**Standard Work Instruction: 805066 Assembly Rev: A**

**PPE Needed:**

None

**Material Needed:**

941728- Cable Shielded Wire **Location: Work Station** Qty: 1 Length: 60.5 inches

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

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

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

**Tools needed:**

Molex contact crimper

Heat gun

Wire stripper (Cyclops)

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 60.5 inches of (941728 Item: 30) 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 (941726 Item: 20) SVH-21T-P1.1 Conn Term Crimp to each conductor wire.

**4.)** Install (941725 Item: 10) VHR-3N Conn Housing onto the crimped contacts according to DWG NO. 805066. Firmly pull each to ensure they are seated.

**5.)** Measure and strip .25 inches of insulation from three conductors on the opposite end.

**6.)** Put both pieces of (941736 Item: 40) heat shrink onto the cable. Move the heat shrink to cover the cable jacket strip and the conductor wires. Apply heat until adhesive is slightly protruding from the edges of the heat shrink.

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