**Standard Work Instruction: 635162 Assembly Rev: A**

**PPE Needed:**

Gloves

**Material Needed:**

941731- Receptacle Molex **Location: Work Table** Qty: 1

941729- Pin Male Molex **Location: Work Table** Qty: 2

941728- Cable shielded wire **Location: Work Station** Qty: 1 Length: 6 Inches

**Tools needed:**

Tape measure

Side cutters

Xcelite Wire Stripper

1005 Klein Crimping/Cutting Tool

Solder Pot

Kester Rosin Paste Flux

**NOTE:** Item numbers reference the DWG bill of material.

**Assembly Steps:**

**1.)** Measure and cut 6 inches of (941728 Item: 30) Cable shielded wire.

**2.)** Remove and keep the red and white conductor wires from the outer jacket. Discard everything else.

**3.)** Measure and strip .25 inches from each end of both conductors wires.

**4.)** Use 1005 Klein Crimping/Cutting Tool to crimp (941729 Item: 20) Pin Male Molex onto one end each conductor wire.

**5.)** Insert the crimped contacts into (941731 Item: 10) Molex Receptacle according to DWG: 635162.

**6.)** On the opposite end, add Kester rosin paste flux to each stripped wire end prior to tinning.

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**Change log: Added location to all items in the Material Needed list.**