



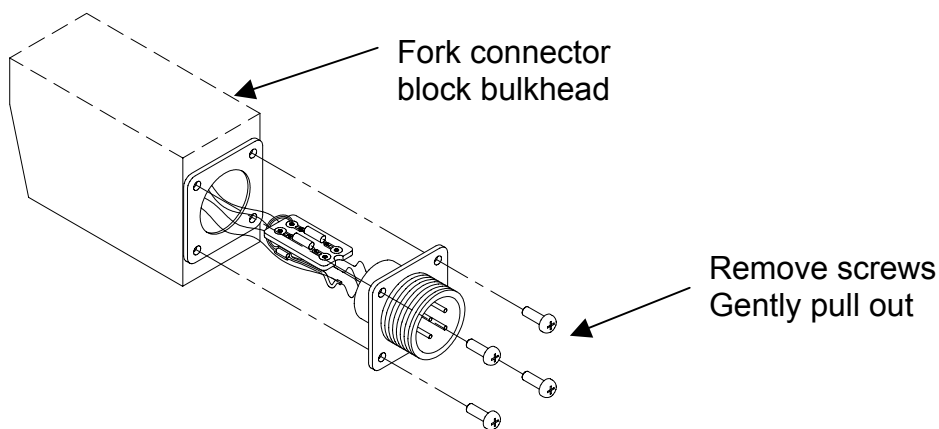
TECHNICAL BULLETIN

1-800-237-0022

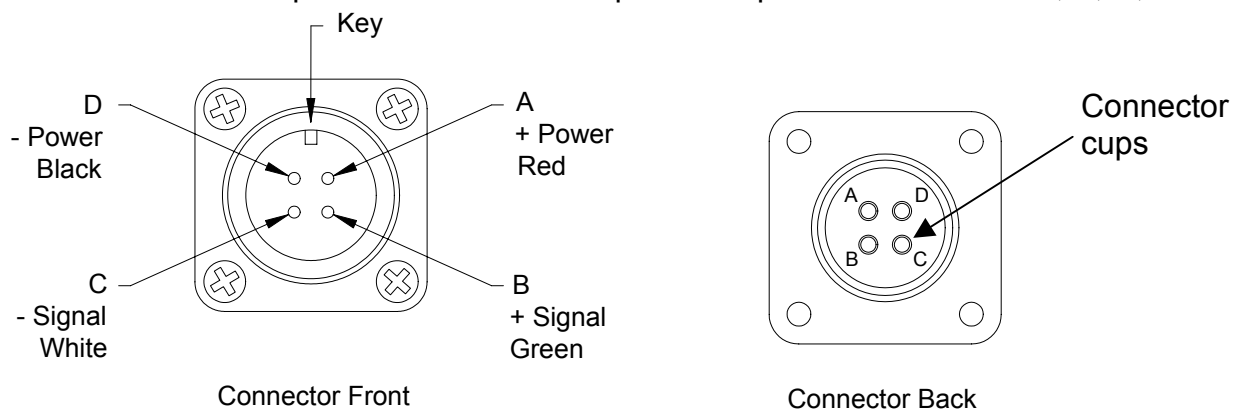
FORK CONNECTOR REPLACEMENT

PART NO. 59-30050-001

- Remove the four 4-40 screws that hold the connector in place.
- Gently pull the connector away from the housing. There is 2-3 inches of extra wire inside to allow for connector removal.



- Trim away the sealant from the 4 pins that are soldered into the connector. Use tweezers as required. Keep the small circuit board and any resistors intact.
- Once cleaned, use a solder gun to remove the pins from the connector cups. Keep track of what pin came from what cup. The cups are identified as A, B, C, D.



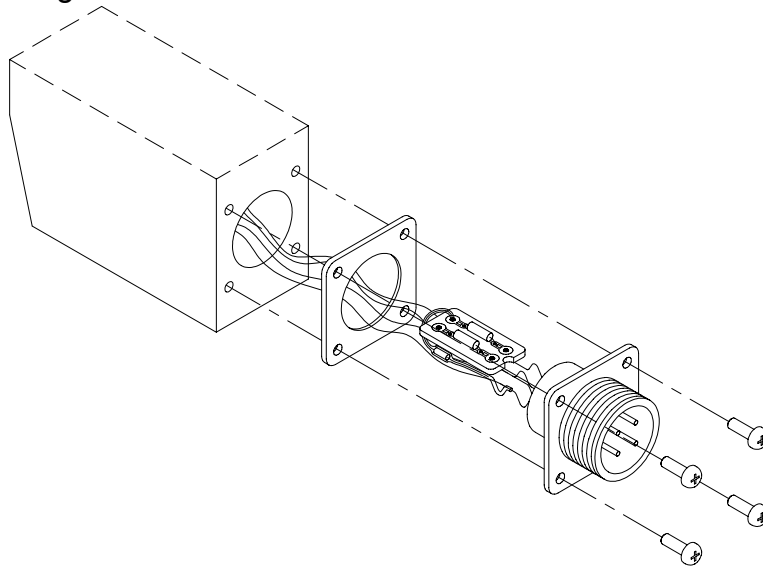
- Clean all four pins. Apply new heat shrink on the green and white wires if the existing heat shrink was damaged. Cut shrink to size as required. Fill each of the connector solder cups with solder. Solder each connection wire into the new connector's solder cups in the correct cup location.



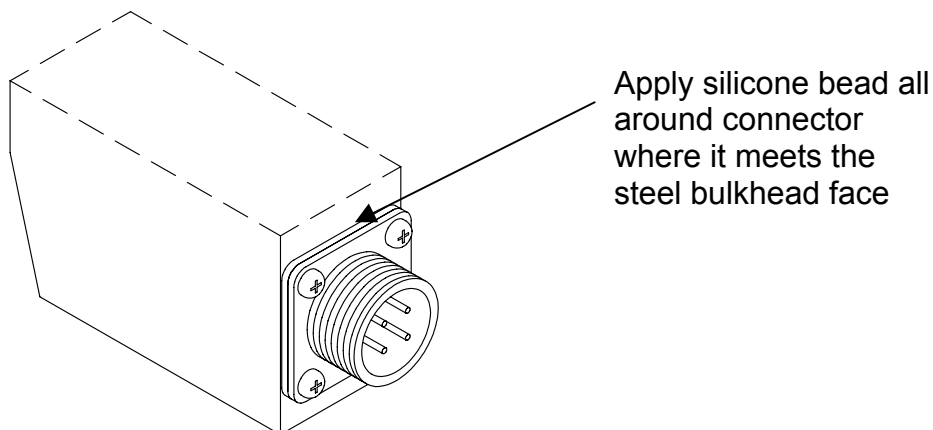
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- If new heat shrink was applied, use heat gun to shrink the tubing.
- Coat all the new solder joints, connector cups and connector back area with silicone sealant.
- Clean steel bulkhead face where connector gasket will seat.
- Remove enough sealant from inside the bulkhead housing so the assembly fits back in easily. To much insertion force will bend the pins.
- Apply a new gasket and push the connector back in the housing and secure in place with four mounting screws.



- Apply a silicone bead to the perimeter of the new connector. Let dry completely.



- When completely dry, put red cap over the connector to protect threads and spray with a rubberized undercoating (3M, Universal Rubberized Undercoating, 3M p/n: 8883).