

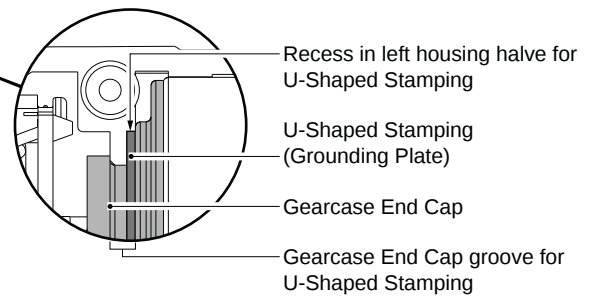
- MILWAUKEE ELECTRIC TOOL CORPORATION**  
13135 W. Lisbon Road, Brookfield, WI 53005  
Drwg. 2

For ease of removal and installation of the High Voltage protection system, it may be necessary to remove the electronic/gearcase assemblies from the left housing halve.

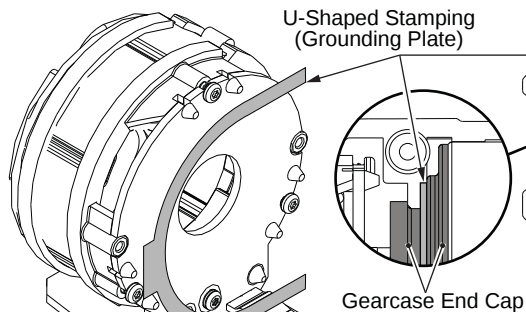
Trim any excess wire stranding. Use a minimal amount of solder.

Slide heat shrink tubing over soldered area and shrink with heat gun.

There may be heat shrink tubing present on the existing negative battery terminal that must be carefully trimmed away prior to soldering on the HV wire. Use a thin piece of electrical tape after soldering.



1. Place wire through hole on small tab of U-Shaped Stamping. Twist metal strands to temporarily hold wire to stamping. Trim any excess wire stranding. Be sure to position wire straight down at the 6:00 position. Secure wire to stamping with a minimal amount of solder to the strands. **NOTE:** Use just enough solder to hold the High Voltage wire in place. **Excessive solder can directly affect the positioning of the top housing halve!**
2. Feed heat shrink tubing over wire and slide up over soldered tab. Use a heat gun to heat tubing to tighten/shrink around the soldered tab.
3. Position the HV wire to the left side, behind the PCBA and behind the fwd./rev. shuttle.
4. Place U-Shaped Stamping onto groove of gearcase end cap with small tab/wire positioned at the bottom. Be sure the U-Shaped Stamping is properly seated in the recess of the left housing halve. (See detail above).
5. Take loose end of kit wire and place metal wire strands onto negative terminal of battery terminal block (front right side with black wire attached to it). **NOTE:** Heat shrink tubing may have to be carefully removed. Secure that end with a minimal amount of solder. Use a small piece of electrical tape to wrap around the black negative wire and the black HV wire.
6. Press all electronic components in place and route all wires in left housing halve according to wiring diagram. Be sure all mechanical and electrical components are firmly seated. Be sure all wires are pressed firmly down in traps. Be sure that fwd./rev. shuttle and spring are reinstalled and function properly.
7. Carefully install Right Housing Halve being sure that there are no interferences. Secure with existing screws.



**NOTE:** This view is shown without gearcase and housing halve for clarity of HV wire routing. Be sure U-Shaped Stamping is placed over the gearcase end cap and against the recess in the left housing halve. (See the detail above).

Route High Voltage Wire to the left side of the PCBA and behind the fwd/rev shuttle. Be sure that the wire does not interfere with the movement of the shuttle.

Solder the High Voltage Wire to negative terminal of battery connector block (along with black wire from switch). **Note:** Heat shrink tubing will have to be carefully trimmed away prior to soldering. After wire is soldered, wrap a thin piece of electrical tape around the two wires and terminal.

● = WIRE TRAPS or GUIDES

