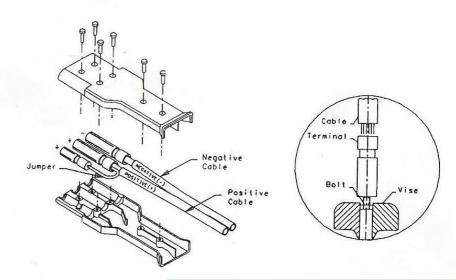
ASSEMBLY PROCEDURE VERSION 1.3

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AIRCRAFTPLUGS® AN 2551





Aircraftplugs® AN2551 Technical instructions

- 1. Strip 13 mm $\frac{1}{2}$ inch insulation from the end of each cable.
- 2. Support terminal as shown in inset of vise with cable end up.
- 3. Heat top of terminal with torch with a pointed flame; fill the opening about 34 full with rosin core solder. Aircraftplugs solder is available and recommended. Caution: flux will flame if overheated.
- 4. Remove heat; slowly insert end of negative cable allowing solder to flow into cable.
- 5. Solder jumper into small terminal as above.
- 6. Solder positive cable and jumper into the remaining terminal.
- 7. Assemble plug as shown. BE SURE POLARITY IS CORRECT.

www.aircraftplugs.com

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