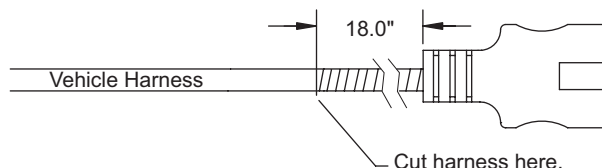
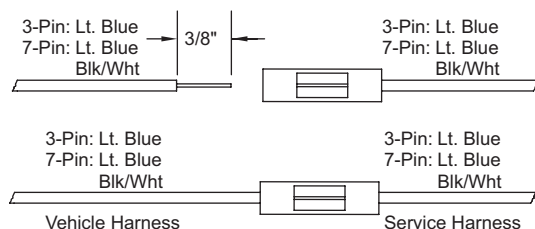


## Vehicle Service Harness Installation

1. Cut the vehicle harness 18" from the back of the plug. Discard the damaged plug.

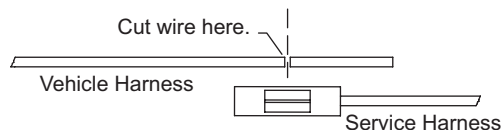


2. Carefully remove 9.5" of braid, exposing the vehicle harness wires.
3. Strip 3/8" insulation from the end of the specified wire. Insert the stripped end into the butt splice and crimp using the correct tool.



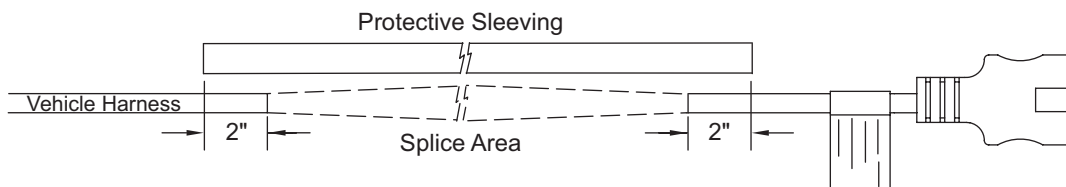
4. Stretch both harnesses so the wires lay side-by-side. Select a vehicle harness wire, locate the matching color on the service harness. Cut the

vehicle harness wire at the midpoint of the butt splice.



**NOTE: Wires cut too long or too short may create problems when securing the protective sleeving over the splices.**

5. Strip 3/8" of insulation from the end of the cut wire, insert the stripped end into the butt splice and crimp. Repeat for the remaining wires.
6. Using a heat gun or other heat source, heat each of the splices, starting from the center moving outward until the tubing shrinks and the adhesive has melted.
7. Cover the splice area with protective sleeving supplied. Open the sleeving, slip it onto the harness; tubing will close around wires. Sleeving should overlap the braid by approximately 2" on both ends.
8. Tape both ends of the sleeving to prevent it from moving. Tape other sections as necessary to prevent sleeving from opening during use. Secure the harness to the vehicle with cable ties as needed.



9. Lubricate the pins with dielectric grease.

The company reserves the right under its product improvement policy to change construction or design details and furnish equipment when so altered without reference to illustrations or specifications used.

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