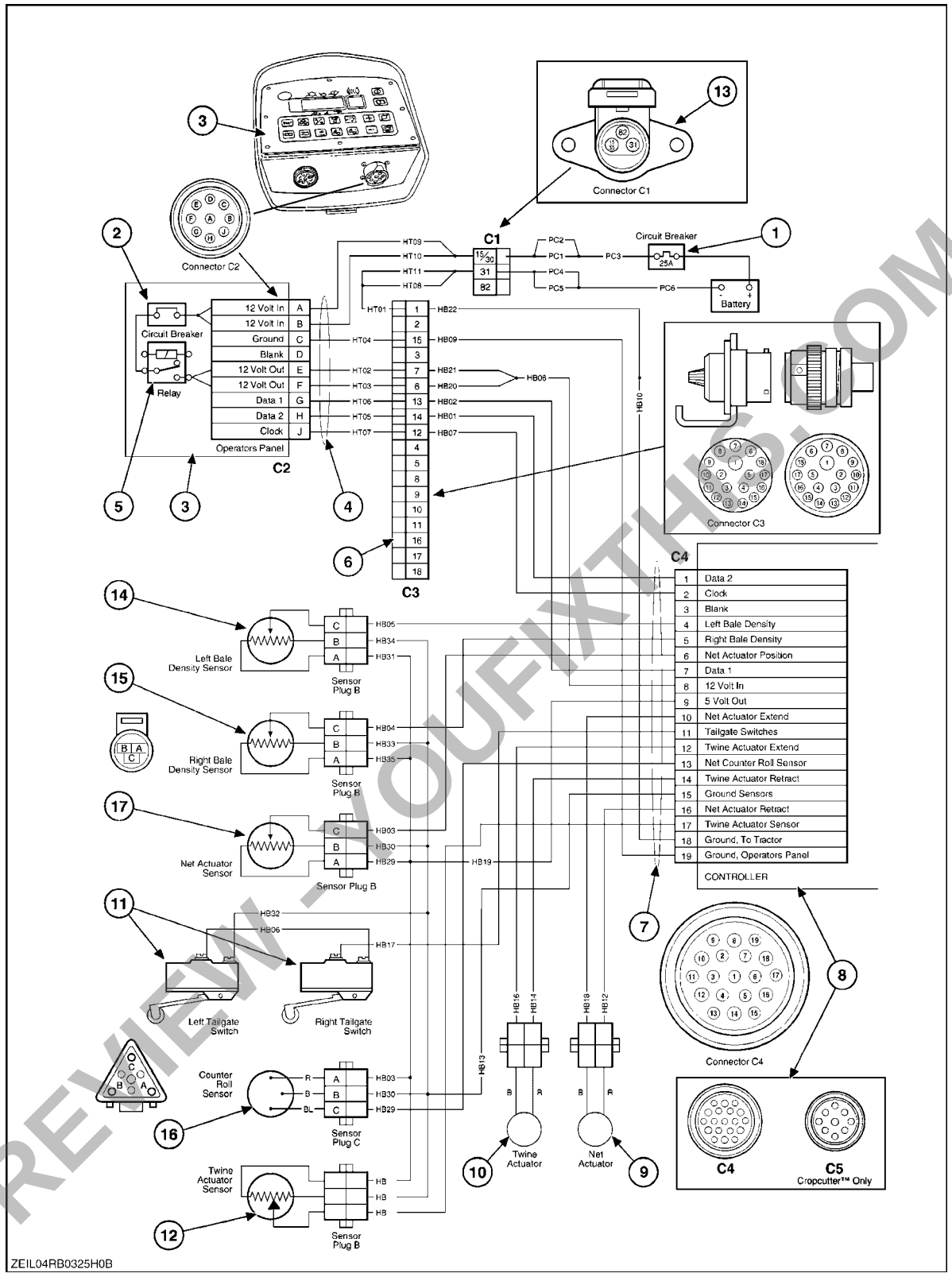


ZEIL04RB0325H0B 1

SYSTEM COMPONENTS	CUTTER CONTROL CONNECTOR PINS
Item and function	**Pin and Function**
1. Actuator position sensor	A. Actuator position sensor
2. Sensor plug	B. Blank
3. Cutter connector to control box (C5)	C. Knife position switch
4. Connector C5	D. Actuator extend
5. Knife actuator	E. Actuator extend
6. Knife position switch	F. Sensor ground

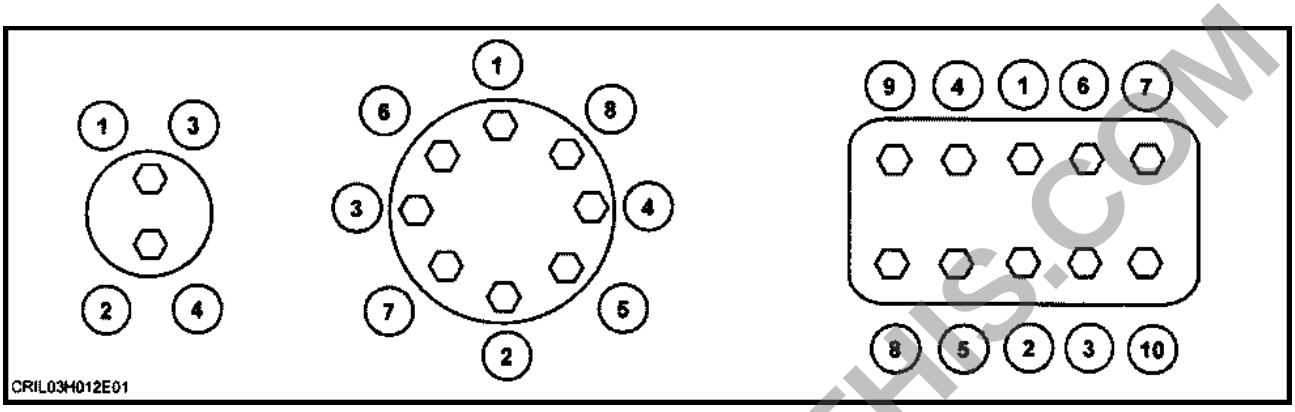
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Torque (- A.90.A.10)

RBX341

Minimum hardware tightening torques Nm lb ft lb in for normal assembly applications unless otherwise stated

IMPORTANT: *Shown below is the suggested initial torque tightening sequences for general applications, tighten in sequence from item 1 through to the last item of the hardware.*



df5019-1 1

Imperial hardware

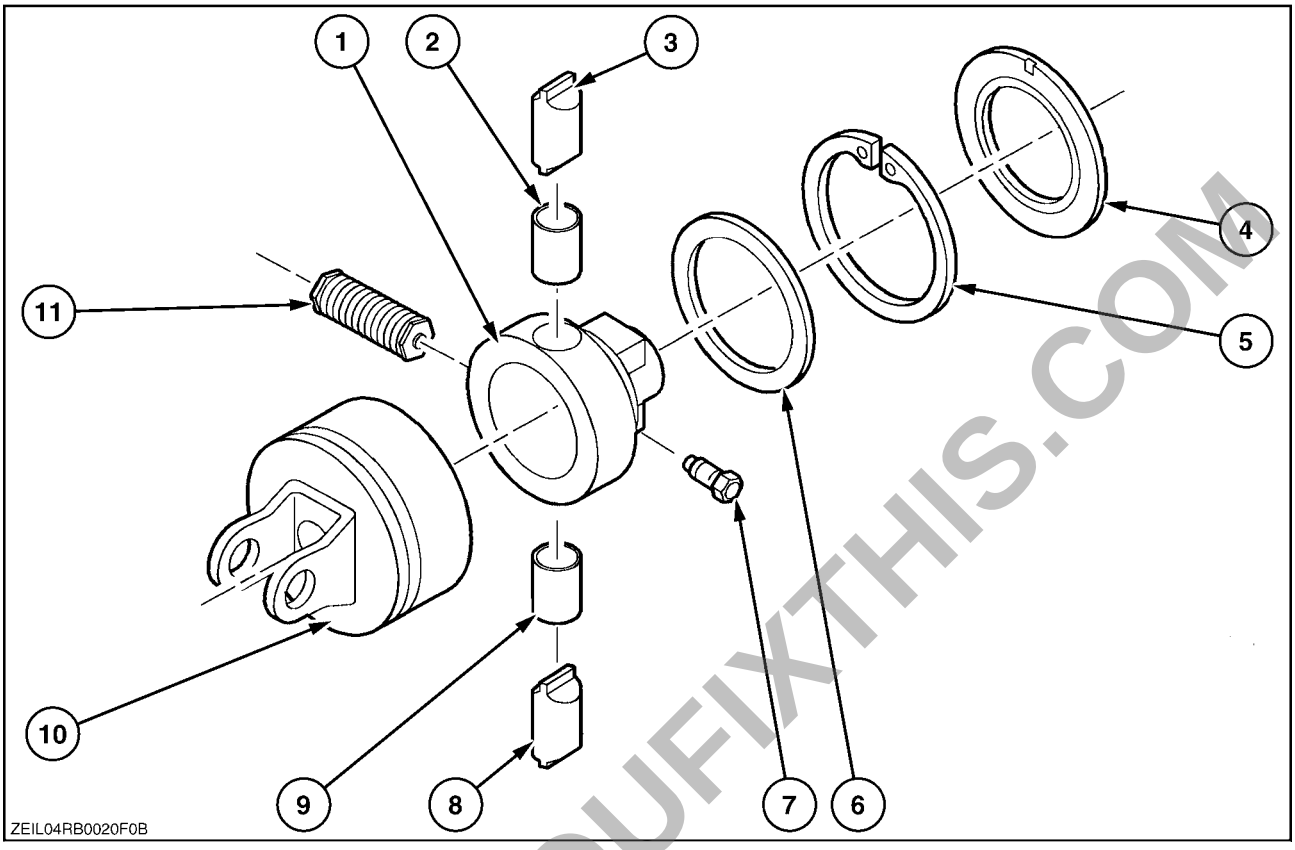
Nominal Size	SAE GRADE 2 Unplated or Silver plated	SAE GRADE 2 plated w/ZnCr GOLD	SAE GRADE 5 Unplated or Silver plated	SAE GRADE 5 plated w/ZnCr GOLD	SAE GRADE 8Unplated or Silver plated	SAE GRADE 8 plated w/ZnCr GOLD	LOCK-NUTS GR.B w/GR5 BOLT	LOCK-NUTS GR.B w/GR8 BOLT
1/4	**6.2 Nm 55 lb in**	**8.1 Nm 72 lb in**	**9.7 Nm 86 lb in**	**13 Nm 112 lb in**	**14 Nm 121 lb in**	**18 Nm 157 lb in**	**6.9 Nm 61 lb in**	**9.8 Nm 86 lb in**
5/16	**13 Nm 115 lb in**	**17 Nm 149 lb in**	**20 Nm 178 lb in**	**26 Nm 229 lb in**	**28 Nm 250 lb in**	**37 Nm 324 lb in**	**14 Nm 125 lb in**	**20 Nm 176 lb in**
3/8	**23 Nm 17 lb ft**	**30 Nm 22 lb ft**	**35 Nm 26 lb ft**	**46 Nm 34 lb ft**	**50 Nm 37 lb ft**	**65 Nm 48 lb ft**	**26 Nm 19 lb ft**	**35 Nm 26 lb ft**
7/16	**37 Nm 27 lb ft**	**47 Nm 35 lb ft**	**57 Nm 42 lb ft**	**73 Nm 54 lb ft**	**80 Nm 59 lb ft**	**104 Nm 77 lb ft**	**41 Nm 30 lb ft**	**57 Nm 42 lb ft**
1/2	**27 Nm 42 lb ft**	**73 Nm 54 lb ft**	**87 Nm 64 lb ft**	**113 Nm 83 lb ft**	**123 Nm 91 lb ft**	**159 Nm 117 lb ft**	**61 Nm 45 lb ft**	**88 Nm 64 lb ft**
9/16	**81 Nm 60 lb ft**	**104 Nm 77 lb ft**	**125 Nm 92 lb ft**	**163 Nm 120 lb ft**	**176 Nm 130 lb ft**	**229 Nm 169 lb ft**	**88 Nm 65 lb ft**	**125 Nm 92 lb ft**
5/8	**112 Nm 83 lb ft**	**145 Nm 107 lb ft**	**174 Nm 128 lb ft**	**224 Nm 165 lb ft**	**244 Nm 180 lb ft**	**316 Nm 233 lb ft**	**122 Nm 90 lb ft**	**172 Nm 127 lb ft**
3/4	**198 Nm 146 lb ft**	**256 Nm 189 lb ft**	**306 Nm 226 lb ft**	**397 Nm 293 lb ft**	**432 Nm 319 lb ft**	**560 Nm 413 lb ft**	**217 Nm 160 lb ft**	**305 Nm 226 lb ft**
7/8	**193 Nm 142 lb ft**	**248 Nm 183 lb ft**	**495 Nm 365 lb ft**	**641 Nm 473 lb ft**	**698 Nm 515 lb ft**	**904 Nm 667 lb ft**	**350 Nm 258 lb ft**	**494 Nm 364 lb ft**
1.0	**289 Nm 213 lb ft**	**373 Nm 275 lb ft**	**742 Nm 547 lb ft**	**960 Nm 708 lb ft**	**1048 Nm 773 lb ft**	**1356 Nm 1000 lb ft**	**523 Nm 386 lb ft**	**739 Nm 545 lb ft**

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Torque limiter - Exploded view (B.90.A.46 - C.10.A.20)

RBX341



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Cut out clutch components	
1. Hub	7. Special clamping bolt
2. Bushing	8. Locking cams
3. Locking cams	9. Bushing
4. Sealing ring	10. Clutch housing
5. Retaining ring	11. Shift cam
6. Ring	

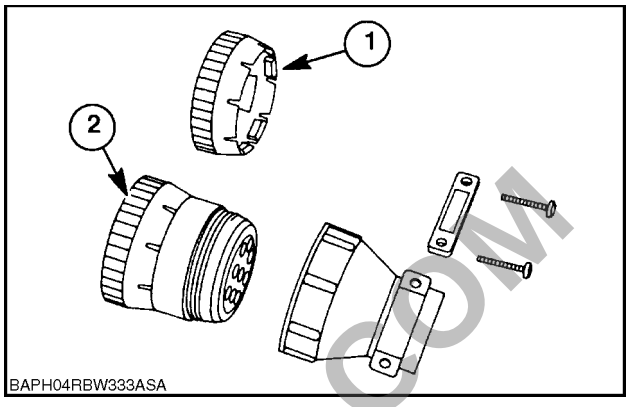
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Connector - Overhaul (A.30.A.87 - F.10.A.40)

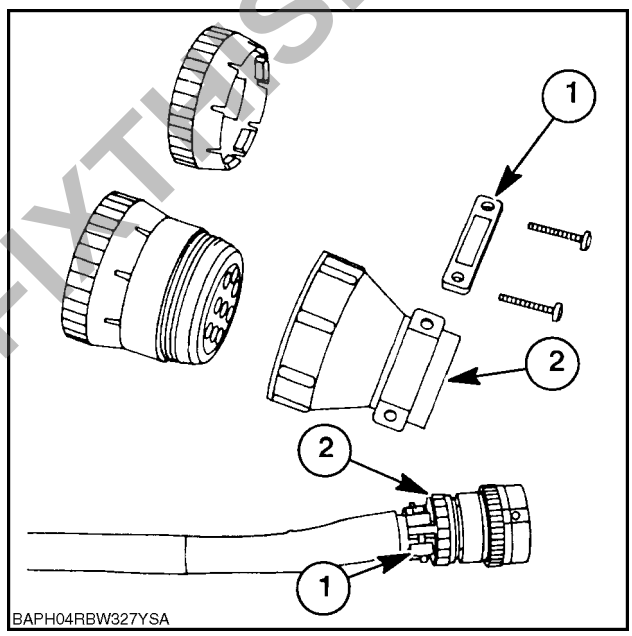
RBX341

1. Deutsch-type wire harness connectors are used in the monitor system to connect the harnesses to the controller, junction box and operator panel. The connectors can be repaired using tools
   Extraction tools
   Crimping pliers
   Electrician's pliers
   Installing a new ring on a plastic connector body
   If the ring **(1)** on a plastic connector body is broken, it can be replaced with a new one without removing the connector from the harness. Remove all parts of the broken ring. Align the new ring with the end of the body **(2)** and carefully push it over the rib on the body.



BAPH04RBW333ASA 1

2. Replacing a connector body
   The same procedure is used for both the plastic connector as shown at the top of and for the metal connector as shown at the bottom.
   1. Remove the cable clamp **(1)** from the connector.
   2. Unscrew the clamp end cap **(2)**.



BAPH04RBW327YSA 2

3. Slide the rubber boot's **(1)** over the harness as far as possible to expose the wires.
   4. Remove the wires from the connector as described below.
   5. Install the wire terminals in the new connector as described on the next page. NOTE: Refer to the monitor wiring diagram to determine the correct hole location for each wire. Install a plug in any unused holes in the connector.
   6. Reinstall the rubber boot's **(1)** followed by clamp end cap **(2)** and cable clamp **(1)**.

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ELECTRONIC SYSTEM - Fault code index (A.50.A - C.40.G.10)

RBX341

FAULT CODES

1. **CHOPPING Crop cutter - Not calibrated (K.30.E - G.30.D.20)**
   CHOPPING Crop cutter - Not calibrated (K.30.E - G.30.D.20)
   Density device - Bad calibration (K.50.D.30 - G.30.D.10)
   Density device - Not calibrated (K.50.D.30 - G.30.D.20)
   Density device - Not calibrated (K.50.D.30 - G.30.D.20)
   Density device - Not calibrated (K.50.D.30 - G.30.D.20)
   Density device - Not calibrated (K.50.D.30 - G.30.D.20)
   Density device - Not calibrated (K.50.D.30 - G.30.D.20)
   Density device - Problem solving (K.50.D.30 - G.40.A.30)
   Density device - Troubleshooting (K.50.D.30 - G.40.A.10)
   Duckbill - Problem solving (K.55.F.65 - G.40.A.30)
   Knife engagement system - Not calibrated (K.30.E.62 - G.30.D.20)
   Monitor - No power (A.50.A.90 - G.30.B.10)
   Monitor - Problem solving (A.50.A.90 - G.40.A.30)
   Monitor - Testing (A.50.A.90 - G.40.A.20)
   Monitor - Testing (A.50.A.90 - G.40.A.20)
   Monitor - Troubleshooting (A.50.A.90 - G.40.A.10)
   Monitor Input function - Bad calibration (A.50.A.90.10 - G.30.D.10)
   Sensing system - Bad calibration (K.50.D.95 - G.30.D.10)
   Sensing system - Bad calibration (A.30.A.95 - G.30.D.10)
   Sensing system - Bad calibration (K.50.D.95 - G.30.D.10)
   Sensing system - Not calibrated (K.50.D.95 - G.30.D.20)
   Sensing system - Problem solving (K.50.D.95 - G.40.A.30)
   Sensing system - Problem solving (A.30.A.95 - G.40.A.30)
   Sensing system - Testing (A.30.A.95 - G.40.A.20)
   Sensing system - Troubleshooting (A.30.A.95 - G.40.A.10)
   Sensing system - Troubleshooting (A.30.A.95 - G.40.A.10)
   Twine arm actuator - Not calibrated (K.55.D.56 - G.30.D.20)
   Twine arm actuator - Not calibrated (K.55.D.56 - G.30.D.20)
   WRAPPING AND TYING Net/Film wrapping - Not calibrated (K.55.F - G.30.D.20)
   WRAPPING AND TYING Net/Film wrapping - Not calibrated (K.55.F - G.30.D.20)
   WRAPPING AND TYING Net/Film wrapping - Not calibrated (K.55.F - G.30.D.20)

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Monitor - Troubleshooting (A.50.A.90 - G.40.A.10)

RBX341

Problem	Possible Cause	Correction
Display will not turn on.	Harness not connected to operator panel, controller or power source.	Be sure all harness connections are properly secured.
	Power supply wires reversed.	Reverse the wires. The red wire (with the incorporated circuit breaker) must be connected to the positive post of the battery.
	Low voltage.	Check battery and charging system of tractor. The baler system needs 11 Volts to start up, and 13.5 V-30 Amp. peak load capability.
	Failed or tripped circuit breaker in battery cable.	Check circuit breaker and replace, if necessary.
	Failed or tripped circuit breaker in operator panel.	Check circuit breaker and replace, if necessary.
	Failed relay in operator panel.	Check relay and replace, if necessary
	Damaged wire harness.	Check wire harness, repair or replace, if necessary.
	Defective operator panel or controller.	Check operator panel and/or controller and replace, if necessary.
During calibration of the cutter full extend position: A '14 Er' error message appears on the display and the alarm sounds three short beeps.	The controller will not calibrate if the sensor readout is not between 160 and 249. The MINUS or WRAPS key was pressed.	Press the PLUS key to calibrate the crop cutter full extend position.
	Incorrect sensor mounting.	Check for correct mounting of the sensor.
	Defective sensor/wiring to the sensor.	Test the sensor and/or wiring to the sensor and repair/replace, if necessary.
	Binding in the linkage to the sensor.	Make sure all linkages to the sensor move freely.
	Maladjusted/damaged crop cutter mechanism keeps the actuator from extending completely.	Check proper function of the crop cutter mechanism and repair, if necessary.
	Crop build up in the knife area.	Clean crop build up.
During calibration of the cutter sensor cut position: A '14 Er' error message appears on the display and the alarm sounds three short beeps.	The controller will not calibrate if the sensor readout is not between 70 and 140. The MINUS or PLUS key was pressed.	Press the WRAPS key to calibrate the crop cutter cut position.
	Incorrect sensor mounting.	Check for correct mounting of the sensor.
	Defective sensor/wiring to the sensor.	Test the sensor and/or wiring to the sensor and repair/replace, if necessary.
	Binding in the linkage to the sensor.	Make sure all linkages to the sensor move freely.
The bale shape bar graphs respond too slowly.	The bale shape sensitivity is set too low.	Set the bale shape sensitivity higher.
	Incorrect function of the bale density sensors.	Check proper function of the bale density sensors and replace/repair, if necessary.
	Defective operator panel display.	Perform operator panel test and replace operator panel, if necessary.
The bale shape bar graphs respond too fast and are constantly changing.	The bale shape sensitivity is set too high.	Set the bale shape sensitivity lower.
	Incorrect function of the bale density sensors.	Check proper function of the bale density sensors and replace/repair, if necessary.

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TOOLS

- The tools that manufacturer suggests and illustrates in this manual have been:
  specifically researched and designed for use with these machines
  essential for reliable repair operations
  accurately built and rigorously tested so as to offer efficient and long-lasting operation.
  By using these tools, Repair Personnel will benefit from: - operating in optimal technical conditions
  obtaining the best results - saving time and effort
  working in safe conditions

NOTE: *Wear limit values indicated for certain parts should be considered to be recommended, but not binding. The terms "front", "rear", "right-hand" and "left-hand" (when referred to different parts) are determined from the rear, facing in the direction of travel of the machine during operation.*

TECHNICAL DATA

WEIGHT	
Twine only baler	**2600 kg 6965 lb**
Net/Twine baler	**2685 kg 7193 lb**
TRACTOR REQUIREMENTS	
PTO Input requirements without knives	
Minimum	**37 kW 50 Hp**
Recommended	**52 kW 70 Hp**
Crop cutter 7 knives engaged	
Minimum	**57 kW 77 Hp**
Reccomended	**40 kW 55 Hp**
Crop cutter 15 knives engaged	
Minimum	**44 kW 60 Hp**
Reccomended	**62 kW 85 Hp**
HYDRAULICS	
2 single-acting valves	Minimum **124 bar 1798 psi** Maximum **210 bar 3045 psi**
Output at **RPM**	Minimum **45 L/min11.88 US gal**
PTO	
ELECTRICS	
Bale command plus system	**13.5 volts** +/- 0.5
Road light equipment	B7 DINN72577 - 7 PIN
HITCH HEIGHT	
Low hitch	**450-550 mm 17.7-61.65 in**
High hitch	**750-1000 mm 29.5-39.37 in**
BALE CHAMBER	
Width and Diameter	**120 cm 47.2 in**
BALE WEIGHT	
Range Minimum-Maximum	**120-800 kg 321-2143 lb**
Typical Straw	**120-200 kg 321-535 lb**
Hay	**180-300 kg 482-803 lb**
Silage	**350-800 kg 937-2143 lb**

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MODE	FUNCTION CONFIGURATION	INFORMATION CONDITIONS OPERATORS DISPLAY	CHANGE ADJUST WITH	SAVE NEXT STEP WITH
10/11	A. 10, Bale density sensor left hand side	A. Close tailgate fully (empty position), flashing 10 with a number between 15 and 40	Rotate potentiometer	Press for 2 seconds Switch between 10 and 11
	11, Bale density sensor right hand side	Flashing 11 with a number between 15 and 40	Rotate potentiometer	Press for 2 seconds
		Open tailgate and place two 40mm spacers on the density feeler rods, close tailgate until against spacers (Full position). Flashing 11 with a number between 150 and 249	Hydraulic control from tractor	Press for 2 seconds Switch between 10 and 11
		Flashing 10 with a number between 150 and 249		Press for 2 seconds
12	Net wrap actuator potentiometer adjustment and calibration	Actuator fully extended (insert position), flashing 12 with a number between 20 and 30	Rotate potentiometer	Press for 2 seconds
		Retract actuator so 2mm between knife and knife guide (pre cut position), flashing 12 with a number between 76 and 85	or Place net actuator in desired pre cut position	Press for 2 seconds
		Actuator fully retracted, (home position), flashing 12 with a number between 160 and 249	Press	Press for 2 seconds
13	A. Twine wrap actuator potentiometer adjustment and calibration B. Buffer zone in net only configuration	Actuator fully extended, (insert position), flashing 13 with a number between 20 and 30	Rotate potentiometer	Press for 2 seconds
		Actuator fully retracted (home position), flashing 13 with a number between 160 and 249	Press	Press for 2 seconds

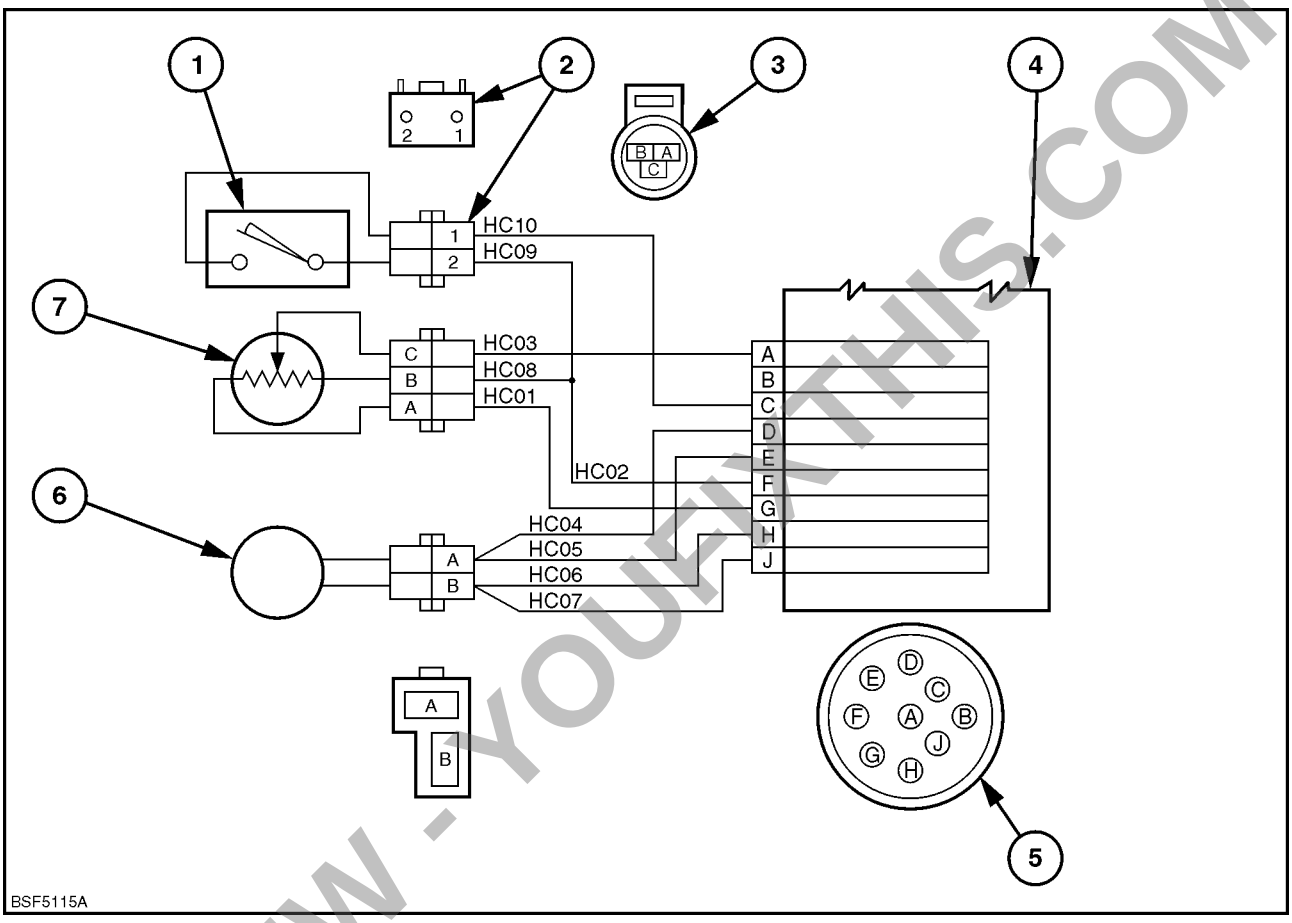
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SYSTEM COMPONENTS	CUTTER CONTROL CONNECTOR PINS
Item and function	**Pin and Function**
7. Knife position switch plug	G. 5V out
	H. Actuator retract
	J. Actuator retract

WIRE COLOUR CODE	R = redB = Black

NOTE: *The following diagram shows the additional components used with the optional cutter system.*



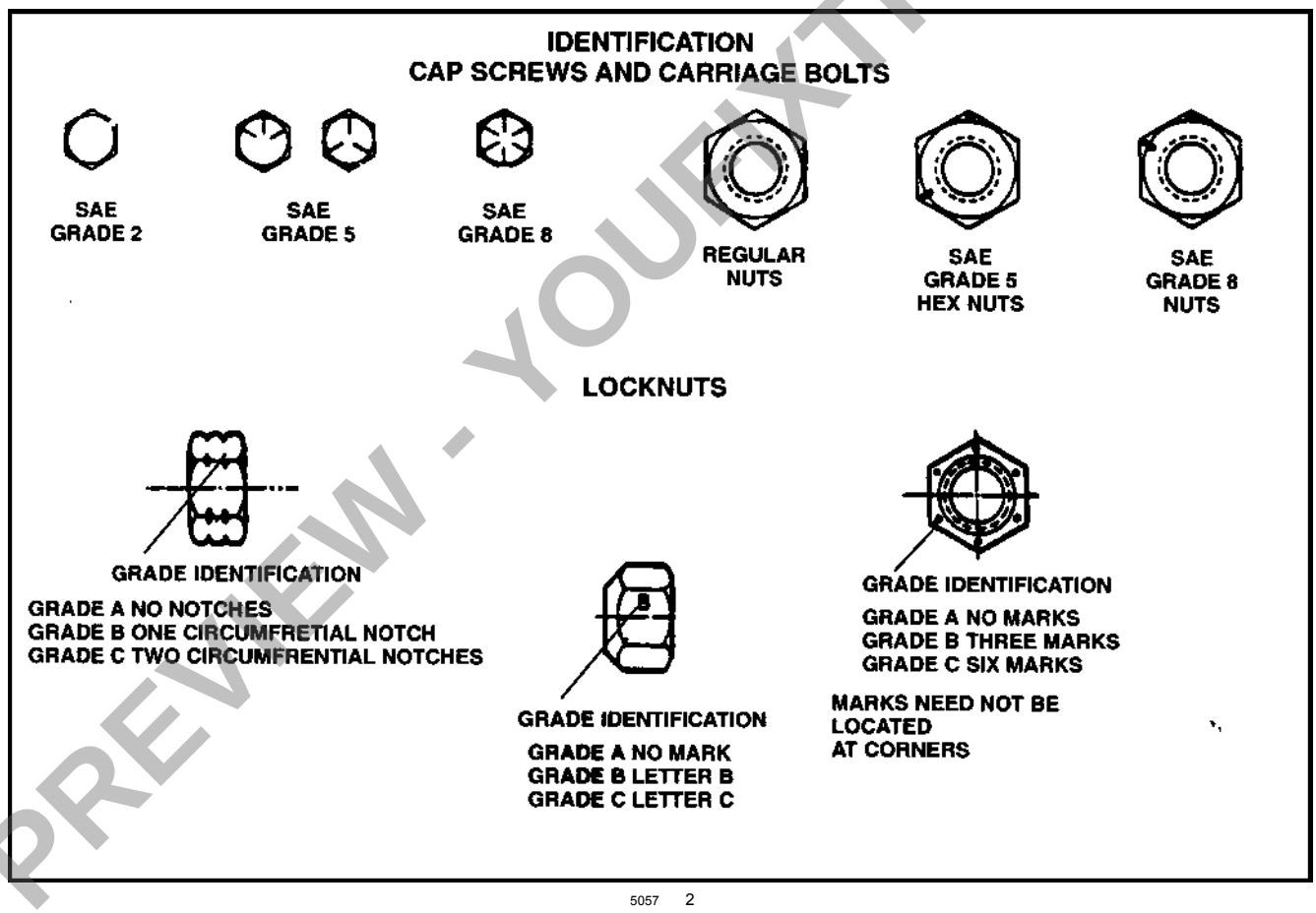
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Metric hardware

Nominal Size	CLASS 5.8 UNPLATED	CLASS 5.8 UNPLATED	CLASS 8.8 UNPLATED	CLASS 8.8 UNPLATED	CLASS 10.9 UNPLATED	CLASS 10.9 UNPLATED	LOCKNUT CL.8 w/CL8.8 BOLT
M4	1.7 Nm 15 lb in	2.2 Nm 19 lb in	2.6 Nm 23 lb in	3.4 Nm 30 lb in	3.7 Nm 33 lb in	4.8 Nm 42 lb in	1.8 Nm 16 lb in
M6	5.8 Nm 51 lb in	7.6 Nm 67 lb in	8.9 Nm 79 lb in	12 Nm 102 lb in	13 Nm 115 lb in	17 Nm 150 lb in	6.3 Nm 56 lb in
M8	14 Nm 124 lb in	18 Nm 159 lb in	22 Nm 195 lb in	28 Nm 248 lb in	31 Nm 274 lb in	40 Nm 354 lb in	15 Nm 133 lb in
M10	28 Nm 21 lb ft	36 Nm 27 lb ft	43 Nm 32 lb ft	56 Nm 41 lb ft	61 Nm 45 lb ft	79 Nm 58 lb ft	30 Nm 22 lb ft
M12	49 Nm 36 lb ft	63 Nm 46 lb ft	75 Nm 55 lb ft	97 Nm 72 lb ft	107 Nm 79 lb ft	138 Nm 102 lb ft	53 Nm 39 lb ft
M16	121 Nm 89 lb ft	158 Nm 117 lb ft	186 Nm 137 lb ft	240 Nm 177 lb ft	266 Nm 196 lb ft	344 Nm 254 lb ft	131 Nm 97 lb ft
M20	237 Nm 175 lb ft	307 Nm 107 lb ft	375 Nm 277 lb ft	485 Nm 358 lb ft	519 Nm 383 lb ft	671 Nm 495 lb ft	265 Nm 195 lb ft
M24	411 Nm 303 lb ft	531 Nm 392 lb ft	648 Nm 478 lb ft	839 Nm 619 lb ft	897 Nm 662 lb ft	1160 Nm 855 lb ft	458 Nm 338 lb ft

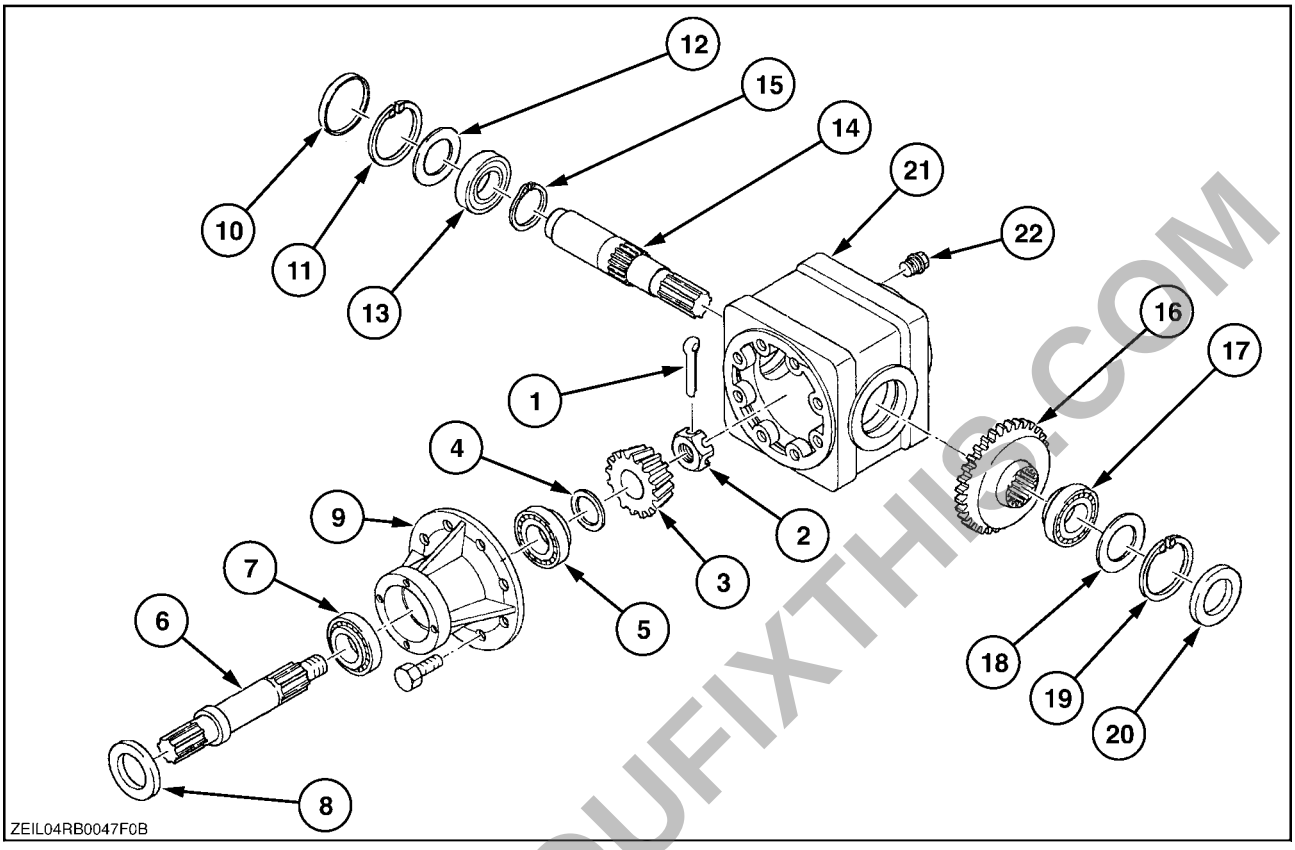


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Gearbox - Exploded view (C.50.B.44 - C.10.A.20)

RBX341



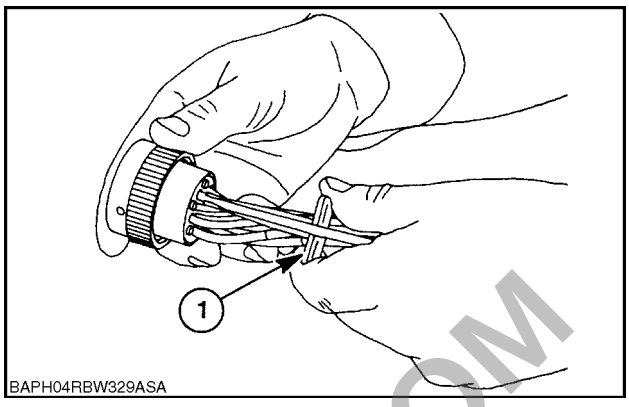
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COMA GEARBOX COMPONENTS	
1. Split pin	12. Shim
2. Nut	13. Ball bearing
3. Bevel drive pinion	14. Splined shaft
4. Shim	15. Retaining ring
5. Roller bearing	16. Crown wheel
6. Splined shaft	17. Roller bearing
7. Roller bearing	18. Shim
8. Seal ring	19. Retaining ring
9. Gearbox	20. Seal ring
10. Cap	21. Gearbox
11. Retaining ring	22. Cap

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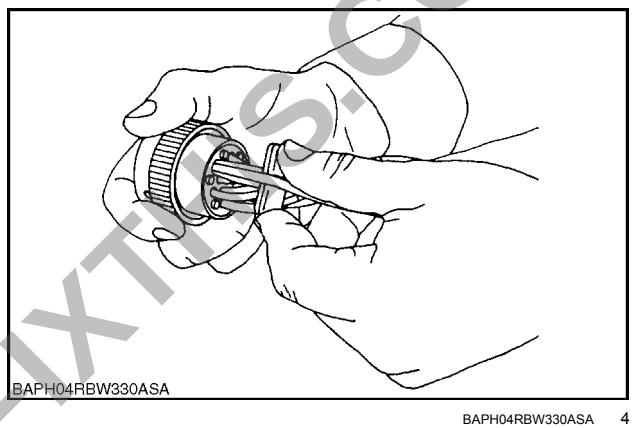
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4. Removing a wire from a connector
1. Position the correct size extraction tool **(1)** on the wire to be removed from the connector as shown.



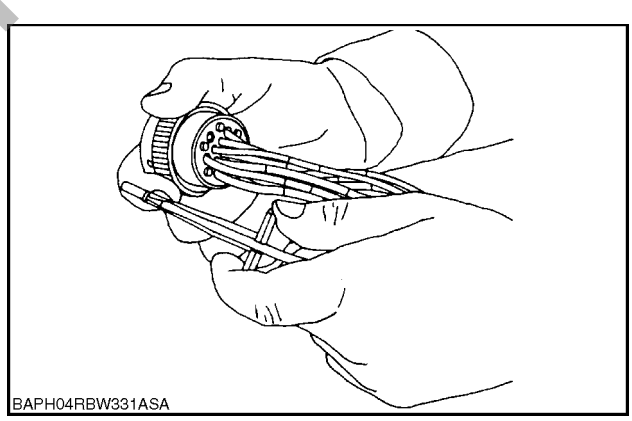
BAPH04RBW329ASA 3

5. Slide the tool along the wire and into the connector as shown until the tool unlocks the terminal from the connector body. This can usually be detected by listening for a click' as the terminal is released.



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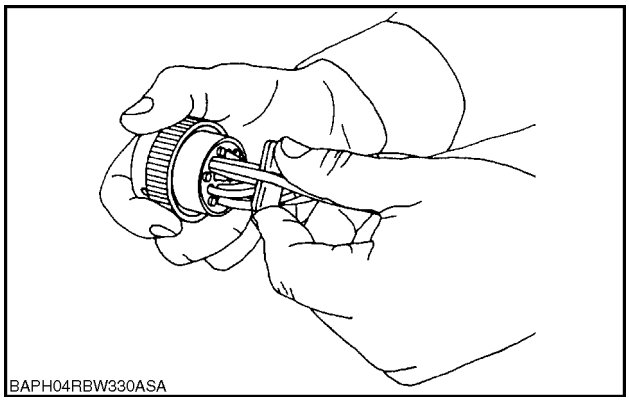
6. Pull the wire, tool, and terminal from the connector as shown.



BAPH04RBW331ASA 5

7. Installing a terminal in a connector
To install a terminal in a connector, simply push the terminal and wire into the appropriate hole in the connector until it clicks into place.

NOTE: It is usually easier to use the extraction tool to reinstall the terminal. This can be done by placing the tool on the wire and part of the terminal as shown and then pushing the tool and wire into the connector as shown, until the clamp release is detected. Remove the tool and check to be sure the terminal is locked in the connector.



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CHOPPING Crop cutter - Not calibrated (K.30.E - G.30.D.20)

RBX341

14 ER - Crop cutter not calibrated

Cause:
Callibration not defined

Possible failure modes:

The controller will not callibrate if the sensor readout is not between 15 and 40 volts.

1. The plus or wraps key was not pressed.

Solution:

1. Press the minus key to callibrate the cutter home position
    A. Maladjusted sensor
    B. Readjust sensor home position
    C. Incorrect sensor mounting
    D. Check for correct mounting
    E. Defective wiring to sensor
    F. Test and repair the wiring
    G. Linkage binding
    H. Adjust linkage

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Problem	Possible Cause	Correction
	Defective operator panel display.	Perform operator panel test and replace operator panel, if necessary.
During calibration of one of the actuators, or during a supply voltage check: The bale command monitor turns off and on again, all display segments light up and the system has returned to the normal operation mode.	Too high a voltage drop at the controller when activating the actuators. Low or insufficient battery voltage.	Check battery and charging system of tractor. The bale command needs **11 volts** to start up, and **13.5 volts 30 amps** peak load capability.
	Loss of electrical power in the wiring from battery to controller.	Check continuity of the wires. Check for loose, corroded or damaged connectors. Check circuit breakers. Connect the bale command system directly to the battery.
	Actuators locked up.	Check for proper adjustments of actuators and linkages. Readjust, if necessary.

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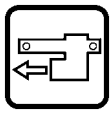
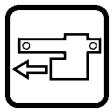
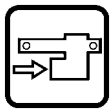
Consumables (- A.92.A.55)

RBX341

Description	Service Interval	Capacity	Brand	International Specification
Multipurpose Grease	10hr - Daily 50hr - Weekly 400hr - Annually		**CASE AKCELA 251H EP MULTI-PURPOSE GREASE**	NLG1 - Class 2
Gearbox oil	400hr - Annually	**1 L 0.26 US gal**	**CASE AKCELA 135H EP GEAR LUBE SAE 80W-90**	API GL5, MIL-L-2105 D SAE 80W-90
Chain Oil	50hr - Weekly		**CASE AKCELA HYDRAULIC EXCAVATORS FLUID BIO**	DIN 51524 part 2 HV 46 ISO VG 46 API CE-MIL-L-2104E MV46
Automatic lubrication system	10hr - Daily	**3 L 0.8 US gal**	**CASE AKCELA HYDRAULIC EXCAVATOR FLUIDCASE AKCELA HYDRAULIC EXCAVATORS FLUID BIO**	DIN 51524 Part 2 HV 46 ISO VG 46 API CE-MIL-L-2104E
Linkages and rods	50hr - Weekly		**CASE AKCELA HYDRAULIC EXCAVATORS FLUID BIO**	DIN 51524 part 2 HV 46 ISO VG 46 API CE-MIL-L-2104E MV46 BIO

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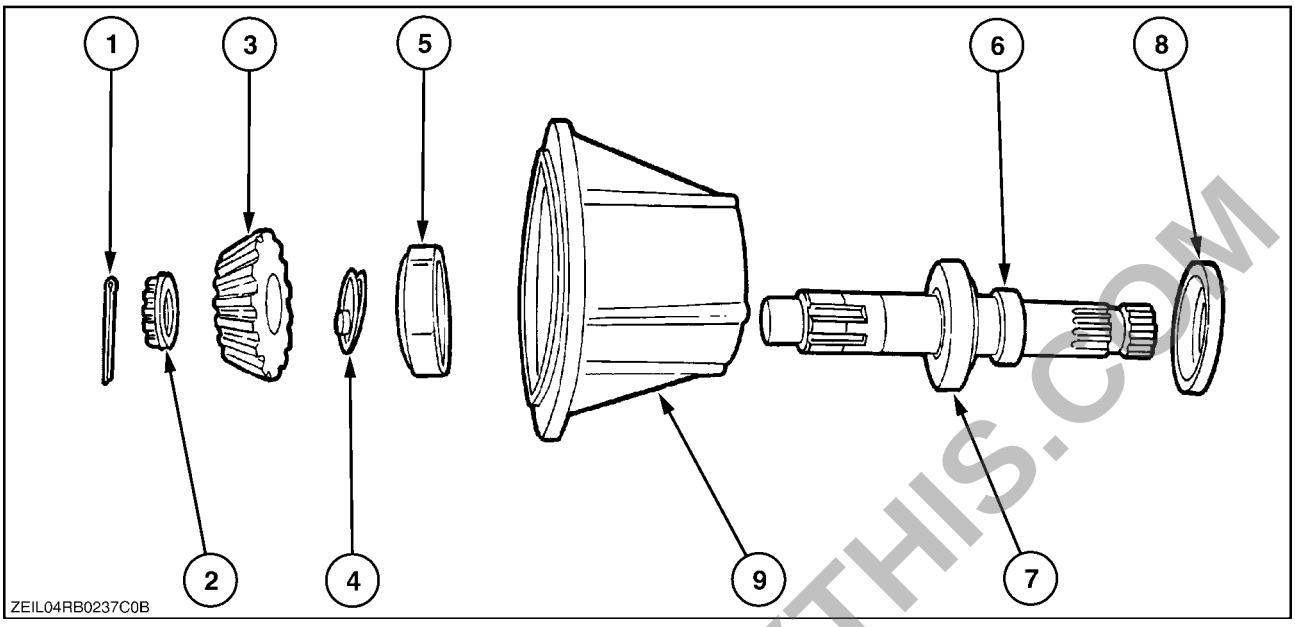
MODE	FUNCTION CONFIGURATION	INFORMATION CONDITIONS OPERATORS DISPLAY	CHANGE ADJUST WITH	SAVE NEXT STEP WITH
14	Crop cutter actuator adjustment and calibration	Actuator fully retracted (home position), flashing 14 with a number between 20 and 30	Rotate potentiometer	 Press for 2 seconds
		Actuator fully extended, Flashing 14 with a number between 160 and 249	 Press	 Press for 2 seconds
		Retract actuator so 2mm gap between knife breakaway link and knife control arm bolt(cut position), flashing 14 with number between 70 and 140	 or  or Place Crop cutter in desired position	 Press for 2 seconds
15	Knife out indication sensor	A. Flashing 15 with three dashes (Knife indication sensor off	 Press for 2 seconds	 Press
		B. Flashing 15 with Lo (metal in front of sensor) or Hi (metal away from sensor) Gap 3-7mm (1/8 to 1/4in)		
16	Tailgate switch adjustment	Flashing 16 with Lo" (both switches closed) or Hi" (one switch open)	Manual close one switch, then manually close both switch	 Press
17	Net counter roll sensor testing	Flashing 17 with Lo (magnet in front of sensor) or Hi (magnet away from sensor), sensor gap 1.5 mm (1/16 in.)	Rotate counter wheel (magnet) in front and away from the sensor face	 Press
18	Bale shape sensitivity	Flashing 18 with a number between 2 (slow) and 50 (fast)	 or 	 Press
19	Software version level	O is operator's panel, C is Electronic Control Unit, versions are on right of display	 or 	 PressPress
20	Operator's panel display and key test	Automatically test the operator's panel display segments, then five dashes, press all the keys, then Pass displayed		 Press

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Gearbox - Exploded view (C.50.B.44 - C.10.A.20)

RBX341



ZEIL04RB0237C0B 1

FRONT PINION ASSEMBLY - COMA GEARBOX	
1. Split pin	6. Shaft
2. Nut	7. Bearing
3. Gear	8. Seal
4. Shims	9. Housing
5. Bearing	

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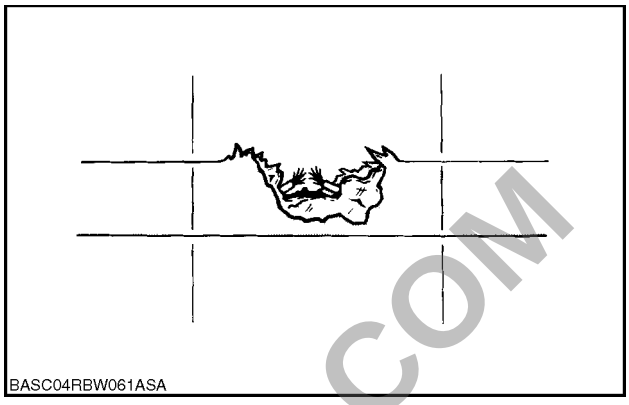
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Wiring harness - Repair (A.30.A.88 - F.75.C.32)

RBX341

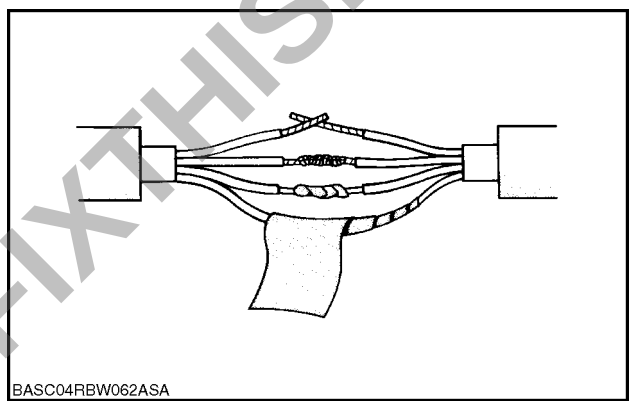
1. The following method to repair wiring is a temporary expedient only. Wiring should be replaced as soon as possible. Replacement of temporary repaired cables with new. Do not attempt to repair the wire on any system sensors as these are sealed and should only be replaced with a new component.

NOTE: *When conducting a cable repair it is important that only RESIN CORED SOLDER is used. Use of other types of solder may result in further cable damage.*



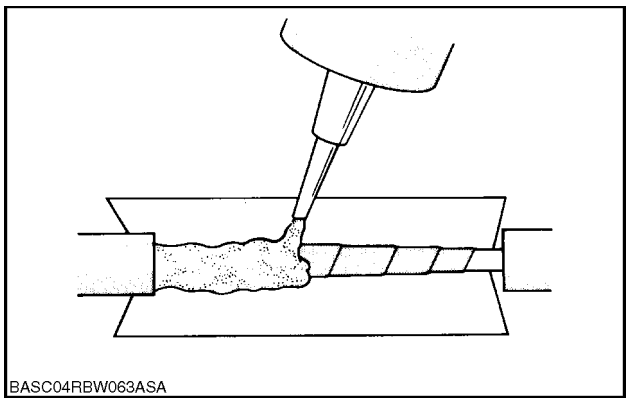
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2. To carry out a temporary repair, proceed as follows:-
1. Locate damaged portion of cable then cut away outer protective cover on both sides of the damaged area.
2. Peel back the cable from both ends of the damaged area and carefully cut away the inner cable cover at the damaged area and strip about **mm0.5 in** of insulation from the wires. Do not cut away any wire strands.
3. Using a suitable solvent, clean about **50 mm 2.0 in** from each cover end. Clean the grey cable cover and the individual leads.



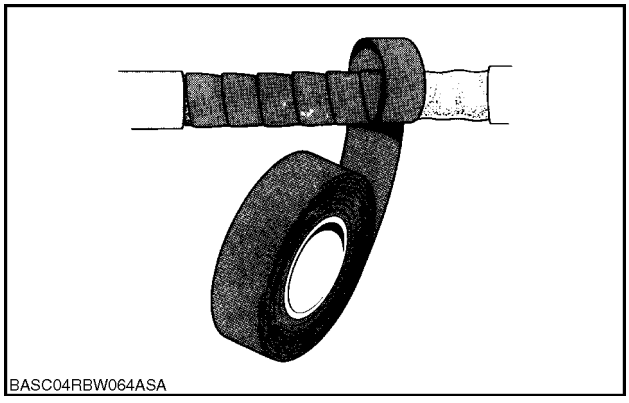
BASC04RBW062ASA 2

3. Twist two bare leads together for each damaged lead, being careful to match wire colours, then solder the leads using resin cored solder. Tape each repaired lead with vinyl insulation tape. Wind a layer of vinyl insulation tape up to the grey cable cover at each end of the repair section. Make a paper trough then apply silicon rubber compound (non hardening sealant) over the repaired section up to the cover ends. Sufficient sealant must be used to fill the ends of the cut away area.



BASC04RBW063ASA 3

4. Allow the compound to cure then cover the area with insulating tape taking the tape well over each end of the repair. An overlap of at least **50 mm 2.0 in** of tape at each end is necessary. Check to ensure the repair is satisfactory and secure the repaired cable so that repeat damage is avoided.



BASC04RBW064ASA 4

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