Tools Required:  
(2) 8mm wrenches  
(1) Rotary tool with stone bit (to round wire end prior to feeding)  

WGM-LW-1 Kit Contents:  
(1) 45° module  
(2) Intermediate fasteners  
(1) Intermediate pilot pin  

End Cap Kit (WGM-ECK-LW-50) Contents:  
(1) “A” style end cap with threaded insert  
(1) “B” style end cap with threaded insert  
(4) End cap fasteners  
(2) End cap pilot pins  

Assembly of 90°, 135° and 180° Guide Modules

Step 1: Connecting Modules  
Insert intermediate pin in one end of module until it firmly seats (Step 1-A). Connect the two modules using the intermediate pin and ears to align the modules together (Step 1-B). Use the intermediate fasteners to lock modules together. Continue connecting modules until you have created the proper bend radius.

Step 2: Connecting End Caps  
Insert one end cap pilot pin into the end of the joined module(s). This will guide the wire into the module wire track. Connect the appropriate end cap over the end cap pin. The pin will stick out approx. 1/4” (6.3mm). Insert and tighten the end cap fasteners to lock in place.

Repeat with the other end cap. This is the wire exit point where wire will be guided into the conduit. Connect the appropriate end cap over the pin and use end cap fasteners to lock in place.

Step 3: End Cap Fitting Options

Pass Through Compression Fitting (recommended): Thread the pass-through compression fitting (A-9) into the appropriate end cap, making sure to correctly follow the wire path designated with the end cap pin. Deburr and countersink the conduit out to the conduit edge. Push the conduit through the compression nut until the conduit bottoms out on the end cap pin. Tighten compression nut. Doing so will pull the conduit to the face of the end cap pin without crushing the conduit.

Quick Disconnect Option: Attach A-5HD quick disconnect into the appropriate end cap. The pilot pin fits in the interior of the disconnect. Optional U-005 orange insulator sleeve shown in photo not included.
ASSEMBLY & MAINTENANCE

FEEDING WIRE:
It is beneficial to round the wire end upon initial feeding. Use a stone bit with a rotary tool to deburr any sharp edges from the wire end. This will prevent unnecessary hang-ups when feeding the wire to the feeder.

MAINTENANCE:
Wire Guide Modules should be cleaned periodically. Weld wire can deposit industrial contaminants such as dirt and dust as well as drawing compounds from the wire package onto the Wire Guide Module track and rollers. Follow these steps to clean the Guide Module:

**Step 1:** Take note of the wire path through the module. The module should be re-installed in the position it was removed from. Using 8 mm wrenches:
- Remove end cap fasteners
- Remove the intermediate fasteners if applicable
- Remove the 4 body fasteners

**Step 2:** The Guide Module will now pull apart (see disassembled unit at right). Remove the rollers and clean the wire track and rollers with a dry rag. You may blast the interior with compressed air to remove any further dust and debris. Do not use solvents inside modules.

**Step 3:** Reassemble the module(s) making sure the intermediate and end cap pilot pins are correctly installed, as shown on page 1.

TROUBLESHOOTING

<table>
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<tr>
<th>PROBLEM</th>
<th>POTENTIAL CAUSES</th>
<th>SOLUTION</th>
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<tbody>
<tr>
<td>Wire is stuck at module</td>
<td>Intermediate or end cap pilot pin incorrectly installed</td>
<td>Remove end cap or joined module and check pin</td>
</tr>
<tr>
<td></td>
<td>Conduit not properly countersunk or deburred</td>
<td>Remove conduit and countersink conduit ends</td>
</tr>
<tr>
<td></td>
<td>Wire end not rounded</td>
<td>Round the wire end and try feeding again</td>
</tr>
<tr>
<td>Wire still pulls hard</td>
<td>The conduit may be crushed causing drag inside the end cap</td>
<td>Remove the conduit and check the end to be sure the conduit was not crushed upon installation</td>
</tr>
<tr>
<td></td>
<td>Conduit is not straight enough</td>
<td>Straighten the conduit by removing excess slack or supporting the conduit with a balancer</td>
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WARRANTY
ELCo Enterprises, Inc. guarantees each Guide Module free from defects for a period of 2 years from the date of purchase. This warranty excludes damage caused by industrial contaminants, arc shorts, improper installation or improper maintenance.