**Standard Work Instruction: 795309 Assembly Rev: C**

**PPE Needed:**

Gloves

**Material Needed:**

941728- Cable Shielded Wire **Location: Work Station** Qty: 1 Length: 36.5 inches

941725- VHR-3N Conn Housing **Location: Work Table** Qty: 1

941726- SVH-21T-P1.1 Conn Term Crimp **Location: Work Table** Qty: 3

941730- Plug Molex 3 Pin **Location: Work Table** Qty: 1

941732- Pin Female Molex **Location: Work Table** Qty: 3

941736- Heat Shrink **Location: Work Table** Qty: 2 Length: 1 inch

**Tools needed:**

Molex contact crimper

Heat gun

Wire stripper (Xcelite)

Side cutters

Ruler

Permanent/Paint marker

Tape measure

Wire cutter

Katapult Wire Stripper (Klein Tools)

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

**Assembly Steps:**

**1.)** Measure and cut 36.5 inches of (941728 Item: 10) cable shielded wire.

**2.)** Measure and strip 1.25 inches of outer jacket from each end of the wire. Use side cutters to remove the foil and fillers from both ends.

**3.)** On one end, measure and strip .25 inches of insulation from the three conductors wires. Use the contact crimper to crimp (941732 Item: 50) Pin Female Molex to each conductor wire.

**4.)** Install (941730 Item: 40) Plug Molex 3 Pin connector onto the crimped contacts according to DWG NO. 795309. Firmly pull each to ensure they are seated.

**5.)** Put both pieces of (941736 Item: 60) heat shrink onto the cable. Do not apply heat.

**6.)** Measure and strip .25 inches of insulation from three conductors on the opposite end. Use the contact crimper to crimp (941726 Item: 30) SVH-21T-P1.1 Conn Term Crimp to each conductor wire.

**7.)** Install (941725 Item: 20) VHR-3N Conn Housing on the crimped contacts according to DWG NO. 795309. Firmly pull each to ensure they are seated.

**8.)** Move the heat shrink to cover the cable jacket strip and the conductor wires. Heat until adhesive is slightly protruding from the edges of the heat shrink.

**Prepared by**

Name: Justin Liles

Date: 2018-MAY-10

**Reviewed by**

Name:

Date:

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Date:

**Revision Record**

Rev: -

Date First Issued: 2018-MAY-10

Rev: A

Date of revision: 2018-MAY-10

Change log: Added item numbers to all listed part numbers to help when referencing the drawing.

Added note to the title page.

Rev: B

Date of Revision: 2018-JUL-02

Change log: Modified length of Item 10 Cable Shielded Wire in Step 1 from 32.5 inches to 36.5 inches.

**Rev: C**

**Date of Revision: 2018-AUG-08**

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