WIRE WIZARD WELDING PRODUCTS

POLYMER CONDUIT CONNECTION ASSEMBLY

FOR COMPRESSION FITTINGS

TOOLS REQUIRED

Available for purchase at *wire-wizard.com*



Polymer Conduit Countersink Tool
EC-DB



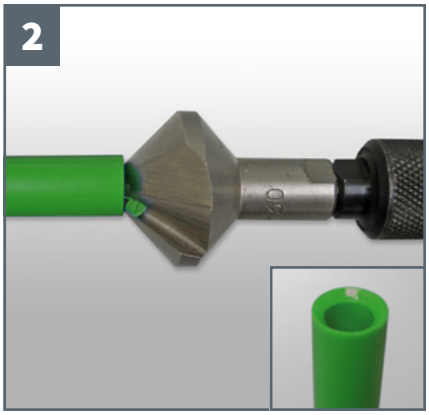
Polymer Conduit Cutter
EC-CUTTER

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



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

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.**

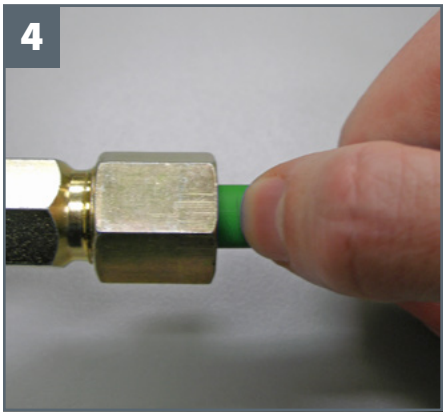


Connection for **Steel Wire**



Connection for **Aluminum Wire**

4



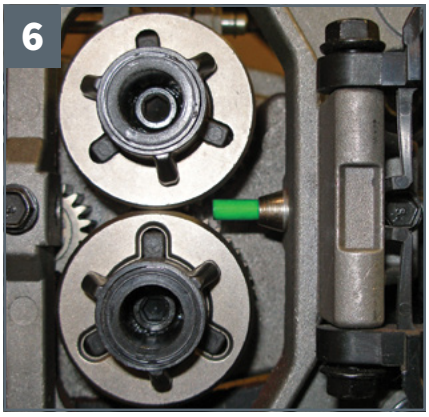
Make a pencil mark on the conduit at the end of the connector. Pull the conduit out from the end of the connector approximately 3/16" to 1/4" (5 – 6 mm).

5



Firmly tighten the connector using two wrenches. Before use, ensure the conduit cannot be easily pulled out by hand. Attach to wire feeder. ***See back page for torque settings.***

6

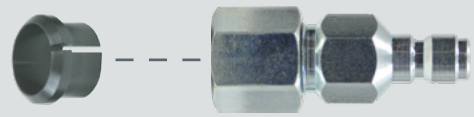


For aluminum wire, attach the connector to your wire feeder and trim the green liner so it is approx. 1/16" (1.5 mm) away from the drive rolls.

POLYMER CONDUIT FITTINGS & FERRULES

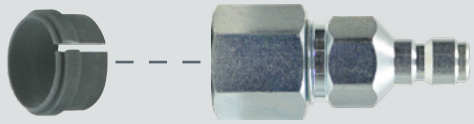
COMPRESSION STYLE FITTINGS Recommended for **robotic applications**

EC-4-R .300 ID x .460 OD (7.6mm ID x 11.7mm OD)



A-10CFE A-10C-H

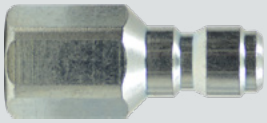
EC-5 .400 ID x .600 OD (10mm ID x 15mm OD)



A-10RFE A-10R

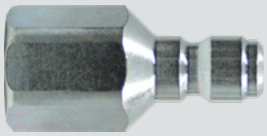
THREAD-ON STYLE FITTINGS* Recommended for **stationary applications**

EC-4-R .300 ID x .460 OD (7.6mm ID x 11.7mm OD)



A-16F-4

EC-5 .400 ID x .600 OD (10mm ID x 15mm OD)



A-16F-5

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

RECOMMENDED TORQUE SETTINGS

Connector Part No.	Ferrule I.D.	Torque Rating
A-10C-H 	0.475"	10 ft/lbs

Connector Part No.	Ferrule I.D.	Torque Rating
A-10R 	0.645"	25 ft/lbs