



## Preparation

- 1) Cut 15mm lengths of 1/16 inch heat shrink. (6 if joining six core cable, 4 for 4 core cable).
- 2) Cut 100mm length of 9mm Glue Heat shrink.
- 3) Strip back 45mm of outer shield on the ends of the cables to be joined. Refer to WIRE\Wirejoin for correct ends.
- 4) Cut the wires to the correct lengths.

Cable attached to load cell	Cable Colour	Extension cable
15mm	Brown	45mm
20mm	Red	40mm
25mm	Green	35mm
30mm	Shield	30mm
35mm	White	25mm
40mm	Black	20mm
45mm	Blue	15mm

- 5) Bare each wire 2mm.

## Joining Cables

- 1) Tin each bare wire (including the shield wire).  
NB: Give the shield wire a twist to tighten the strands together before tinning.
- 2) Slide the glue heat shrink (100mm) over the cable attached to the load cell. Pushing it clear of the wires to be joined.
- 3) Lightly grip the top 100mm of the cable attached to the load cell in the small vice (**DO NOT** squash the outer sheath) leaving the coloured wires pointing approx 30 degrees upwards.
- 4) Slide a piece of 1/16 inch heat shrink over each of the coloured wires.
- 5) Solder each like coloured wire together (including shield wire) overlapping the bare wires as per drawing WIRE\Wirejoin.
- 6) Clean solder joints with Flux Cleaner and let dry.

## Inspection.

- 1) Check each solder joint for:  
Solder spikes, Wire strands sticking out and General poor joints.  
(Prevent splitting of heat shrink, shorting of wires etc..)

## Heat shrink

- 1) Slide 1/16 inch heat shrink over joins as per drawing WIRE\Wirejoin and use the heat gun to shrink down to size.
- 2) Slide 9mm heat shrink over the joins as per drawing WIRE\Wirejoin and use the heat gun to shrink down to size.

**Note:** *Ensure that glue melts and runs correctly. When finished the glue should be coming out each end and around the circumference of the outer sheath.*



# TN 11.884 Load Cell Cable Joining

Technical Support

