

**Assembly instructions manual AN2551 polycarbonate P/N AN2551**Content of packaging :

- 2 Covers (L + R polycarbonate).
- 2 Main terminals silver plated.
- 1 Silver plated interlock contact
- 6 Stainless steel screws.
- 1 Short interlock wire.

Instructions :

1. Strip 13 mm ($\frac{1}{2}$ inch) insulation from the top-end of each main wire.
2. Strip 13 mm ($\frac{1}{2}$ inch) insulation from the both-ends of the interlock wire.
3. Use a screw bench to hold the terminals, do not put any pressure on the slotted pins
4. Heat top-end of terminals with torch with a pointed flame.
5. Fill the top opening about $\frac{3}{4}$ full with tin solder.
6. Aircraftplugs solder is available and recommended.
7. Caution : Do not overheat , the solder flux will flame and it can damage the contact.
8. Remove heat; slowly insert each wire.
9. Allow solder to flow into the wires for secure electrical contact.
10. Connect the interlock wire with the positive main contact and interlock contact.
11. Solder positive wire and jumper into the positive main contact terminal.
12. Cool down all terminals.
13. Place all terminals and wires into the housing.
14. Screw the assembly together using the 6 stainless steel screws.(ISO Torque 1.8 Ft/Lbs)
15. Check the polarity.

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