Not part of the standard equipment but available as a special accessory.
- ★ only available as a set

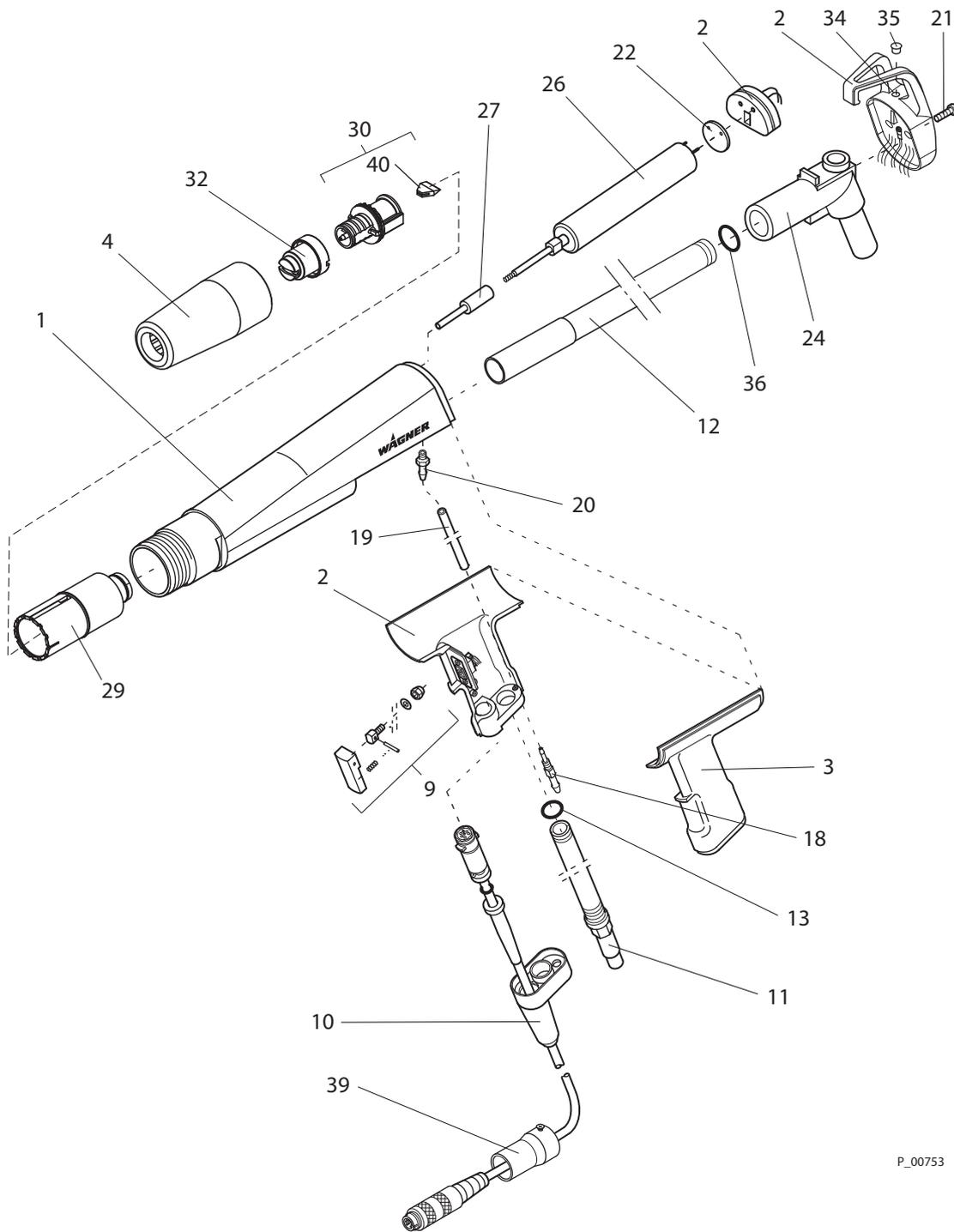


P_00835

C4 R electrode holder with nozzles

Item	K	Quantity	Order No.	Designation
1	★	1	390917	Electrode holder (complete)
2	★	1	390916	C4 R electrode holder
3	◆	1	390310	Protective wedge
4	◆	1	390313	Deflector cone sleeve
5	◆	1	390207	R20 deflector cone (Ø 20 mm; 0.79 inches)
6	◆	1	390208	R28 deflector cone (Ø 28 mm; 1.10 inches)

- ◆ Wearing part
- Not part of the standard equipment but available as a special accessory.
- ★ only available as a set



P_00753

PEM-C4R HiCoat manual gun

Item	K	Quantity	Order No.	Designation
1		1	390347	PEM spray gun housing rework
2	★	1	390926	PEM-C4R handle (right half) **
3		1	259387	Handle (left half)
4		1	390311	Outer nut
9		1	351905	PEM trigger
		1	259310	Bearing bolt
		1	259451	Bearing bolt, reworked
		1	9910126	Hexagon nut
		1	9920130	Washer
		1	9930804	Straight pin
		1	9994284	Compression spring
10		1	351652	Corona manual spray gun cable
11	◆	1	351618	PEM powder tube handle
12		1	390909	C4 powder tube (PEM)
13	◆	1	9971316	O-ring 11.6x1.2
18	◆	1	351777	Hose nipple
19		1	9982076	Hose
20		1	9985717	Threaded fitting
21		2	9907194	M6x20 fillister head cap screw
22	◆	1	259331	Sealing washer
24	◆	1	351764	Bend
26	◆	1	259900	PEA/PEM cascade
27		1	351320	Cable reinforcement
29		1	390204	C4 nozzle body
30	◆	1	390915	F electrode holder (complete)
32	◆	1	390324	F1 fan spray nozzle
34		1	9913018	M4x7.9 threaded insert
35		1	9998619	Disk stopper
36		1	9971331	O-ring 12x1
39		1	351627	Protective sleeve plug (complete)
40	◆	1	390310	Protective wedge

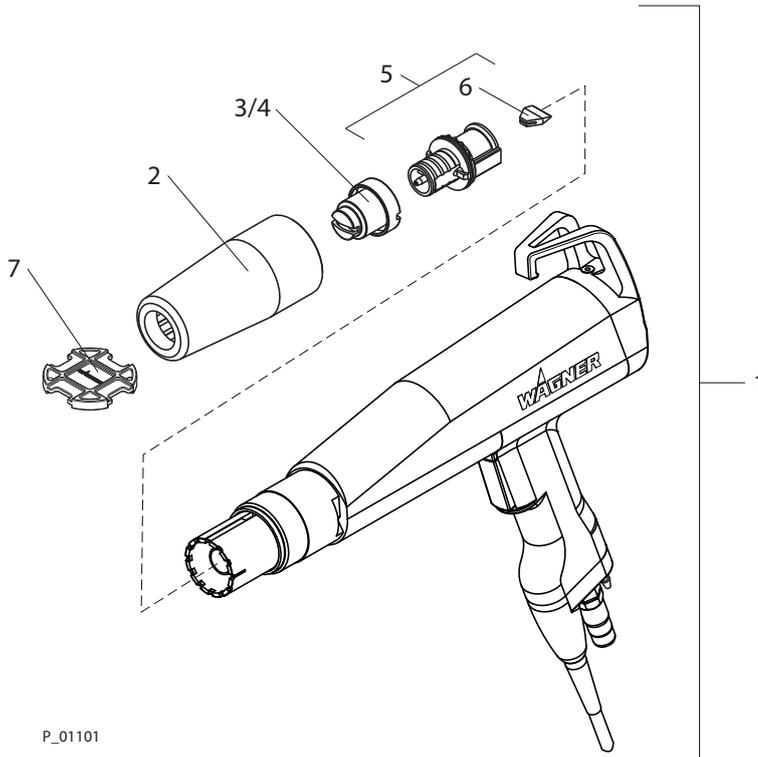
◆ Wearing part

● Not part of the standard equipment but available as a special accessory.

★ only available as a set

** The handle should only be replaced as a complete module. Repair is not possible.

5.5 PEM-C4 ERGO CORONA MANUAL GUN

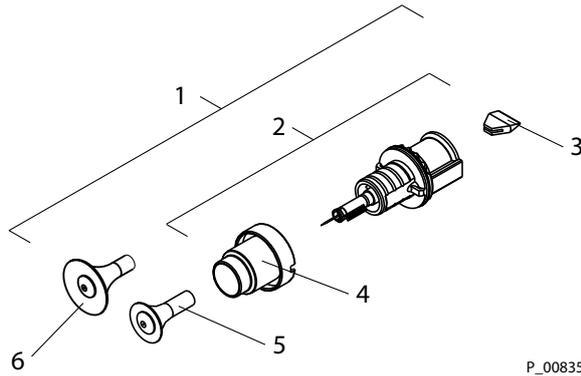


P_01101

PEM-C4-Ergo manual gun

Item	K	Quantity	Order No.	Designation
1		1	2305069	PEM-C4-Ergo Corona manual gun
2		1	390311	Outer nut
3	◆	1	390324	F1 fan spray nozzle
4	◆	1	390325	F2 fan spray nozzle
5	◆ ★	1	390915	Electrode holder
6	◆	1	390310	Protective wedge
7		1	390342	Adjustment tool for fan spray nozzles

- ◆ Wearing part
- Not part of the standard equipment but available as a special accessory.
- ★ only available as a set

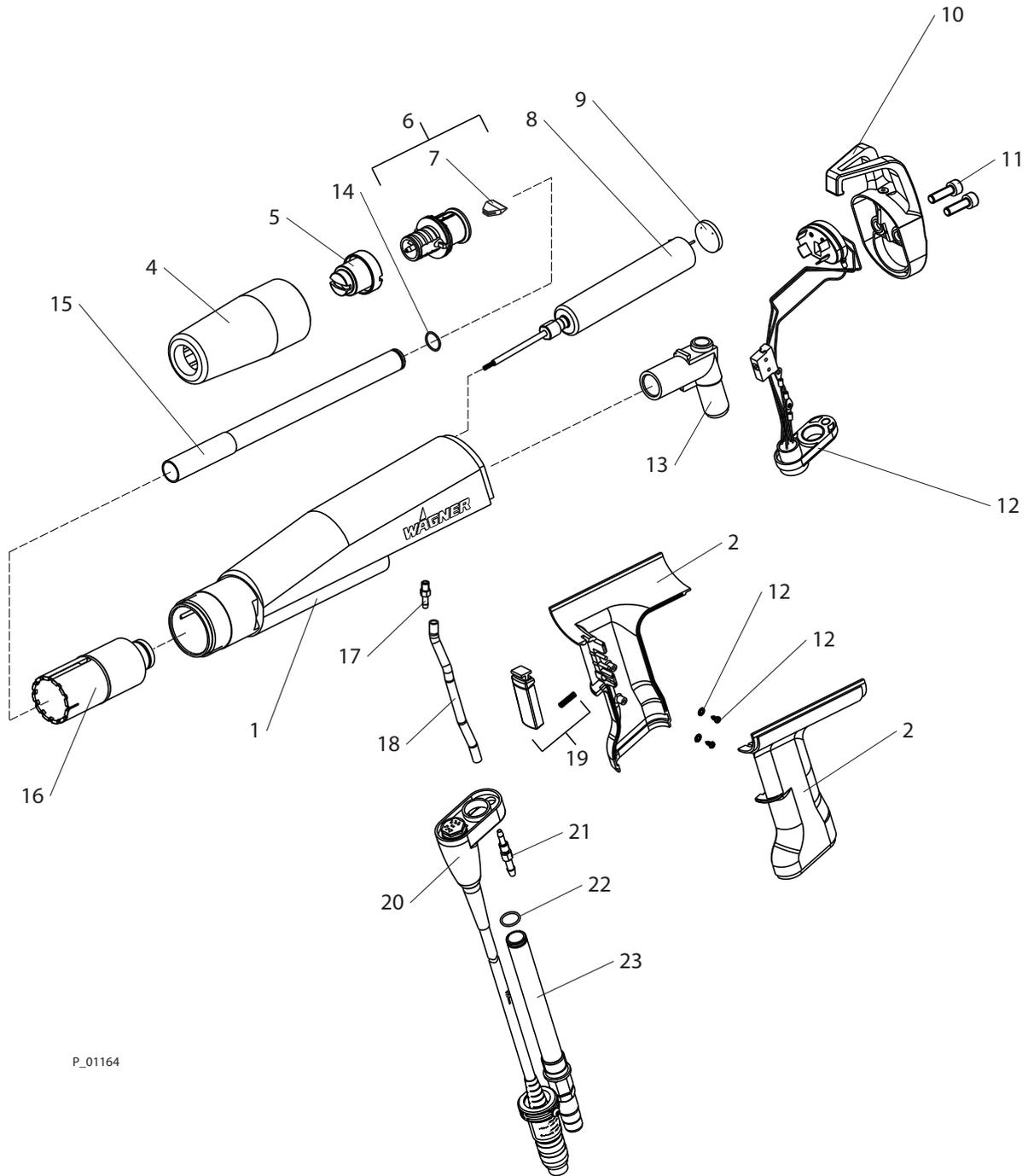


P_00835

C4 R electrode holder with nozzles

Item	K	Quantity	Order No.	Designation
1	★	1	390917	Electrode holder (complete)
2	★	1	390916	C4 R electrode holder
3	◆	1	390310	Protective wedge
4	◆	1	390313	Deflector cone sleeve
5	◆	1	390207	R20 deflector cone (∅ 20 mm; 0.79 inches)
6	◆	1	390208	R28 deflector cone (∅ 28 mm; 1.10 inches)

- ◆ Wearing part
- Not part of the standard equipment but available as a special accessory.
- ★ only available as a set



P_01164

PEM-C4-Ergo manual gun

Item	K	Quantity	Order No.	Designation
1		1	2303837	PEM-C4-Ergo spray gun housing rework
2	★	1	2314651	C4 handle (right half/left half) **
4		1	390311	Outer nut
5	◆	1	390324	F1 fan spray nozzle
6	◆	1	390915	C4 F electrode holder (complete)
7	◆	1	390310	C4 protective wedge
8	◆	1	259900	PEA/PEM cascade
9	◆	1	259331	Sealing washer
10		1	390967	PEM-C4 cover plate ET
11		2	9907194	Fillister head cap screw
12		1	2306843	PEM-C4-Ergo cable assembly ET
13		1	351764	Bend
14	◆	1	9971331	O-ring
15	◆	1	2306841	PEM-C4-Ergo powder tube ET
16	◆	1	390204	Nozzle body (complete)
17		1	9985717	Threaded fitting
18		1	9982076	Hose
19		1	2306842	PEM-C4-Ergo trigger ET
20		1	351652	Corona manual spray gun cable
21	◆	1	351777	Hose nipple
22	◆	1	9971316	O-ring
23	◆	1	351618	Adaptor tube

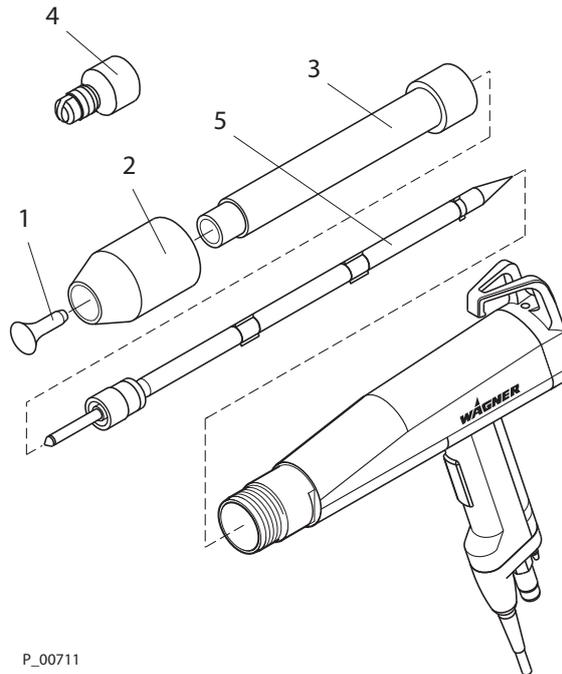
◆ Wearing part

● Not part of the standard equipment but available as a special accessory.

★ only available as a set

** The handle should only be replaced as a complete module. Repair is not possible.

6.2 PEM-T3 AND PEM-T3R TRIBO MANUAL GUN



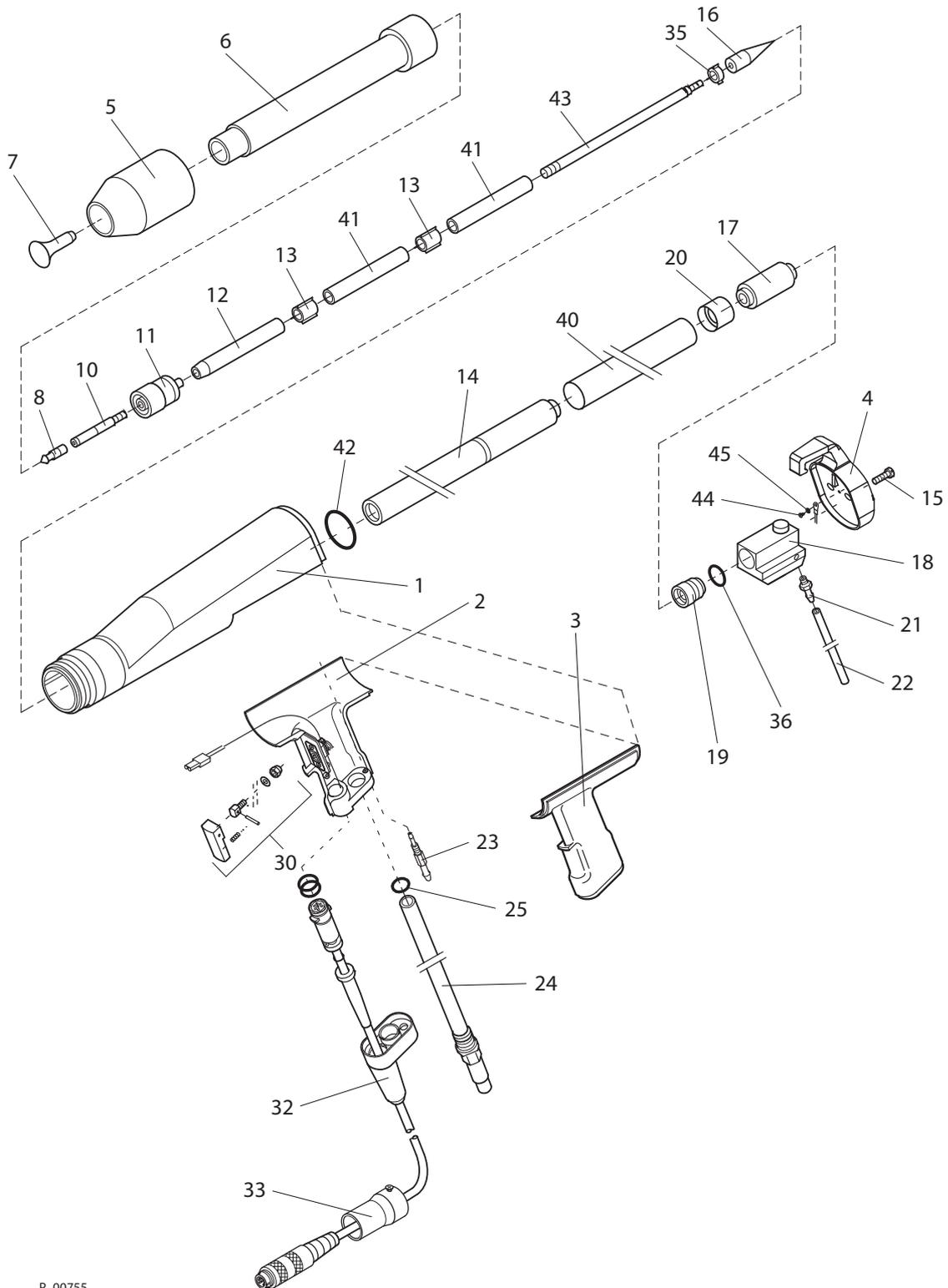
P_00711

PEM-T3/PEM-T3R manual gun

Item	K	Quantity	Order No.	Designation
--		1	351019	PEM-T3 Tribo manual gun
--		1	351041	PEM-T3R Tribo manual gun
1	◆	1	259474	Deflector cone (Ø 22mm; 0.87 inches)
1	◆ ●	1	259475	Deflector cone (Ø 28mm; 1.10 inches)
2		1	351654	Tribo outer nut
3		1	351581	Nozzle body
4	◆	1	260928	Fan spray nozzle
5	◆	1	260629	Charging body (complete)

- ◆ Wearing part
- Not part of the standard equipment but available as a special accessory.
- ★ only available as a set

SERVICE MANUAL



P_00755

PEM-T3 manual gun

Item	K	Quantity	Order No.	Designation
1		1	351637	PEM-T3 gun housing
2	★	1	351984	PEM-T3 handle (right half), complete **
3		1	259387	Handle (left half)
4		1	351770	Cover plate
5		1	351654	Tribo outer nut
6	◆	1	351581	Nozzle body
7	◆	1	259474	Deflector cone (∅ 22 mm; 0.87 inches)
8	◆	1	260632	Air nozzle (complete)
10	◆	1	260469	Deflector cone rod
11	◆	1	260463	Central air supply
12	◆	1	260470	Rod
13	◆	2	260476	Support ring
14	◆	1	259459	Powder tube
15		2	9907194	Fillister head cap screw
16	◆	1	260472	Tip
17	◆	1	259463	Intermediate tube
18	◆	1	259620	Valve housing
19	◆	1	259512	Air diffuser
20	◆	1	260468	Contact tube
21		1	9985717	Threaded fitting
22		1	9982076	Hose
23		1	259621	Non-return valve
24	◆	1	351618	PEM powder tube handle
25	◆	1	9971316	O-ring 11.6x1.2
30		1	351905	PEM trigger
		1	259310	Bearing bolt
		1	259451	Bearing bolt, reworked
		1	9910126	Hexagon nut
		1	9920130	Washer
		1	9930804	Straight pin
		1	9994284	Compression spring
32		1	351653	Tribo manual spray gun cable
33		1	351627	Protective sleeve plug (complete)
35	◆	1	260474	Ring
36	◆	1	9974005	O-ring 15x1
40		1	259473	Grounding tube

◆ Wearing part

● Not part of the standard equipment but available as a special accessory.

★ only available as a set

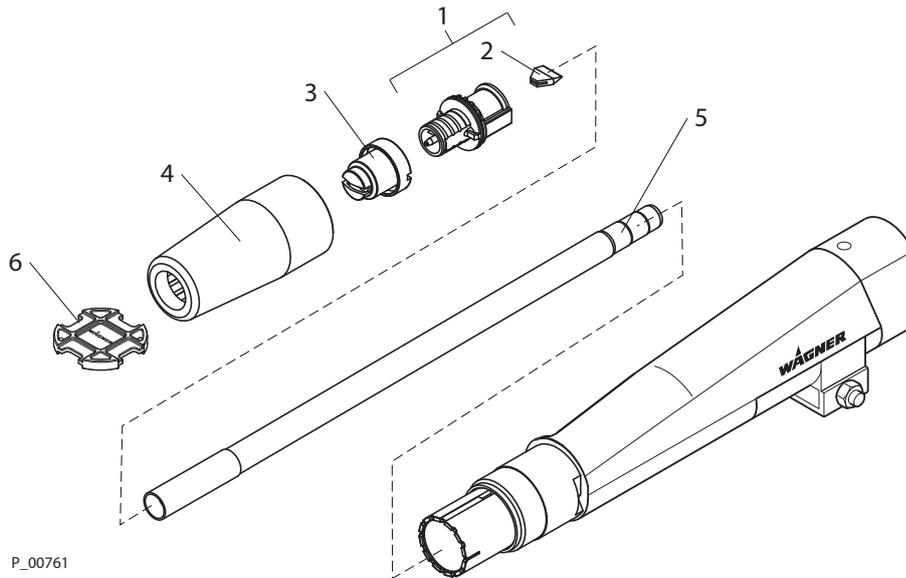
** The handle should only be replaced as a complete module. Repair is not possible.

PEM-T3 manual gun

Item	K	Quantity	Order No.	Designation
41	◆	2	260471	Charging tube
42	◆	1	9974136	O-ring 21x1
43		1	260473	Threaded bar
44		1	9907008	PT screw
45		1	9922020	Serrated lock washer

- ◆ Wearing part
- Not part of the standard equipment but available as a special accessory.
- ★ only available as a set
- ** The handle should only be replaced as a complete module. Repair is not possible.

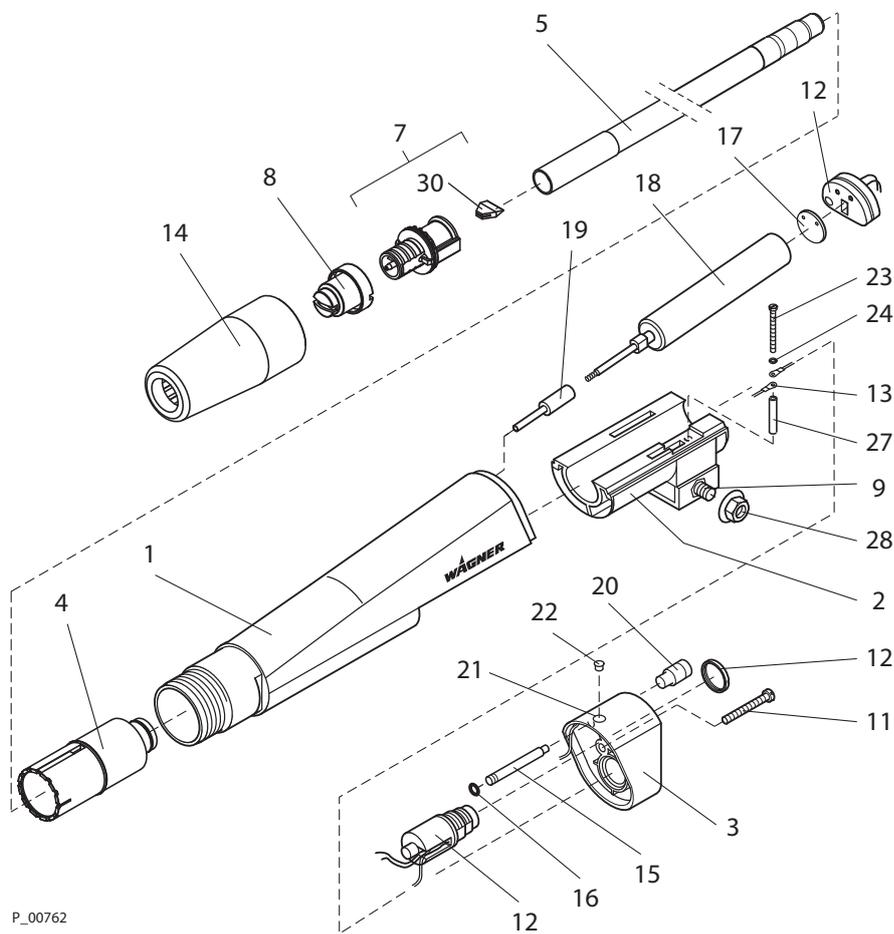
9.2 PEA-C4 HICOAT CORONA AUTOMATIC SPRAY GUN



PEA-C4 HiCoat automatic spray gun

Item	K	Quantity	Order No.	Designation
--		1	390004	PEA-C4 HiCoat Corona automatic spray gun
1	◆ ★	1	390915	F electrode holder
2	◆	1	390310	Protective wedge
3	◆	1	390324	F1 fan spray nozzle
4		1	390311	Outer nut
5	◆	1	390911	C4 ET (PEA-C4) powder tube
6	◆	1	390342	Adjustment tool for fan spray nozzles

- ◆ Wearing part
- Not part of the standard equipment but available as a special accessory.
- ★ only available as a set



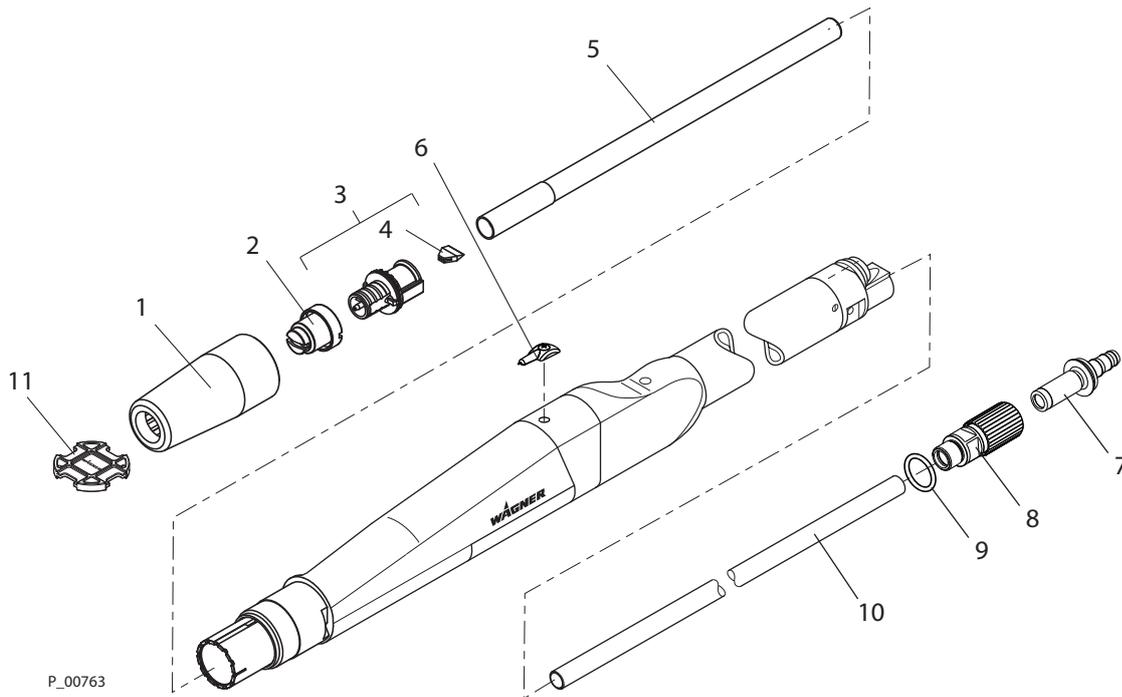
P_00762

PEA-C4 HiCoat automatic spray gun

Item	K	Quantity	Order No.	Designation
1		1	390345	PEA spray gun housing rework
2		1	351307	PEA-C2 fastener
3		1	351657	PEA-C2/C3 cover plate
4		1	390204	C4 nozzle body (complete)
5	◆	1	390911	C4 (PEA-C4) powder tube
7	◆	1	390915	F electrode holder
8	◆	1	390324	F1 fan spray nozzle
9		1	351308	Threaded bolt
11		2	9900756	M6x40 fillister head cap screw with slot
12		1	351202	PEA-C2 plug unit
13		1	362212	Strand, complete (PEA-C3)
14		1	390311	Outer nut
15		1	351330	Connecting tube
16		1	9974056	O-ring 3x1.2
17		1	259331	Sealing washer
18	◆	1	259900	PEA/PEM cascade
19		1	351320	Cable reinforcement
20		1	9999057	Straight plug connector
21		1	9913018	M4x7.9 threaded insert
22		1	9998619	Disk stopper
23		1	9900704	M3x30 fillister head cap screw with slot
24		1	9922011	Serrated lock washer
27		1	351340	Support sleeve
28		2	9913028	Locking nut
30	◆	1	390310	Protective wedge

- ◆ Wearing part
- Not part of the standard equipment but available as a special accessory.
- ★ only available as a set

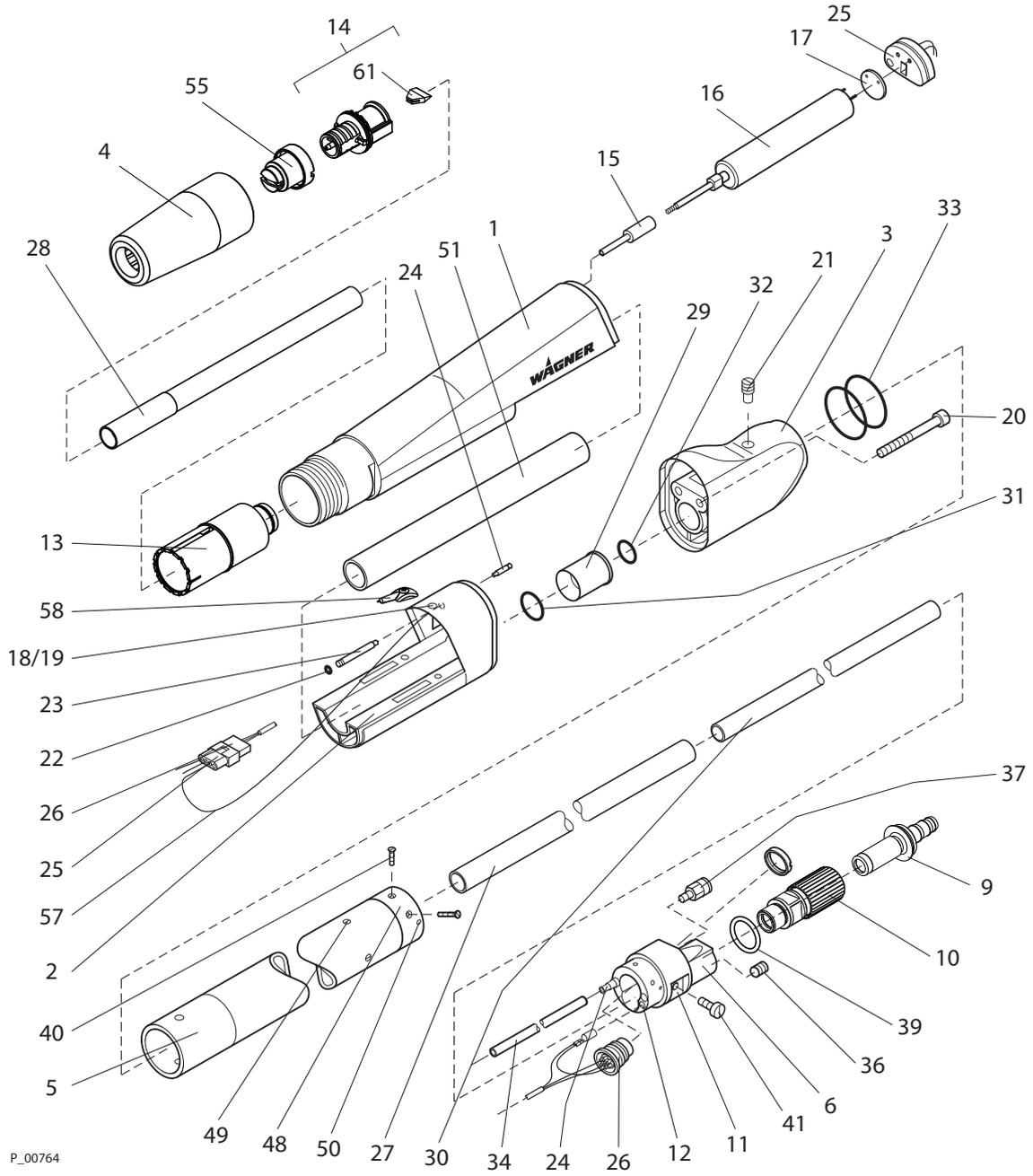
11.2 PEA-C4XL HICOAT CORONA AUTOMATIC SPRAY GUN



PEA-C4XL HiCoat automatic spray gun

Item	K	Quantity	Order No.	Designation
1		1	390311	Outer nut
2	◆	1	390324	F1 fan spray nozzle
3	◆ ★	1	390915	F electrode holder
4	◆	1	390310	Protective wedge
5	◆	1	390910	PEA-C4 XL powder tube
6	◆	1	390957	Mini Corona-Star
7	◆ ★	1	390955	Hose coupling \varnothing 10-12 mm; 0.393-0.472 inches
8	◆	1	390954	Coupling piece
9	◆	1	9974184	O-ring 22x3
10	◆	1	351565	Rear powder tube 0.85
10	◆	1	351557	Rear powder tube 1.1
10	◆	1	351549	Rear powder tube 1.4
10	◆	1	351579	Rear powder tube 1.8
11		1	390342	Adjustment tool for fan spray nozzles

- ◆ Wearing part
- Not part of the standard equipment but available as a special accessory.
- ★ only available as a set



P_00764

PEA-C4XL HiCoat automatic spray gun

Item	K	Quantity	Order No.	Designation
--		1	390005	PEA-C4XL HiCoat Corona automatic spray gun 850 mm; 33.5 inches
--		1	390006	PEA-C4XL HiCoat Corona automatic spray gun 1100 mm; 43.3 inches
--		1	390007	PEA-C4XL HiCoat Corona automatic spray gun 1400 mm; 55.1 inches
--		1	390008	PEA-C4XL HiCoat Corona automatic spray gun 1800 mm; 70.9 inches
1		1	390345	PEA spray gun housing rework
2		1	351535	Cover component
3		1	351536	Tube mounting piece
4		1	390311	Outer nut
5		1	351677	Mounting tube 1.8 (L = 1380 mm; 54.33 inches)
5		1	351546	Mounting tube 1.4 (L = 980 mm; 38.58 inches)
5		1	351555	Mounting tube 1.1 (L = 680 mm; 26.77 inches)
5		1	351563	Mounting tube 0.85 (L = 430 mm; 16.93 inches)
6		1	351537	Tube end component (order with pos. 36 together)
9	◆	1	390955	Hose coupling \varnothing 10-12 mm; 0.393-0.472 inches
10	◆	1	390954	Coupling piece
11		1	351545	Grounding piece
12		1	351553	Contact pin
13		1	390204	C4 nozzle body (complete)
14	◆	1	390915	Electrode holder
15		1	351320	Cable reinforcement
16	◆	1	259900	PEA/PEM cascade
17		1	259331	Sealing washer
18		1	9998619	Disk stopper
20		2	9906036	M6x55 fillister head cap screw
21		2	351551	Setscrew **
22		1	9974056	O-ring
23		1	351330	Connecting tube
24		2	260310	Hose nipple **
25		1	351277	PEA-C2XL plug unit
26		1	351676	PEA-C2XL 1.8 cable (complete)
26		1	351278	PEA-C2XL 1.4 cable (complete)
26		1	351285	PEA-C2XL 1.1 cable (complete)
26		1	351293	PEA-C2XL 0.85 cable (complete)

- ◆ Wearing part
- Not part of the standard equipment but available as a special accessory.
- ★ only available as a set

** Secure the setscrews 21 and hose nipples 24 against loosening with Loctite 270.

PEA-C4XL HiCoat automatic spray gun

Item	K	Quantity	Order No.	Designation
27		1	351678	Support tube 1.8 (L = 1429 mm; 56.26 inches)
27		1	351547	Support tube 1.4 (L = 1029 mm; 40.51 inches)
27		1	351556	Support tube 1.1 (L = 729 mm; 28.70 inches)
27		1	351564	Support tube 0.85 (L = 479 mm; 16.89 inches)
28	◆	1	390910	PEA-C4XL powder tube
29		1	351550	Tube connection
30	◆	1	351679	Rear powder tube 1.8 (L = 1526 mm; 60.08 inches)
30	◆	1	351549	Rear powder tube 1.4 (L = 1126 mm; 44.33 inches)
30	◆	1	351557	Rear powder tube 1.1 (L = 826 mm; 32.52 inches)
30	◆	1	351565	Rear powder tube 0.85 (L = 576 mm; 22.68 inches)
31		1	9974113	O-ring 15x1.5
32		3	9971364	O-ring 13x1.5
33		2	9974114	O-ring 39x2
34		1	9982061	Hose, blue 1.8 Ø 5x1 (L = 1450 mm; 57.09 inches)
34		1	9982061	Hose, blue 1.4 Ø 5x1 (L = 1050 mm; 41.34 inches)
34		1	9982061	Hose, blue 1.1 Ø 5x1 (L = 750 mm; 29.53 inches)
34		1	9982061	Hose, blue 0.85 Ø 5x1 (L = 500 mm; 19.69 inches)
36		1	9913043	Threaded insert
37		1	3114203	M5 straight plug connection
39		1	9974184	O-ring 22x3
40		3	9907143	M4x6 countersunk screw
41		1	9907151	Fillister head cap screw
48		1	351567	Transition tube
49		3	9907157	M3x5 countersunk screw
50		1	3057540	M3x5 grounding pin
51		1	351590	Front guide tube
55	◆	1	390324	F1 fan spray nozzle
57		1	362211	PEA-C3XL strand (complete)
58		1	390957	Mini Corona-Star
61	◆	1	390310	Protective wedge
			992528	Loctite 270

- ◆ Wearing part
- Not part of the standard equipment but available as a special accessory.
- ★ only available as a set