

SOLN1 25 Wiring Harness Solder Guide

<i>Wiring harness leads</i>	<i>Negative</i>	<i>Positive</i>
<i>Male, short</i>	WHM-s	WHM+s
<i>Male, long</i>	WHM-l	WHM+l
<i>Female (enclosed prongs)</i>	WHF-	WHF+

Everything is tinned before soldering.

- Trim two black leads at 24½” (WHM-s) and 32½” (WHM-l)
- Trim two red leads at 4½” (WHM+s) and 8½” (WHM+l)
- Trim inverter excess leads at 3” (black, WHF-) and 3½” (red, WHF+)
- Find + and - sides on WHM
- Solder WHM-s/l to WHM-; use medium black heatshrink
- Solder WHM+s/l to WHM+; use large red heatshrink
- Cover WHM with large clear heatshrink
- Solder WHF- and WHF+; cover both with small black heatshrink, ensuring residual heat or brief heat gun shrink enough to push inside sheath before shrinking the rest of the way
- Crimp ring connectors to WHM-s/l, long leads on inline fuses
- Crimp butt connectors between WHM+s/l and short leads of inline fuses