

## Splicing Instructions: RD-02.CONN

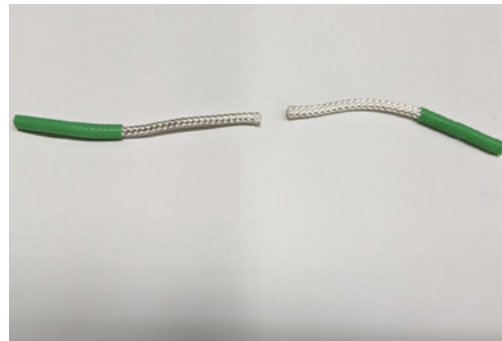
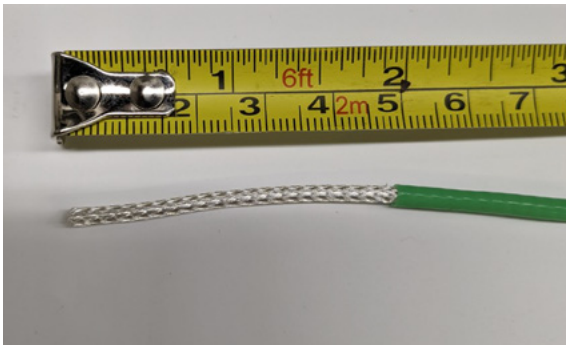
This demonstration was completed on a workbench with the shielded wire supplied in the kit (RD-02.CONN). Please note the OEM wire shield is woven differently but a similar technique can be used to make the repair. There are alternative methods to make this work, however this is a simple and reliable method to repair a damaged O2 connector. Ideally the harness should be replaced.

**Important: Slide Heat Shrink onto wire prior to splicing, otherwise the heat shrink cannot be applied.**

**Important: Crimp quality is critical to ensuring a good signal is transmitted**

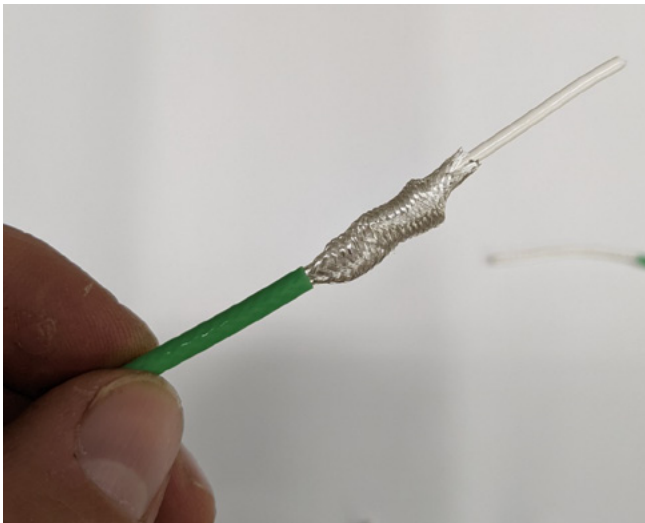
### **Step #1: Removing Shielding Insulator**

Cut back 50mm of the shield insulator on both wires very **gently** (to avoid cutting deeper than the insulator) by cutting around the circumference with a blade. Note: unless you have the correct wire strippers, there is a chance you will cut through the shielding wire.



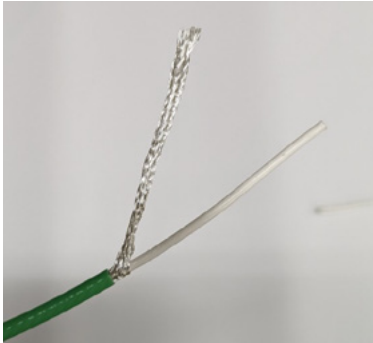
### **Step #2: Splitting Wires**

In this step you will have to remove the primary conductor from its woven shield. In order to do this, loosen the shielding and slide it back which will result in bunching. Now that you have the shield bunched, gently create a opening/passage with a pencil. Then bend the wires at the opening and extract the primary conductor through the opening without compromising the insulator (avoid the use of a screwdriver).



**Step #3: Cutting Primary Conductor**

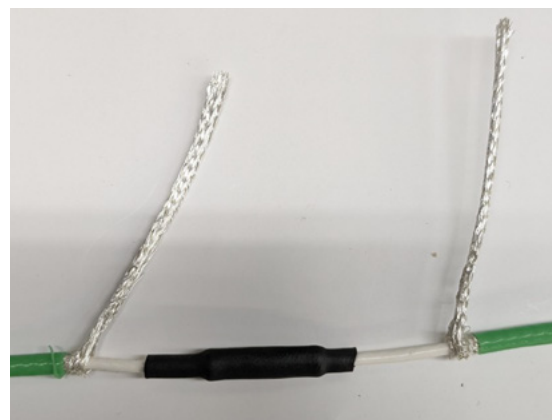
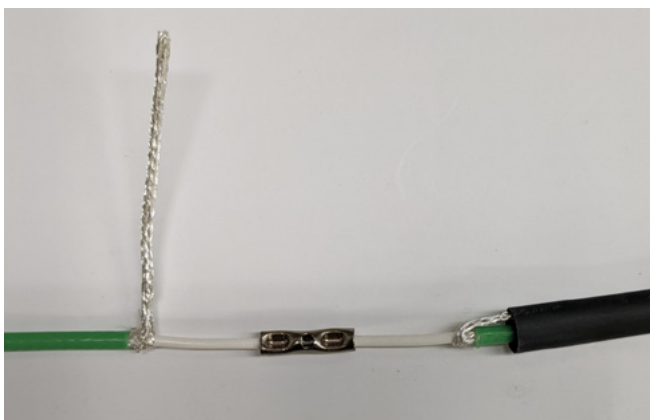
Cut 25mm off of the primary conductor and strip 8mm of shielding,

**Step #4: Splicing Primary Conductor**

Splice the two primary conductors using the butt splice, ensuring the 'brush'/wire is visible through the inspection window. Use good crimpers! And conduct an informal 'pull test' to check that the crimp is sufficiently strong.

**Step #5: Heat Shrinking Primary Conductor**

Use the supplied heat shrink to insulate the primary conductor splice. Slide the heat shrink by folding one side of the shielding.



**Step #6: Splicing Shielding Wire & Heat Shrink**

Splice the two shielding conductors using the butt splice, ensuring the 'brush'/wire is visible through the inspection window. Use good crimpers! And conduct an informal 'pull test' to check that the crimp is sufficiently strong. Slide on the second piece of heat shrink to insulate the splice.



**Important: Slide Heat Shrink onto wire prior to splicing, otherwise the heat shrink cannot be applied.**

**Important: Crimp quality is critical to ensuring a good signal is transmitted**