1. Quick Disconnect Feeder End may be connected directly to a Bernard adaptor by threading quick disconnect directly into adaptor. Make all necessary power, control, and gas connections.

2. Quick Disconnect Feeder End, PN 4920 is supplied with two long guide tubes (PN 478 and 479) of different I.D.’s which must be cut to the proper length.

3. Select the proper guide tube I.D. from the table below.

<table>
<thead>
<tr>
<th>Electrode</th>
<th>Small I.D.</th>
<th>Large I.D.</th>
</tr>
</thead>
<tbody>
<tr>
<td>.023-.052</td>
<td>.062 -1/8</td>
<td></td>
</tr>
</tbody>
</table>

4. Install taper end toward feed rolls. If electrodes below .045 are being used, it may be advisable to grind a chisel point on the tapered end to guide electrode closer to the feed rolls.

5. Procedure to determine cut length for guide tube that extends beyond quick disconnect (Refer to Illustration 1):
   A. Mark tube at point even with end of quick disconnect body.
   B. Remove guide tube.

6. Procedure to determine cut length for guide tube recessed within quick disconnect (Refer to Illustration 2).
   A. With small rule, measure amount guide tube is within quick disconnect body. Shorten guide tube from end opposite taper.
   B. Using formula below, cut guide tube to proper length. Shorten guide tube from end opposite taper.
   C. 1-1/2” minus distance measured inside the quick disconnect body equals length to be shortened.

7. Insert the guide tube in the adaptor. Check guide tube length as indicated in Illustration 3 for proper fit and tighten set screw. E-Z Feed Adaptor Kits are supplied with pre-cut guide tubes for specific machines, as indicated below.