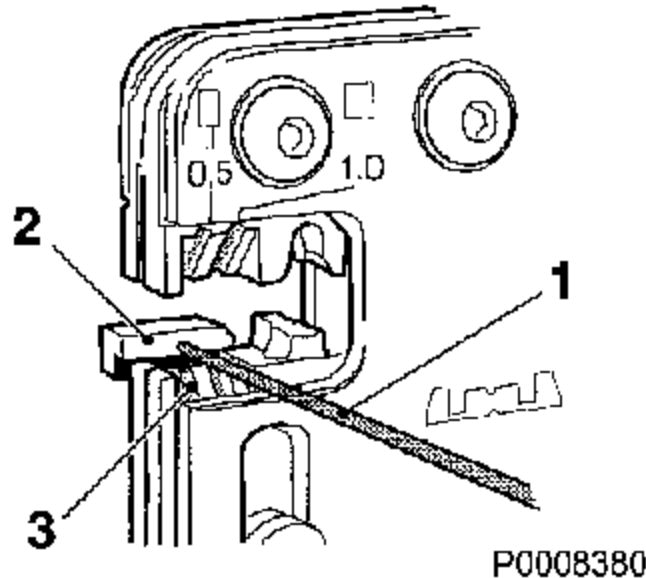


Step D - Damage type 1, Repair of damaged cables

D1.1 - Strip insulation from lead ends

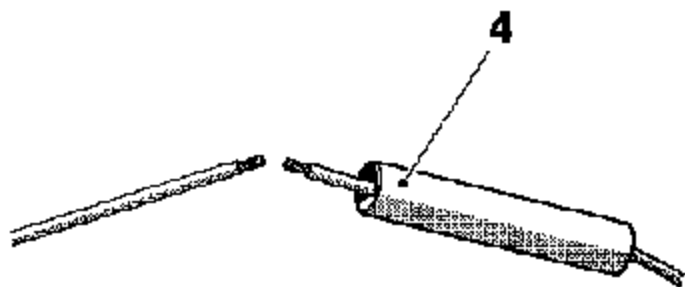
- Number cables according to plug diagram (see section 5), or identify according to cable colour, so that it will not be possible to confuse the cables when connecting them later.
- Sever defective cable at suitable location but vary the separation locations to essentially retain the same cross-section for the entire wiring harness.
- Determine cross-section of cable (see circuit diagram), select corresponding crimping tool.
- Insert lead end (1) into crimping tool to the stop (2). Check position of cable in wire stripping station of crimping tool (3). Do not hold cable at an angle to crimping tool, otherwise individual strands of the flex may be damaged. Strip insulation from cable.



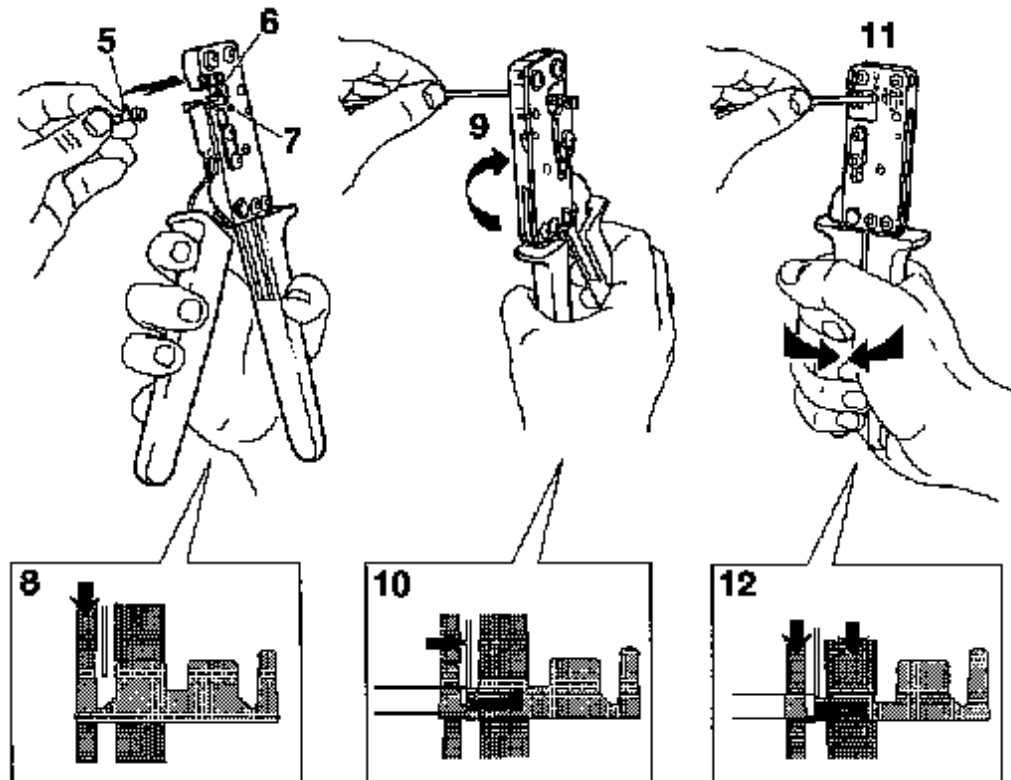
Note: Do not twist stripped lead ends.

D1.2 - Pull on shrink-down tube

- Select shrink-down plastic tube (4) according to cable cross-section and guide over lead end.



D1.3 - Crimp

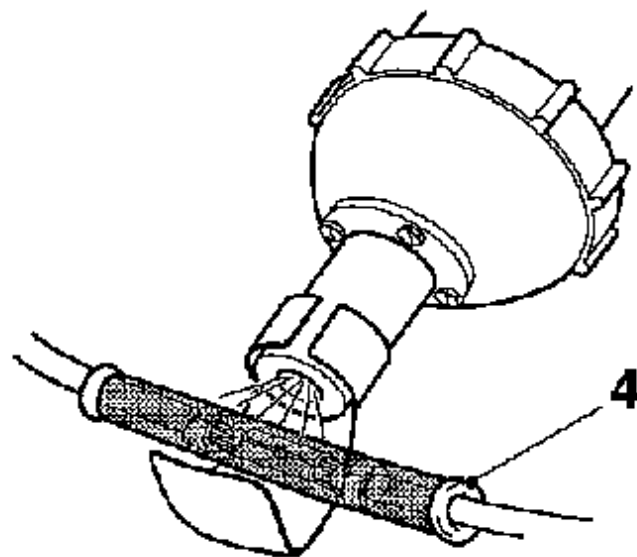
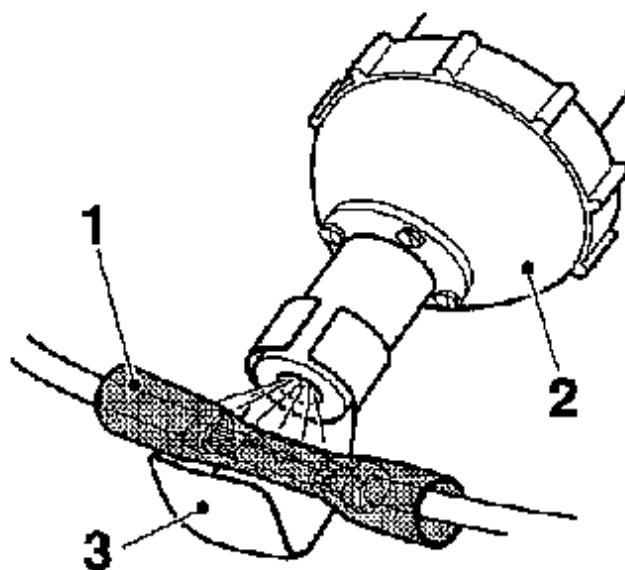


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- Select cable connector (5) according to cable cross-section, insert into crimping nest (6) from the side (7) of the crimping tool without lettering .
- Squeeze crimping tool until the cable connector is secured (8).
- Select cable with the same cross-section for repair, insert cable from the side (9) of the crimping tool with lettering to the stop (10).
- Squeeze crimping tool to the point of contact (11). The crimping tool can only be released once it has reached the point of contact (12).
- Crimp second lead end with the cable connector.

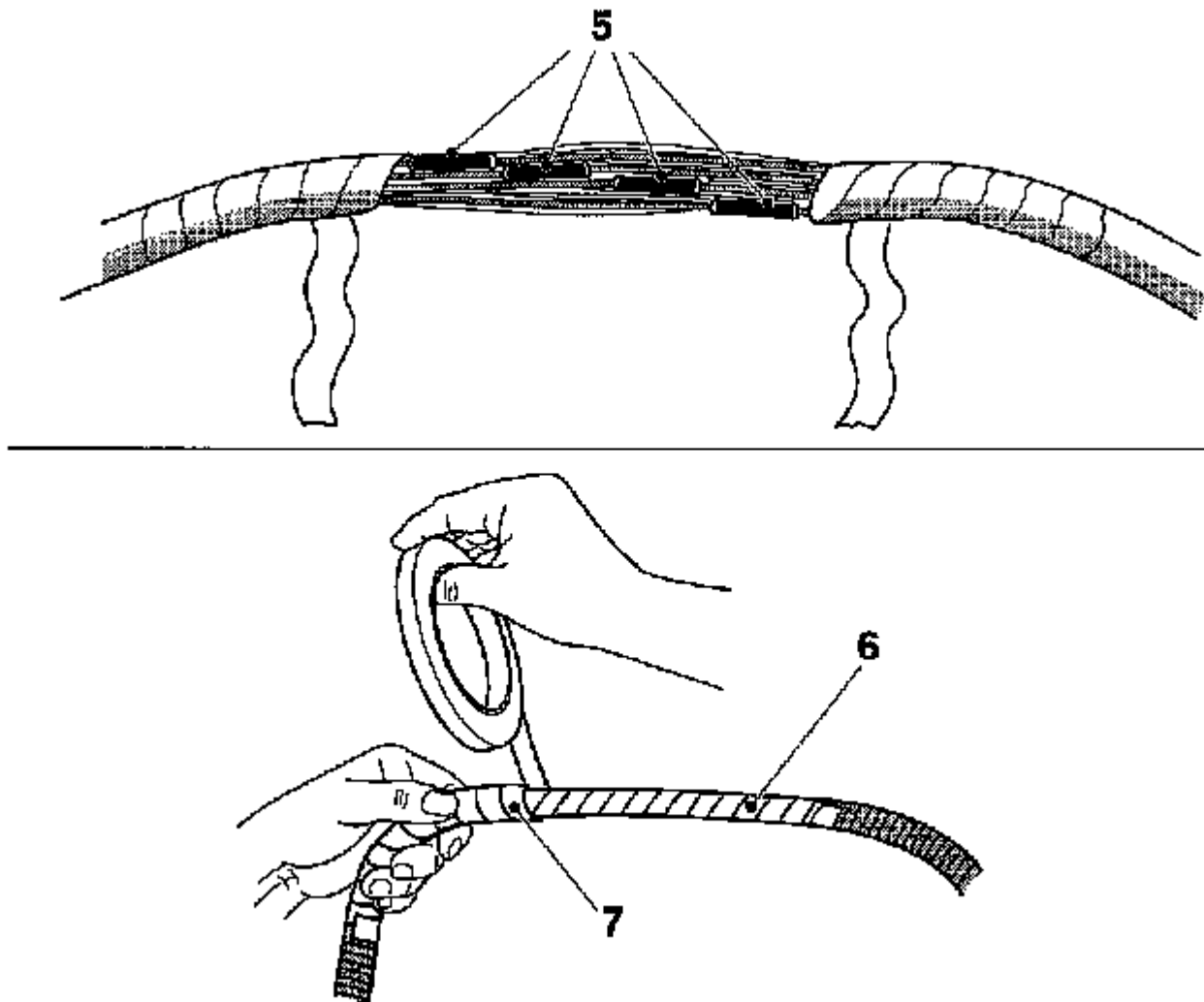
D1.4 - Shrink on shrink-down tube

- Guide shrink-down plastic tube (1) centrally over cable connector.
- Shrink shrink-down tube with hot air blower (2) and reflector nozzle (3) until sealing compound (4) escapes on both sides.



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D1.5 - Perform additional crimps



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- Repeat steps D1.1 to D1.4 to repair additional cables.

In this case, select different crimping locations (5) so that the cross-section of the wiring harness is not substantially increased.

D1.6 - Insulate wiring harness

- Insulate wiring harness with commercially available plastic or textile adhesive tape (6) in accordance with insulation of original wiring harness.
- Also insulate wiring harness in the opposite direction (7).