

Assembly instruction shrink sleeve:

1. Tools:

- Portable heat gun
- Side cutter
- Insulation stripping knife
- Cable stripper
- Scissors
- Crimping tool for insulated butt connectors



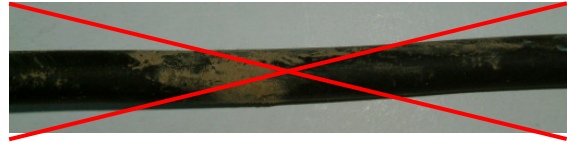
2. Material: Shrink hose with adhesive



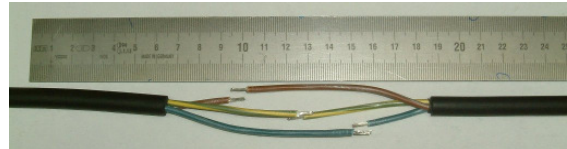
3. Material: Butt connectors incl. insulation and adhesive



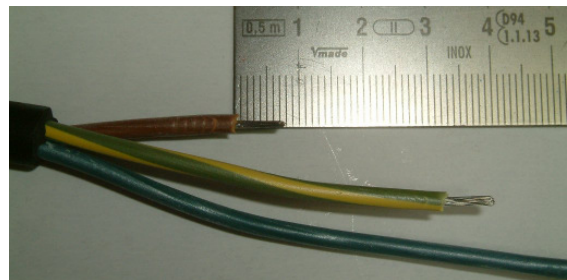
4. Only clean and dry circuit/cable



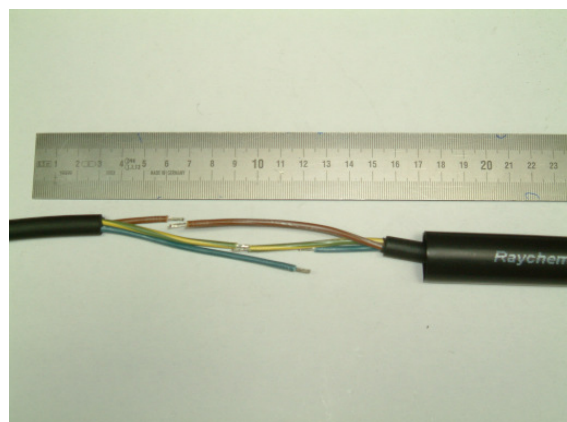
5. Dismantle new (arranged in an offset pattern)



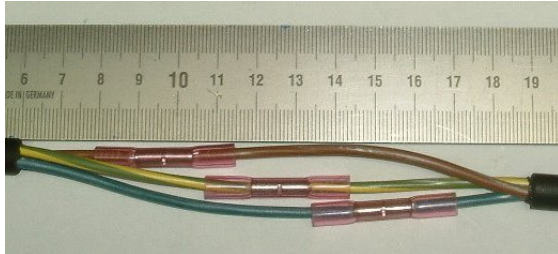
6. Dismantle leads (7 mm)



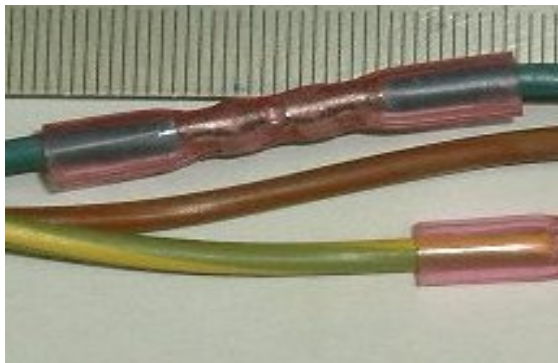
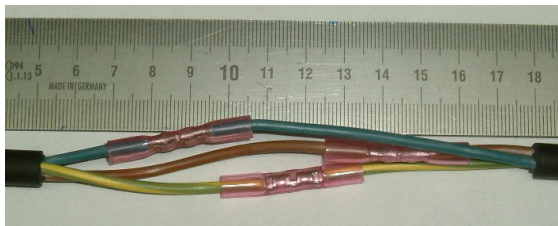
5. Crop the shrink hose with scissors in suitable length. After shrinking the hose has to be 5 cm over the outer cover of the cable on the right and on the left side. Drag the cropped shrink hose onto the cleaned cable.



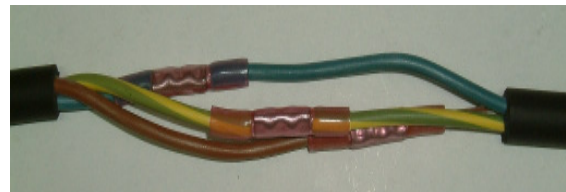
6. Plug the insulated cables in the butt connectors. Please pay attention that both cables in one butt connector match coloured to each other and the both cables have respectively the same identification.



7. Crimp the butt connectors **only** with a crimping tool. Choose the correct jaws according to the colour of the cables, in this case red. Please check the result after crimping by pulling the cables easily. The crimping process is done correctly when the cables can't be pulled out of the butt connectors and when the insulation of the butt connectors isn't damaged.



8. After the crimping of all butt connectors shrink the insulation of the butt connector with a heating gun. The shrinking temperature is between 100 and 120 °C. Please take care that nothing is damaged through the heating gun, for example the insulation of the leads or the outer cover of the cables. Always start in the middle of the butt connector and work slowly from the middle to the ends. By rotating the heating gun or the object that is to be shrunk every sides should be heated equally. By heating the shrink insulation of the butt connector tightens and covers up the insulation of the lead. The inner side of the shrink insulation of the butt connector is moistened with a hot-melt adhesive which can ooze out at the sides after the shrinking. The adhesive is responsible for the watertightness of the butt connector after the successful shrinking.



9. Pull the black cutted shrink hose centred over the leads and the butt connectors. Please take care that the shrink hose is 5 cm over the outer cover of the cable on the right and on the left side.



Here you also start the shrinking process in the middle of the shrink hose and work slowly from the middle to the ends. By rotating the heating gun or the object that is to be shrunk every sides should be heated equally. Please take care that the shrink hose doesn't shift during the shrinking process. The inner side of the shrink hose moistened with a hot-melt adhesive which can ooze out at the sides after the shrinking. This is volitional. The adhesive is responsible for the watertightness of the butt connector after the succussful shrinking.



Generally, there mustn't be dirt or water in the shrink sleeve!