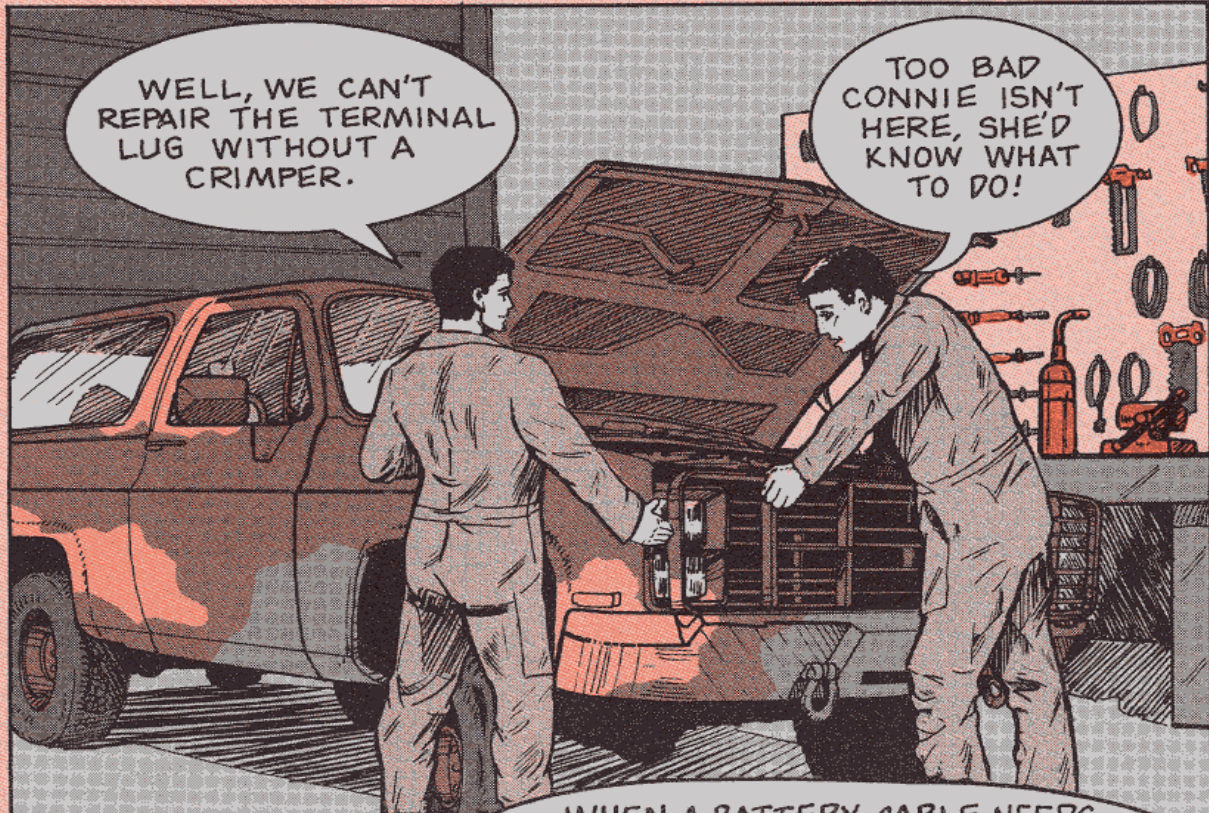


Battery Cables ...

# Solder,



WELL, WE CAN'T REPAIR THE TERMINAL LUG WITHOUT A CRIMPER.

TOO BAD CONNIE ISN'T HERE, SHE'D KNOW WHAT TO DO!

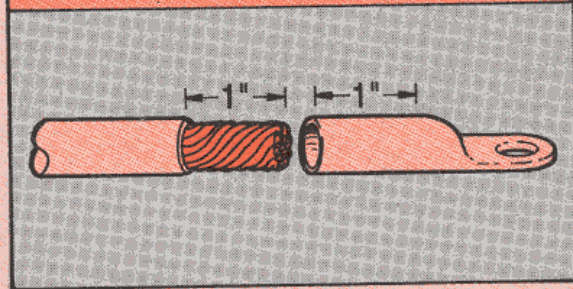


WHEN A BATTERY CABLE NEEDS A NEW TERMINAL LUG AND A PROPER CRIMPER IS NOT AVAILABLE, YOU CAN MAKE DO WITH SOLDER. YOU NEED...

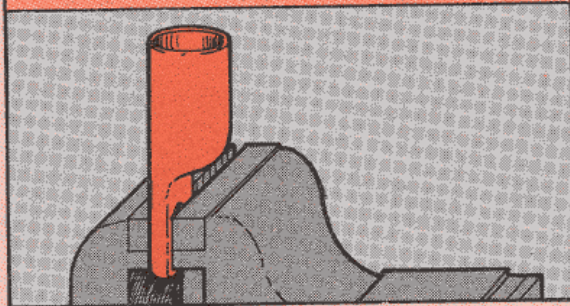
- ➔ The propane torch kit from the No. 1 Common shop set
- ➔ A 1-lb spool of 50/50 rosin core solder, NSN 3439-00-640-2404
- ➔ A terminal lug (see the -20P manual for your equipment - truck, generator, etc.)
- ➔ Heat-shrinkable tubing, NSN 5970-00-815-1300
- ➔ Face protection and gloves

# Soldier!

**1.** Strip about an inch of insulation from the cable. That should match the depth of the lug well.

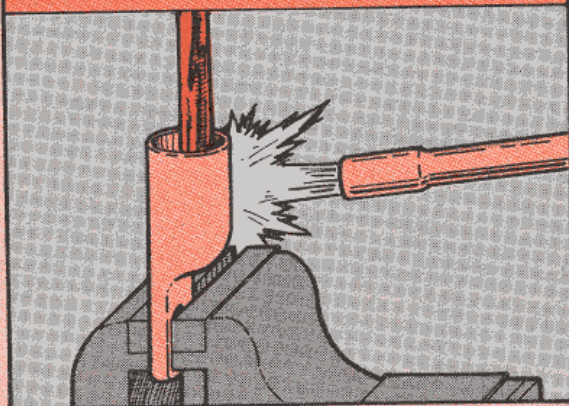


**2.** Clamp your new lug in a vise, so it points straight up.



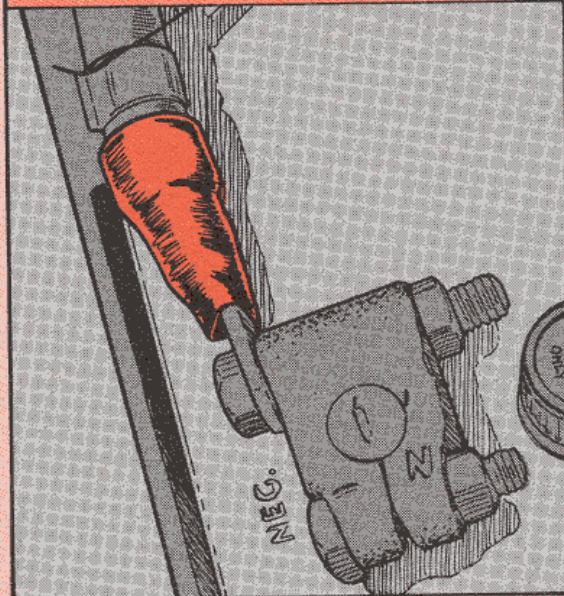
**3.** Slide a 2-in piece of heat-shrinkable tubing over the cable and out of the way.

**4.** With the torch and solder, tin the bare wire of the cable. Then, fill two-thirds of the lug well with molten solder.



**5.** Keep both the bare end of the cable and the lug hot. Push the bare end of the cable into the solder. Take away the heat. Hold the cable end in the lug until the solder hardens.

**6.** Let the lug cool until you can touch it. Slide the heat-shrinkable tubing into place. Cover one-half inch of the lug. Shrink the tubing with the torch. That keeps out corrosion.



IF YOU  
NEED ANY  
REFRESHER  
INFORMATION  
ON SOLDERING,  
GET A COPY OF  
TB SIG 222.

