



Installation Manual

General Instructions for Plug Assembly

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Revision: -

This manual is subject to change without prior notice.



1 PREPARING THE CABLE ENDS

- a) Proper preparation of the cable end will ensure easy assembly. To prepare the cable end, follow these steps:
- b) Confirm that the cable terminates in a plug. Refer to the cabling diagram or the component to be installed.

NOTE: Shielding is not required on all cables however, the following instructions include its use. If the particular cable being fitted to a plug does not have shielding, omit any reference to it.

- c) Strip off 2" (51 mm) of cable insulation as shown in the Figure 1. Take care not to cut the shielding.
- d) Isolate the shielding from the leads by twisting it separately.
- e) Strip 1/8" (3mm) of insulation off the individual leads.

NOTE: If the lead insulation diameter is larger than 1/8" (3mm), it may be difficult to insert the insulation into the plug. If this is the case, strip off 3/8" (9mm) of insulation.

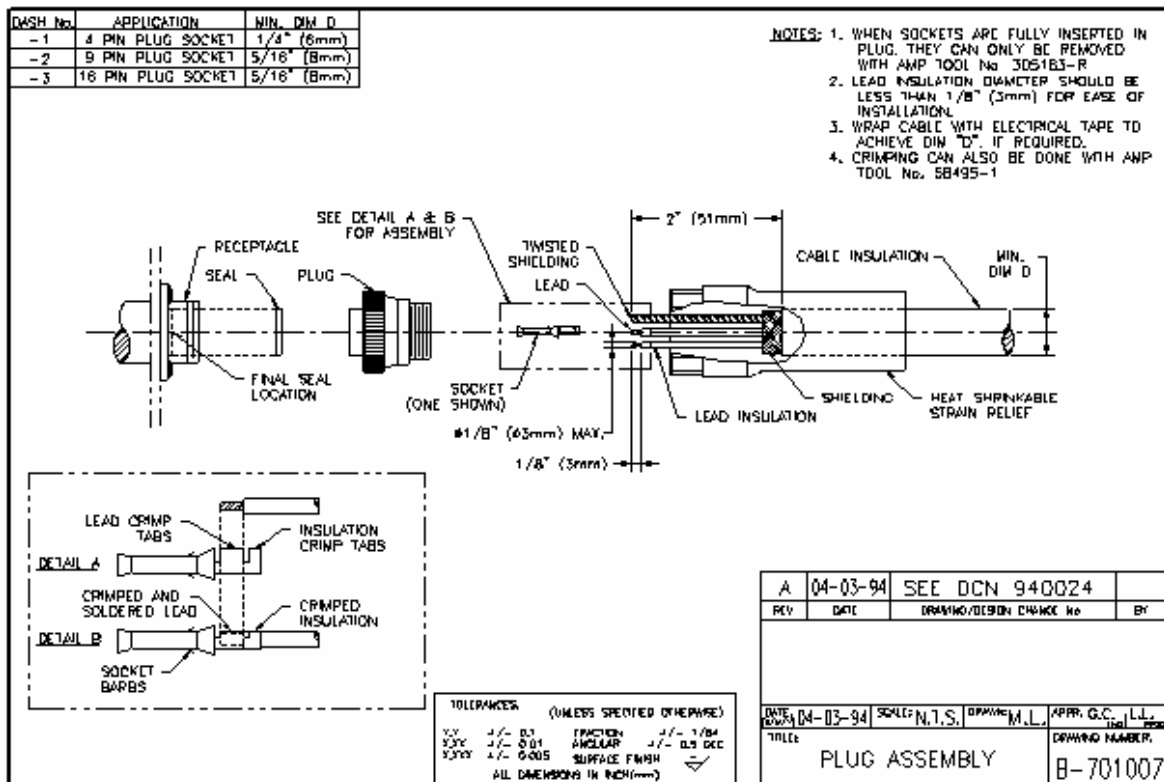


Figure 1 – Plug Assembly



2 ATTACHING THE SOCKETS

To attach the sockets, follow these steps:

- a) Place the lead into the socket as shown in Figure 1, Detail A.
- b) With a crimping tool, crimp the insulation and lead tabs around the insulation and lead respectively as in Detail B.
- c) Solder the crimped lead with a very small amount of solder on the crimped lead only. Excessive soldering may make insertion of the socket into the plug difficult.
- d) For the twisted shielding, crimp and solder both tabs to the shielding.

3 ASSEMBLY

WARNING: ALL CABLE WIRES MUST BE SECURELY CONNECTED. A LOOSE WIRE OR SHORT CIRCUIT CAN CAUSE SUDDEN LOSS OF STEERING.

- a) Please refer to Figure 2 for parts breakdown and kit sizes.
- b) Slide the heat shrinkable strain relief over the cable as shown.
- c) Refer to the wiring diagram and determine which plug socket port numbers are used and to which socket (i.e. lead) they correspond.
- d) Partially insert the sockets in their respective plug socket ports.

IMPORTANT: The plug socket numbers are embossed on the plug. Once sockets are fully inserted in the plug, they can only be removed with a special tool available from Wagner.

- e) Re-check the wiring diagram to ensure the correct socket locations. Also ensure that the heat shrink strain relief is oriented correctly as shown in Figure 1.
- f) If sockets are correctly located, insert them fully into the plug until the socket barbs grab.
- g) Ensure that the shielding is installed in a manner that will not cause electrical shorts to occur. If the twisted shielding requires insulating it may be wrapped with electrical tape.



- h) Confirm that the cable insulation diameter is larger than the diameter indicated in the table of Figure 1. If the cable diameter is less than the dimension shown, the cable end may be wrapped with electrical tape. This will ensure that the strain relief adequately supports the cable once heat shrinking is done.
- i) Slide the strain relief along the cable and thread it to the plug.

CAUTION: Do not install the O-ring or heat-shrink the strain relief onto the cable until after the system is tested.

- j) Insert the plug into the receptacle. Confirm that the heat shrinkable strain relief is tightly threaded to the plug.

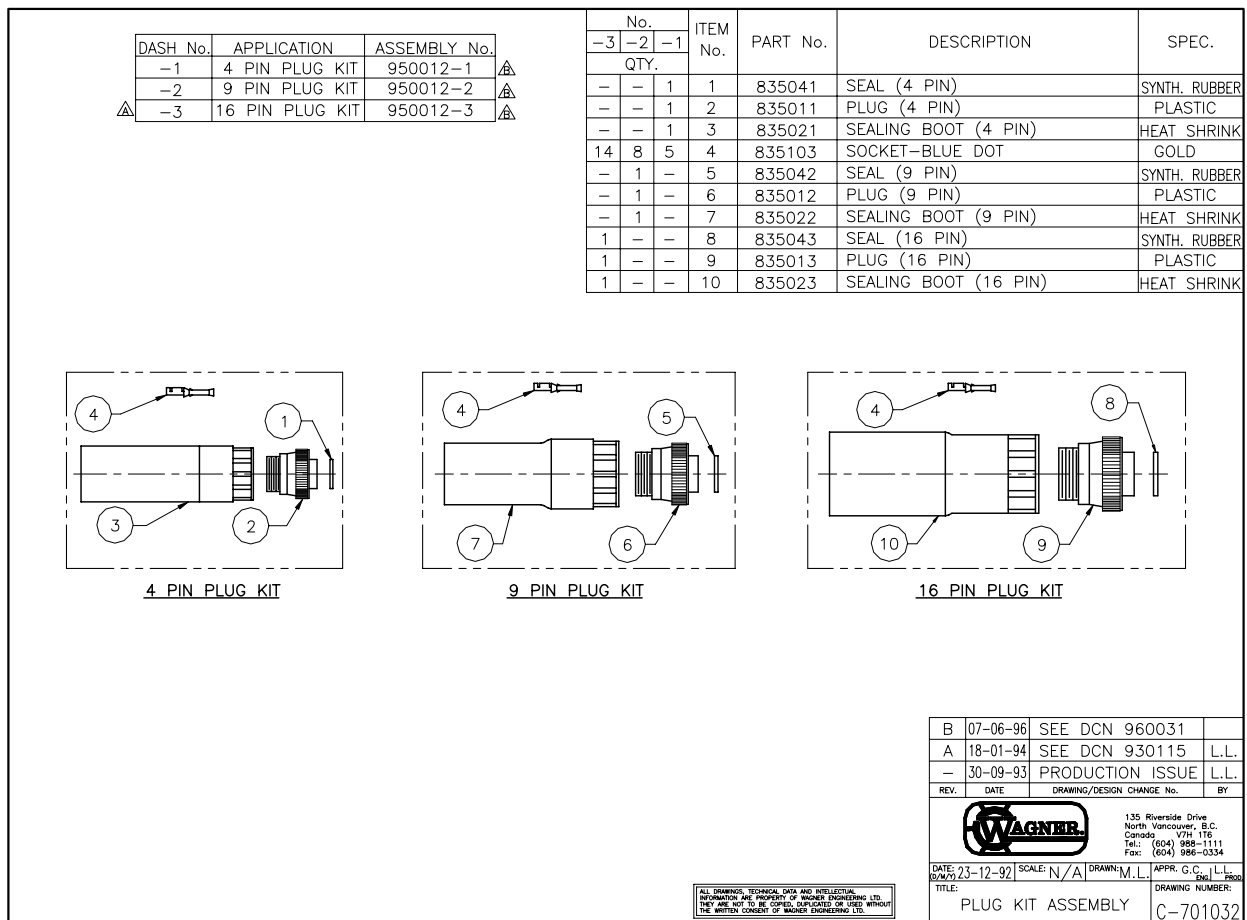


Figure 2 – Plug Kit Assembly