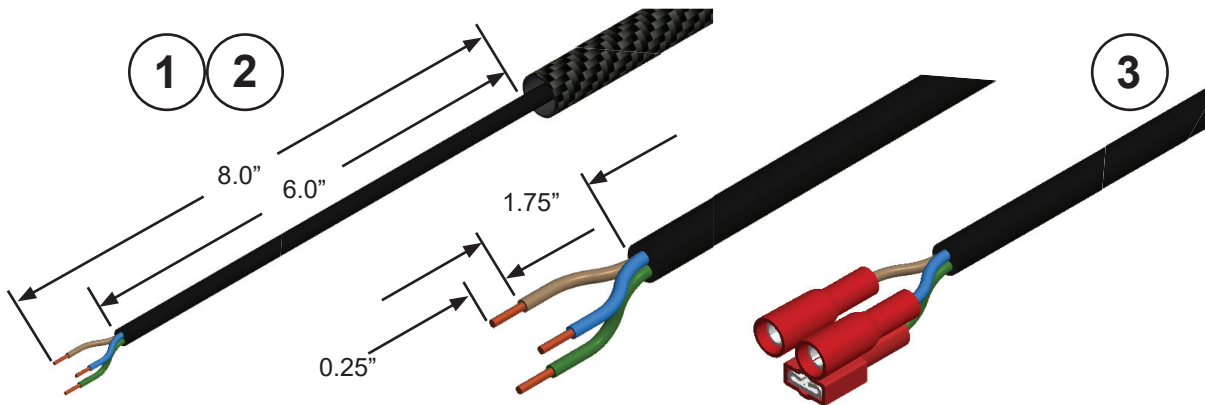


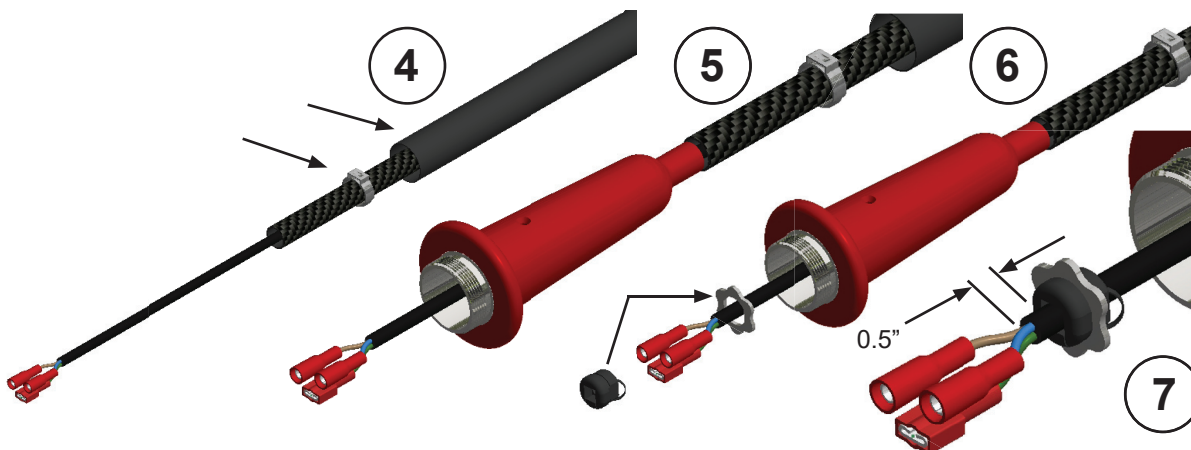
HANDLE AND SOCKET

6150H

INSTRUCTIONS FOR REPLACING THE HANDLE AND SOCKET



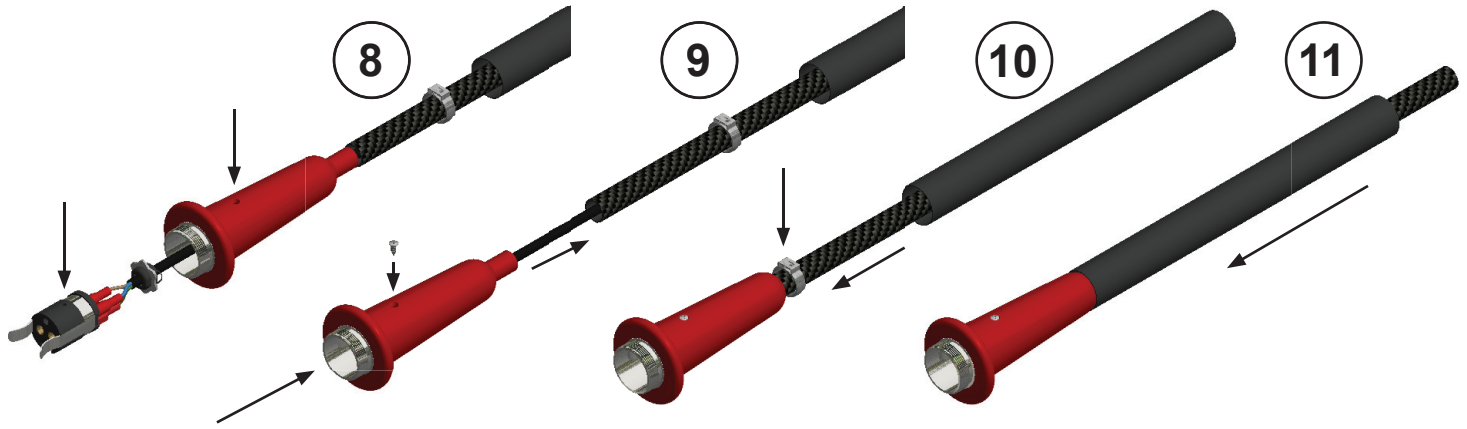
- 1: Cut away the old handle and any damaged hose, keeping the cut as close to the old handle as practical.
- 2: Cut and strip the wires according to the diagram above and cut or slide the blue or black hose back 6" from the end of the insulated black cord. (Read through to step five before cutting the outer hose.)
- 3: Crimp the connectors onto the wires with the female spade connector on the green/yellow wire.



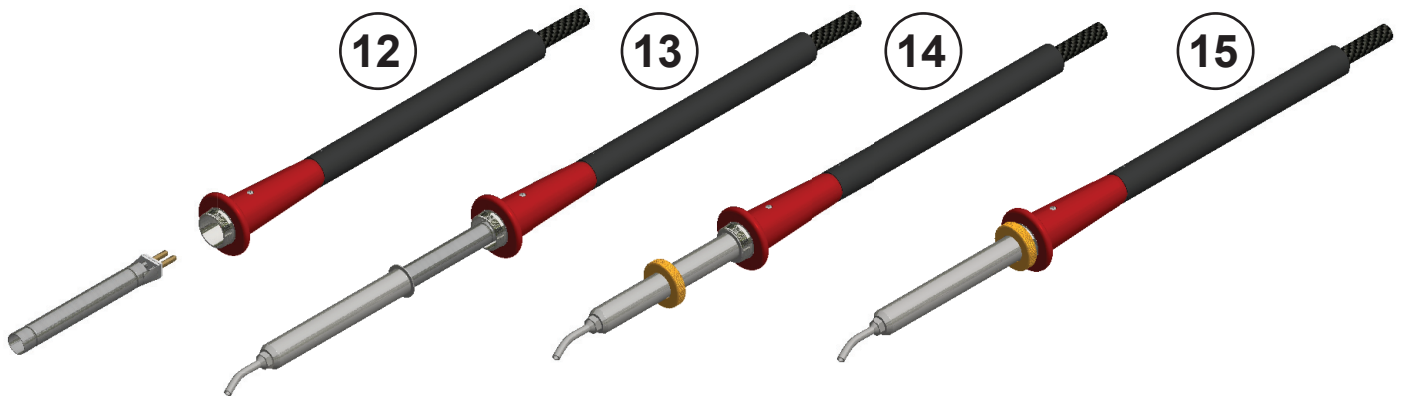
- 4: Place the heat shrink tubing onto the hose and cable, followed by the hose clamp.
- 5: Feed the cable with connectors into the small end of the handle until 2" of cable (minimum) is protruding from the large end of the handle. It may be necessary to loosen or remove the compression fitting on the plastic t-fitting at the opposite end of the wire assembly to get the slack you need. The fitting will be inside the control box or on the back of the welder. If the "T" is on the back of the welder, removal of the strain relief may also be required to get enough slack in the cable.
- 6: Place the flower-shaped metal jam washer over the connectors and onto the cord.
- 7: Insert the plastic strain-relief into the jam washer with 1/2" to 5/8" of black sheathing exposed on the free end. Forceful squeezing and wiggling is required to fit the strain relief. Be careful if you clamp the washer into a vice or locking pliers for stability, deforming it will make installation even more difficult or impossible. Properly installing the strain relief is a difficult but important step.

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- 8: Plug the bullet connectors onto the round pins on the socket. Plug the ground wire onto the flat tab. Note the placement of the hole in the socket in relation to the hole in the handle, both should face up.
- 9: Plug the heating element into the socket (step 12 illustration). Use it as a handle to guide the socket into the handle and align the screw holes of the socket with the handle. Pull the cord until the jam washer is seated snugly into the handle, then insert the retaining screw through the handle and into the socket. Be sure not to pinch the wires between the socket and the handle. The socket and handle holes will not line up correctly and the socket will be crooked inside the handle if that happens
- 10: Slide the hose over the end of the handle and crimp the clamp it in place. You will need to pull excess cable through the hose from the other end. To do this, loosen the compression fitting and pull the cable through the hose. Keeping the hose straight while doing this will make the job easier. If removed or loosened, be sure to reinstall and tighten the compression fitting and o-ring.
- 11: Slide the heat-shrink tubing up over the clamp and the end of the hose. Use a heat gun to shrink the tubing in place.



- 12: Install the heating element if not already installed.
- 13: Place the steel barrel over the heating element.
- 14: Secure the barrel with the large knurled brass nut to the handle. **Hand tighten only!**
- 15: Check to be sure air flows freely through the hose assembly.



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