

Housing Assembly (HA, 22-0000)

BILL OF MATERIAL:			
PART #	PART DESCRIPTION	QTY	<input checked="" type="checkbox"/>
22-1111	Main Housing	1	<input type="checkbox"/>
22-2222	Top Pin	1	<input type="checkbox"/>
22-3333	Contactor-B	1	<input type="checkbox"/>
22-4444	Tab	10	<input type="checkbox"/>
22-5555	Resistor	9	<input type="checkbox"/>
22-6666	Tab Screw	10	<input type="checkbox"/>
WHEN COMPLETE: INITIAL & DATE →			

NOTE: Refer to [Figure 3](#) and [Figure 4](#)

- 1.0. Insert and secure the Contactor-B (22-3333, 1x) onto the Main Housing (22-1111, 1x). Make sure Contactor-B is placed in 12 o'clock position on the Main Housing.
- 2.0. Insert and secure the Stop Pin (22-2222, 1x) onto the Main Housing at 1 o'clock position.
- 3.0. Tab & Tab Screw Installation:
 - 3.1 Place the Tab (22-4444, 1x) into the 2 o'clock position on the Main Housing. Secure the Tab onto the Main Housing using Tab Screw (22-6666, 1x).
 - 3.2 Repeat Step [3.1](#), in order to install Tab and Tab Screw onto the Main Housing from 3 o'clock position to 11 o'clock position on the Main Housing.
- 4.0. Soldering Of the Resistors:
 - 4.1 Place the Main Housing into the Vice Clamp.
 - 4.2 Place the Resistor (22-5555, 1x) between the Tabs (Tab at 2 o'clock position and Tab at 3 o'clock position).
 - 4.3 Using Pliers, bend the leads of the Resistor at each end and pass the leads of the Resistor through the Tabs hole.

- 4.4 Using Soldering Iron and Solder, solder the Resistor onto the Tabs.
- 4.5 Using Wire Cutter, cutoff the excess leads of the Resistor.
- 4.6 Using IPA Alcohol and Q-tip clean up the surfaces of the Tabs.
- 4.7 Repeat Steps 4.2 through 4.6, in order to solder resistors between Tabs (from Tabs at 3 o'clock position through Tab at 11 o'clock position).

FIGURE 3. Housing Assembly (View 1)

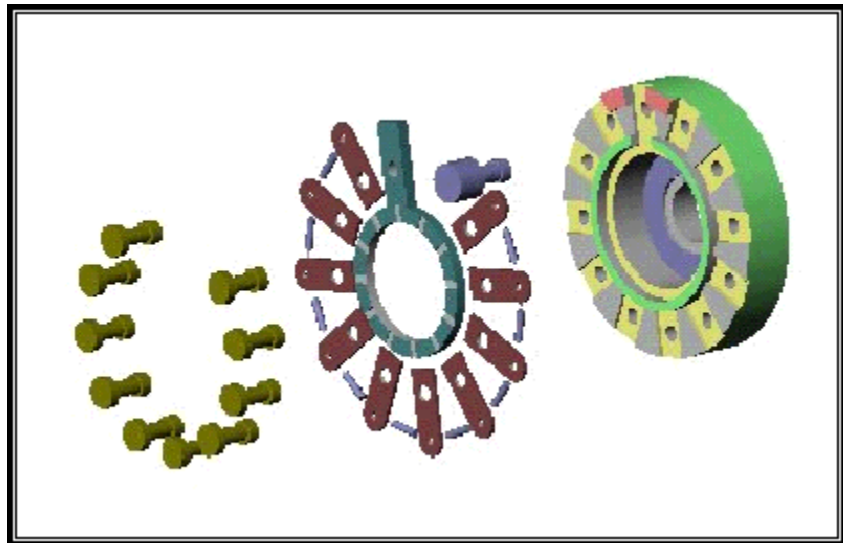


FIGURE 4. Housing Assembly (View 2)

