











Manufacturing Work Instruction



Part Name: Remote Starter	Part Number : 511-7800	Part Picture 
Revision:	Last Revision Date: 3/17/2009	
Tools and Equipment :		
Multimeter, Terminal crimper, Soldering Iron , Solder, heat gun, super glue, channel lock pliers and wire tie gun.		

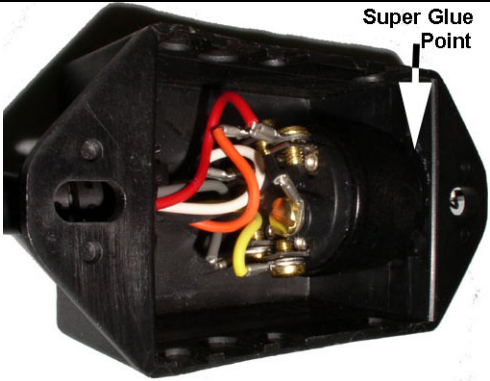




Required Parts

Seq.	Qty	Part Number	Image	Description
1	6	CON-0024		#8 Ring Terminal
2	6	FAS-0147		#8 Internal Star Washer SS
3	1	EME-0007		Keyswitch
4	1	HWP-0025		Gasket
5	1	MET-0073		Metal Plate
6	1	HWP-0047		Strain Relief
7	3	HWP-0040		6" Wire Tie

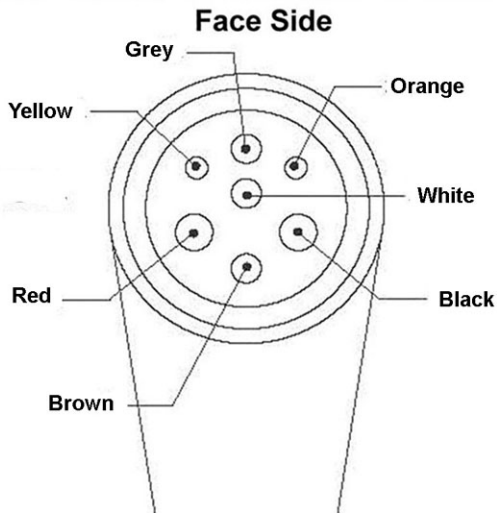
8	1	PLA-0143		Pre-Drilled Box
9	1	PAS-7800		

Assembly Instructions

Seq.	Image	Instruction														
1		<div>1. Even the wires on the end of the PAS-7800 harness.</div> <div>2. Strip approximately 3/16” of insulation from all of the wires except the brown wire.</div> <div>3. Crimp and solder the #8 ring terminals on the ends of all the wires except the brown wire.</div>														
2		<div>4. Install the strain relief in the small hole located in the end of the case.</div> <div>5. Route the wires thru the strain relief until there is at least 2 inches of wire inside the case.</div> <div>6. Secure the wires inside the case by using a wire tie around the wires next to the strain relief.</div>														
3		<div>7. Connect the ring terminals the keyswitch using the brass screws provided with the keyswitch. Use a SS #8 Internal Star Washer between the ring terminal and the tab on the keyswitch. Use the connection key below.</div> <table><tr><th>Terminal</th><th>Wire Color</th></tr><tr><td>A</td><td>White</td></tr><tr><td>B</td><td>Red</td></tr><tr><td>C</td><td>Grey</td></tr><tr><td>S</td><td>Yellow</td></tr><tr><td>M</td><td>Black</td></tr><tr><td>M</td><td>Orange</td></tr></table>	Terminal	Wire Color	A	White	B	Red	C	Grey	S	Yellow	M	Black	M	Orange
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4		<p>8. Cut the Brown wire off approximately 1" from the wire tie.</p> <p>9. Place a piece of 3/16" heat shrink over the Brown wire and shrink it down.</p>
5		<p>10. Turn the key in the keyswitch counter-clockwise and remove the key from the keyswitch.</p> <p>11. Remove the hex nut from the keyswitch.</p> <p>12. Slide the keyswitch thru the large hole in the case.</p> <p>13. Install the hex nut on the outside and rotate the keyswitch so that the keyswitch is straight up and down.</p> <p>14. Tighten the hex nut.</p> <p>15. Turn the case over and place 1-2 drops of super glue on the contact area where the keyswitch touches the case on the inside.</p>
6		<p>16. Remove the protection cover from one side of the gasket and place it on the metal plate. Take care to center the gasket as you place it on the plate. If you loosen one corner of the cover from the remaining side before it is placed on the plate, it will be easier to remove.</p>
7		<p>17. Remove the protection cover from remaining side of the gasket and place the plate on the case. Be sure to center the plate on the case.</p> <p>18. Secure the plate to the case with a wire tie in each end.</p>
8		<p>19. Place the Part Label on the top side, centered side to side and top to bottom.</p>
9		<p>20. Finished. Ready for testing.</p>

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21. With the keyswitch in the off position, you should read a short between the Black and the Orange wires. No connection to any other terminal.
22. With the keyswitch in the on position, you should read a short between the Red and the White wires. No connection to any other terminal.
23. With the keyswitch in the Start position, you should read a short between the Red, White and the Yellow wires. No connection to any other terminal.
24. With the keyswitch in the on position, push in on the key for the Choke position. You should read a short between the Red, Grey and the White wires. No connection to any other terminal.

25. Done, ready for packaging.

