



**Items needed:**

**1) A Splice Kit**

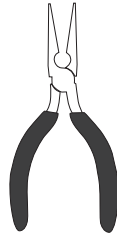


1 - 20 - 18 AWG  
Sealed Crimp +  
Solder connectors  
FASTENAL  
P/N: 0710573

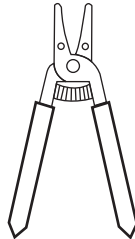


1 - .40 x 6" Heavy Wall, Adhesive-Lined  
Heat Shrink Tube  
FASTENAL P/N: 58654

**2) Tools**



Needle Nose Plier



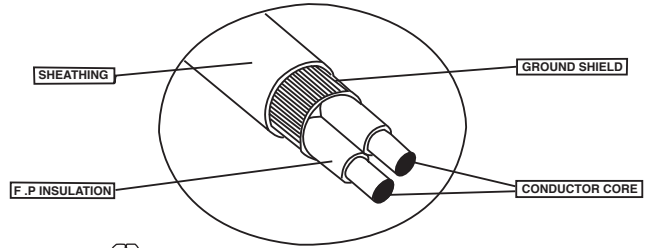
Wire strippers



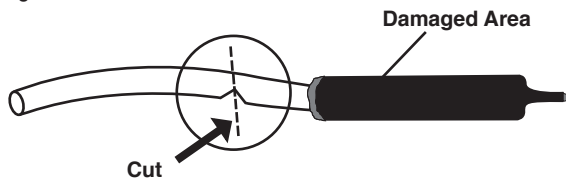
Crimping tool



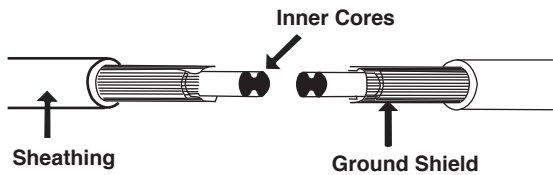
Hot air pistol



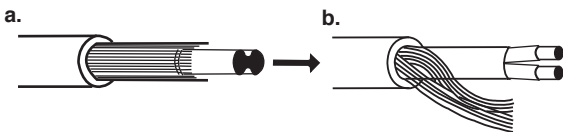
**Step 1** - Determine where the damage is and make a clean cut through the wire.



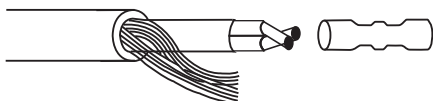
**Step 2** - Using wire strippers, strip 1" of the outer insulation of the cable.



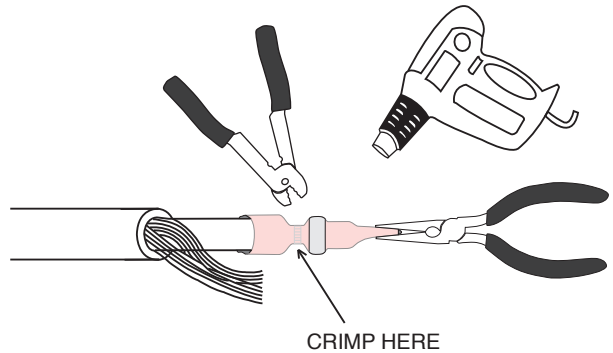
**Step 3** - Separate the braided sheath wire from the inner layer of insulation. Remove 1/4" of insulation from each inner conductor.



**Step 4** - Twist the inner conductor wires together and then insert them into the crimp-on connector.



**Step 5** - Compress the crimp-on connector on each side using crimp tool. Using a hot air pistol, carefully heat crimp connectors to seal crimp and melt solder. When connector warms, crimp end with pliers, as shown, to seal end.



**Step 6** - Place the ground braid along the crimp and slide the heat shrink tube over the completed joint and shrink it with a hot air pistol. Do not use a naked flame. When tubing warms, use pliers to crimp end closed, as shown. Verify sealant flow at both ends of the tube. There should be clear glue at each end of the tube. This will ensure a waterproof seal.

