

**Items needed:**


**1) A Splice Kit**



1 - 14 - 16 AWG  
Uninsulated butt  
connector.  
FASTENAL  
P/N: 58615

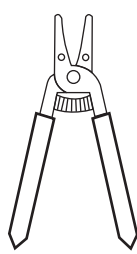


2 - 20 - 18 AWG  
Sealed Crimp +  
Solder connectors  
FASTENAL  
P/N: 07009714



1 - 3/8" x 6" Flexible, Adhesive-Lined Heat  
Shrink Tube. FASTENAL P/N: 0714596

**2) Tools**



Wire strippers



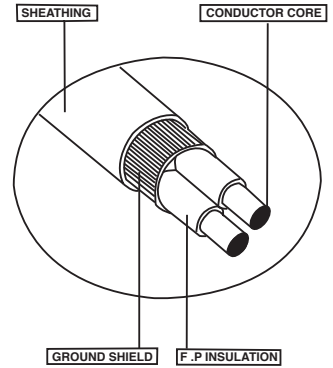
Crimping tool



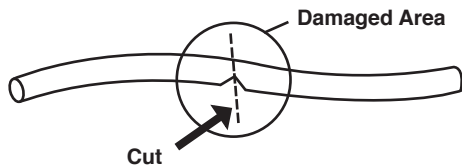
Butane Torch



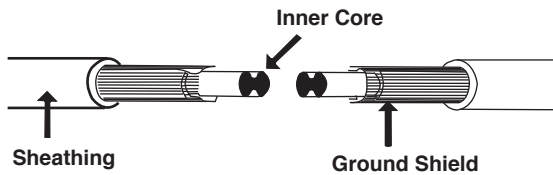
Hot air pistol



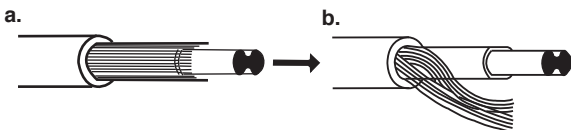
**Step 1** - Determine where the damage is and make a clean cut through the wire.



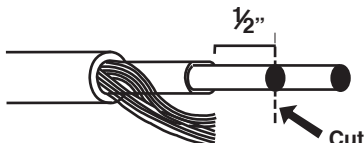
**Step 2** - Using wire strippers, strip 1" of the outer insulation from both cables.



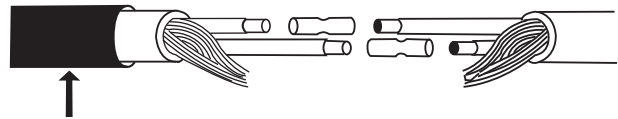
**Step 3** - Separate the braided sheath wire from the inner layer of insulation.



**Step 4** - Shorten one inner conductor wire of both the cables to 1/2".



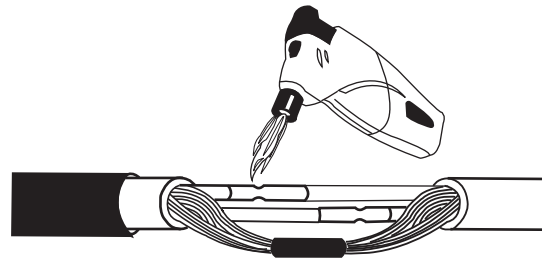
**Step 5** - Place heat shrink tube over one side of the cable & then insert the inner conductor wires into each side of the crimp-on connector.



3/8" heat shrink tube

**Step 6** - Compress the crimp-on connector on each side using crimp tool and overlap both braided sheath wires and connect them with the uninsulated butt connector connector. Using a butane torch, carefully heat crimp connectors to seal crimp and melt solder.

**Heat Connector with Butane Torch**



Uninsulated butt connector

**Step 7** - Slide the heat shrink tube over the completed joint and shrink it with a hot air pistol. Do not use a naked flame. 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.

