1. Trim the conduit to length by making a firm, straight cut. Be sure to leave some slack when running the conduit to your wire feeder.

2. Make a pencil mark on the conduit at the end of the connector. Pull the conduit out from the end of the connector approx. 3/16” to 1/4” (5 - 6 mm). Use the countersink tool to bore into the end of the conduit as shown. Firmly tighten the connector using two wrenches. Before use, ensure the conduit cannot be easily pulled out by hand. Attach to wire feeder.

3. Based on the type of wire, connect the end assembly as shown and firmly hand-tighten. Be sure to push the conduit all the way into the connector until it bottoms out.

4. For aluminum wire, attach the connector to your wire feeder and trim the blue liner so it is approx. 1/16” (1.5 mm) away from the drive rolls.

5. Use the countersink tool to bore into the end of the conduit as shown.

6. Make a pencil mark on the conduit at the end of the connector. Pull the conduit out from the end of the connector approx. 3/16” to 1/4” (5 - 6 mm).

TOOLS REQUIRED
- EC-DB Countersink
- EC-CUTTER Polymer Conduit Cutter

Available from ELCo Enterprises

CONNECTION FOR STEEL WIRE

CONNECTION FOR ALUMINUM WIRE

EC-DB
Polymer Conduit Cutter

EC-CUTTER

TOOL REQUIRED

(517) 782-8040 • Fax (517) 782-8039 • Jackson, MI 49201 USA

www.wire-wizard.com

Last Revised: 5/30/17
**COMPRESSION STYLE FITTINGS**  
Recommended for robotic applications

- **EC-3-R**  
  0.175 ID x 0.340 OD (4.4mm ID x 8.6mm OD)

- **EC-4-R**  
  0.300 ID x 0.460 OD (7.6mm ID x 11.7mm OD)

- **EC-5**  
  0.400 ID x 0.600 OD (10mm ID x 15mm OD)

- **EC-6**  
  0.550 ID x 0.750 OD (14mm ID x 19mm OD)

**THREAD-ON STYLE FITTINGS**  
Recommended for stationary applications

- **EC-3-R**  
  0.175 ID x 0.340 OD (4.4mm ID x 8.6mm OD)

- **EC-4-R**  
  0.300 ID x 0.460 OD (7.6mm ID x 11.7mm OD)

- **EC-5**  
  0.400 ID x 0.600 OD (10mm ID x 15mm OD)

- **EC-6**  
  0.550 ID x 0.750 OD (14mm ID x 19mm OD)

* Prior to attaching screw-on fittings, be sure to taper the conduit ends as shown in step 2 on page one.