

Ford SRS Connectors



Offset



Chamfered Down



Chamfered Up

Ford Repair Procedures

WIRING REPAIR KIT

KIT CONTENTS		
Part Number	Description	Quantity
Kit Specific	Connector With Leads	1
Kit Specific	Butt Splices (with 14 AWG and Larger Diameter Wire)	As Required
ESD-349056-47	Clear HeatShrink Sleeve	As Required
34-3022-148475-AA	Instruction Sheet	1

SERVICE PROCEDURE:

NOTE: Refer to applicable model year wiring diagram for circuit information. For twisted wire circuit repair, the twisting must not be disturbed for more than 2 inches. Twist the repaired wires in the same direction and with the same general twist rate as the original wiring. Re-apply the shielding on shielded circuits. Instruction for the use of Rotunda 164-R5901 Pre-Crimper and additional soldering guidance can be found in TSB 03-11-6

1. Disconnect battery ground.
2. Disconnect connector from affected component. Remove tape and convuls.
3. Cut first circuit approximately 3 inches from connector. Leave enough wire to allow repairs to be staggered to minimize harness diameter and to maintain harness length. Excess wire from the harness can be folded back on itself to maintain harness length.

For kits with 16 AWG and smaller diameter wire (solder/heat shrink repair):

1. Strip insulation 1-1/2" from one wire being spliced (Wire #1) and 3/4" from the other.
2. Slide heat shrink tubing at least 1" away from one of the stripped ends being spliced.
3. Twist wires together. Solder wires together using resin core mildly-activated (RMA) solder.
4. Bend Wire #1 back in straight line after solder has cooled. Inspect solder joint bond.
5. Evenly position heat shrink tube over wire repair.
6. Use a shielded heat gun to heat the entire length of heat shrink tubing until hot melt appears from both ends.

For kits with 14 AWG and larger diameter wire (crimp/heat shrink repair):

1. Once wire lengths are sized so repairs can be staggered, strip insulation 1/4" from wire on pigtail.

Depending on the gage of the butt splice and wire harness, the strip length will vary per the following:

WIRE SIZE (REFER TO TSB 03-11-6 FOR GRAPHICS ON HOW TO FOLD STRIPPED WIRE)		BUTT SPlice As Stamped 16-14	
12	1/4" strip, cut 7 strands - All only	12	1/4" strip, All and harness
14	3/8" strip, All and harness	14	3/8" strip, All and harness
16	3/8" strip, All and harness	16	3/8" strip, All and harness
18	5/8" strip, fold 2x diameter - harness	18	5/8" strip, fold 2x diameter - harness
20	1" strip, fold 2x diameter - harness	20	1" strip, fold 2x diameter - harness
22	1-1/4" strip, fold 4x diameter - harness	22	1-1/4" strip, fold 4x diameter - harness
BUTT SPlice As Stamped 12-10		10	1/4" strip, All and harness
12	1/4" strip, All and harness	12	1/4" strip, All and harness
14	3/8" strip, fold 2x diameter - harness	14	3/8" strip, fold 2x diameter - harness
16	1" strip, fold 2x diameter - harness	16	1" strip, fold 2x diameter - harness
18	1-1/4" strip, fold 4x diameter - harness	18	1-1/4" strip, fold 4x diameter - harness

2. Slide heat shrink tubing at least 1" away from one of the stripped ends being spliced.
3. Identify the appropriate crimping chamber of the Rotunda 164-R5901 Pre-Crimper by matching the wire size on the tool die with the wire size stamped on the butt splice.
4. Center one end of the butt splice in the appropriate crimping chamber.
5. Engage the Pre-Crimper but don't deform the butt splice.
6. Insert stripped wire into the splice until wire hits stop. Make sure insulation does not enter splice.
7. Holding wire in place, squeeze tool handles together until ratchet releases.
8. Reposition the uncrimped splice in the same crimping chamber and repeat steps 3 to 6.
9. Inspect repair for acceptable crimp.
10. Evenly position heat shrink tubing over wire repair.
11. Use a shielded heat gun to heat the entire length of a heat shrink tubing until hot melt appears from both ends.

NOTE:

- Repeat process as needed to repair remaining circuits. Stagger repairs so harness doesn't become too large.
- Seal the ends of all pigtail leads not being used with dual wall heat shrink and slow. Silicone must not be used.
- Re-apply convolute and tape. Reconnect battery ground when repairs are complete.

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 WIRING REPAIR KIT

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 WIRING REPAIR KIT

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