



### PRODUCT SERVICE BULLETIN NO. 73-1

#### WIRE TERMINATION AND TERMINAL IDENTIFICATION

This bulletin aids the ELEC-TRAK tractor mechanic in the selection of the proper wire termination and in preventing component damage during soldering while still providing a good electrical connection.

Two varieties of terminals have been supplied to Elec-Trak tractor dealers as spare parts; closed-barrel types and open-barrel types.

To select the proper terminal, consider the following:

- Terminal Style - Ring, fast-on, edge, mate-n-lok pin, mate-n-lok socket, shur-plug, bifurcated, etc.
- Wire Gage - The diameter of the wire
- Stud Size - The size of the stud to which the ring terminal is fastened

Use Fig. 1 and Table I to determine which terminal is required.

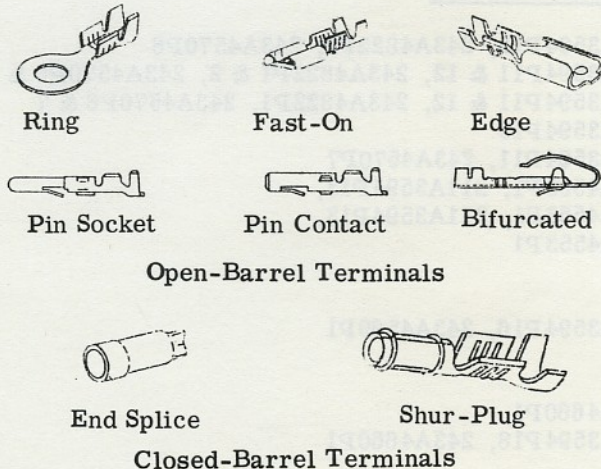


Fig. 1

#### Terminal Crimping

Two types of crimping tools are available:

1. Yellow handle, Part No. 243A4510P1, for crimping closed-barrel terminals and splices.
2. Blue handle, Part No. 243A4510P2, for crimping open-barrel terminals.

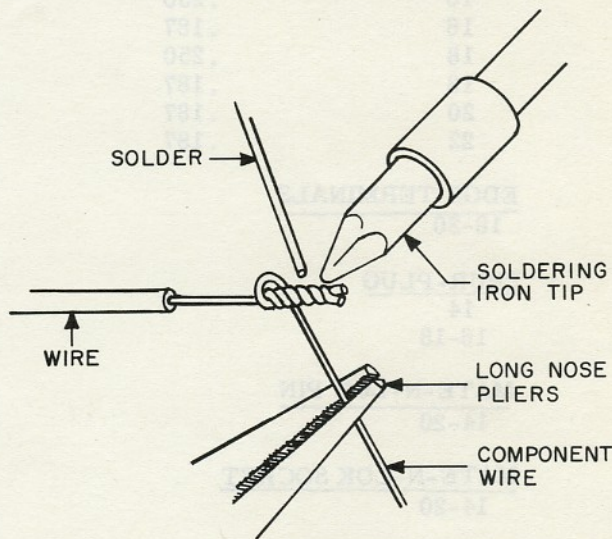
Terminals which cannot be accommodated by either of the supplied crimping tools should be partially closed on the wire with another tool, such as pliers, and then soldered. (See soldering instructions.)

Wire and terminals should be free of dust, dirt, and grease. A good mechanical connection should be made before soldering by twisting the wires together or closing the terminal on the wire. Only rosin core solder should be used, since acid core solder may cause corrosion.

#### Soldering

Use the proper soldering gun or iron for the job. An iron of 150 watts is sufficient to solder any terminal in the tractor. For small terminals or connections such as small diodes, varistors, etc. a lower-wattage iron (40 watts) should be used, while soldering on printed circuit cards requires an iron with a 25 watt rating.

When soldering or desoldering any component (diode, resistor, etc.) a heat sink should be used to prevent excessive heat from reaching the component (See Fig. 2). By grasping the component wire between the component body and the joint to be soldered, heat traveling towards the component is blocked. When the soldering iron tip is held against the joint, feed solder between the tip and joint to provide high localized temperature for quick soldering.



USING PLIERS AS A HEAT SINK TO PREVENT HEAT DAMAGE TO COMPONENTS

Fig. 2

