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PLEASE READ THE FOLLOWING INSTRUCTIONS BEFORE INSTALLATION.

WIRING REPAIR KIT KIT CONTENTS	
Description	Quantity
Connector with Leads	1
Butt Splices (with 14 AWG and Larger Diameter Wire)	As Required
Dual Wall Heat Shrink	As Required

SERVICE PROCEDURE:

NOTE: Refer to applicable model year wiring diagram for circuit information. For twisted wire circuit repair, the twisting must not be disturbed for more than 2 inches. Twist the repaired wires in the same direction and with the same general twist rate as the original wiring. Re-apply the shielding on shielded circuits.

1. Disconnect battery ground.
2. Disconnect connector from affected component. Remove tape and convolute.
3. Cut first circuit approximately 3 inches from connector. Leave enough wire to allow repairs to be staggered to minimize harness diameter and to maintain harness length. Excess wire from the harness can be folded back on itself to maintain harness length.

For kits with 16 AWG and smaller diameter wire (solder/heat shrink repair):

1. Strip insulation 1-1/2" from one wire being spliced (Wire #1) and 3/4" from the other.
2. Slide heat shrink tubing **at least 1"** away from one of the stripped ends being spliced.
3. Twist wires together. Solder wires together using rosin core mildly-activated (RMA) solder.
4. Bend Wire #1 back in straight line after solder has cooled. Inspect solder joint bond.
5. Evenly position heat shrink tube over wire repair.
6. Use a shielded heat gun to heat the entire length of heat shrink tubing until hot melt appears from both ends.

For kits with 14 AWG and larger diameter wire (crimp/heat shrink repair):

1. Once wire lengths are sized so repairs can be staggered, strip insulation 1/4" from wire on pigtail.

Depending on the gage of the butt splice and wire harness, the strip length will vary per the following:

GAGE SIZE		
Butt Splice as Stamped 16-14	10	1/4" strip, cut 7 strands - kit only
Marked 16-14	12	1/4" strip, kit and harness
	14	1/4" strip, kit and harness
	16	1/4" strip, kit and harness
	18	5/8" strip, fold 2x diameter - harness
	20	1" strip, fold 3x diameter - harness
	22	1-1/4" strip, fold 4x diameter - harness
Butt Splice as Stamped 12-10	10	1/4" strip, kit and harness
	12	1/4" strip, kit and harness
	14	5/8" strip, fold 2x diameter - harness
	16	1" strip, fold 3x diameter - harness
	18	1-1/4" strip, fold 4x diameter - harness

2. Slide heat shrink tubing **at least 1"** away from one of the stripped ends being spliced.
3. Identify the appropriate crimping size of the crimper by matching the wire size on the tool with the wire size stamped on the butt splice.
4. Center one end of the butt splice in the appropriate crimping tool.
5. Engage the crimper but don't deform the butt splice.
6. Insert stripped wire into the splice until wire hits stop. Make sure insulation does not enter splice.
7. Holding wire in place, firmly squeeze tool handles together.
8. Reposition the uncrimped splice in the same crimping size and repeat steps 3 to 6.
9. Inspect repair for acceptable crimp.
10. Evenly position heat shrink tubing over wire repair.
11. Use a shielded heat gun to heat the entire length of a heat shrink tubing until hot melt appears from both ends.

NOTE:

- Repeat process as needed to repair remaining circuits. Stagger repairs to harness doesn't become too large.
- Seal the ends of all pigtail leads not being used with dual wall heat shrink and stow. **Silicone must not be used.**
- Re-apply convolute and tape. Reconnect battery ground when repairs are complete.

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