

## MINI POWER ITA CONTACT ASSEMBLY

PART # 610 115 124 / 610 115 125



Dimensions shown: [millimeters]  
inches

### ASSEMBLY INSTRUCTIONS

1. Strip wire (**Figure A**).
2. Insert a piece of 0.25" [6.35 mm] diameter shrink tubing 1.00" [25.4 mm] long onto wire.
3. Solder and clean (**Figure B**). VPC solders per IPC'S J-STD-001.  
*NOTE: Make sure the heat from the solder does not shrink the tubing.*
4. Slide the piece of shrink tubing over the soldered end, up to the inspection hole; make sure that the inspection hole is not covered (**Figure C**).
5. Shrink the tubing.

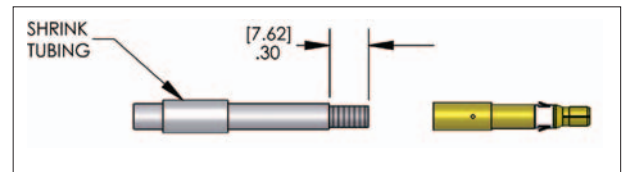


Figure A. Strip length.

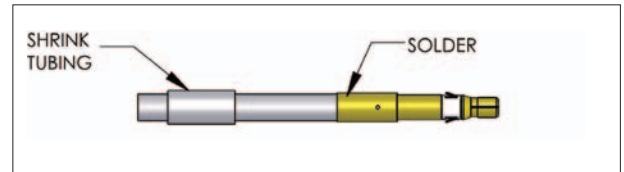


Figure B. Solder, taking care not to shrink the tubing.

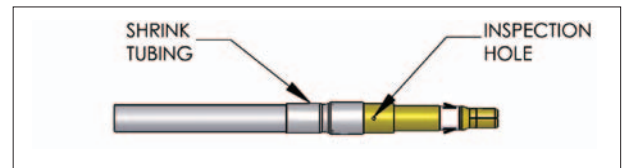


Figure C. Ensure inspection hole is not covered.