

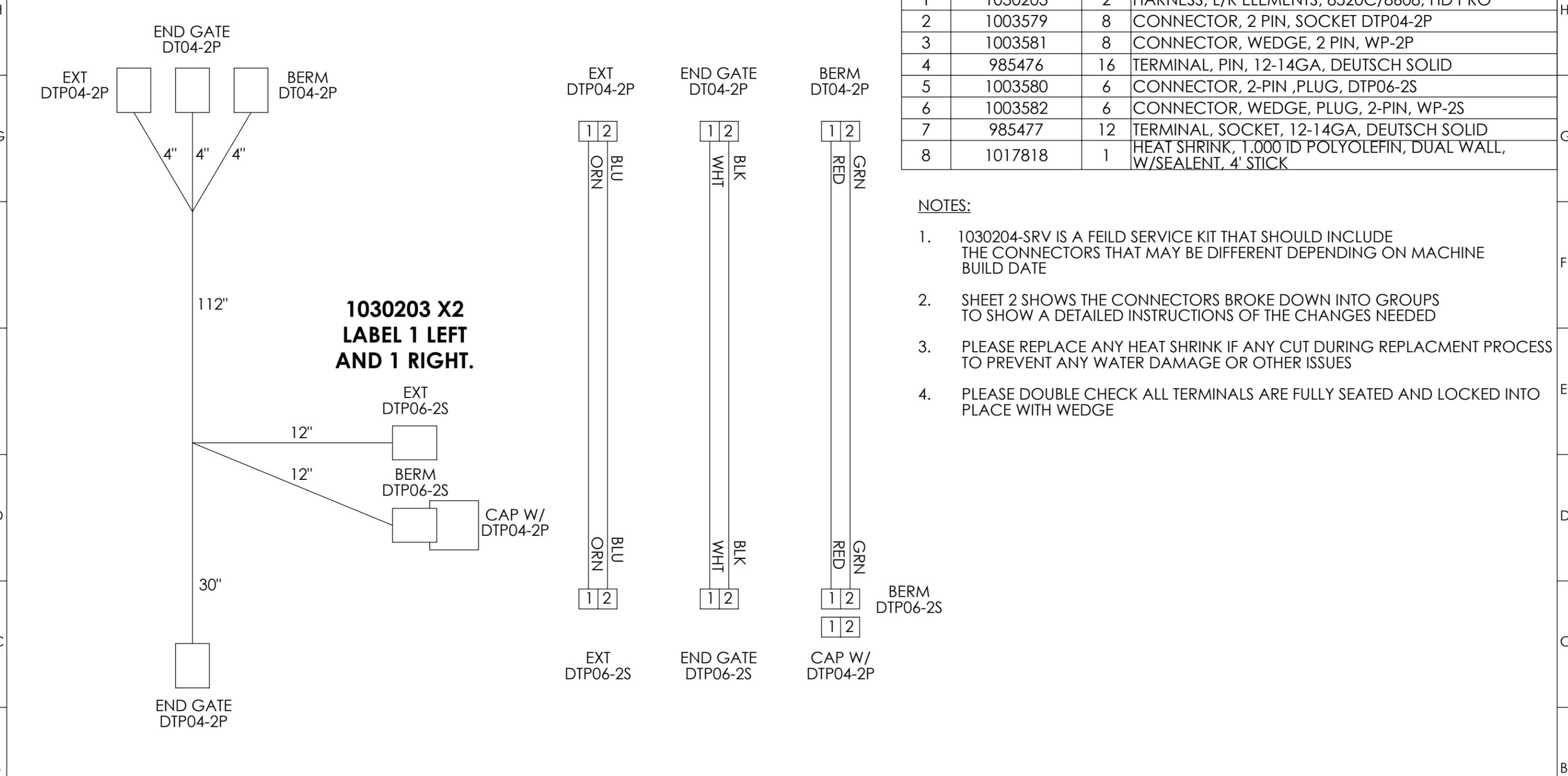
REVISIONS					
ECN	REV	DESCRIPTION	ZONE	BY	DATE
31677	A	NEW RELEASE		CJ	3/17/2025

ITEM NO.	PART NUMBER	QTY	DESCRIPTION
1	1030203	2	HARNESS, L/R ELEMENTS, 8520C/8608, HD PRO
2	1003579	8	CONNECTOR, 2 PIN, SOCKET DTP04-2P
3	1003581	8	CONNECTOR, WEDGE, 2 PIN, WP-2P
4	985476	16	TERMINAL, PIN, 12-14GA, DEUTSCH SOLID
5	1003580	6	CONNECTOR, 2-PIN ,PLUG, DTP06-2S
6	1003582	6	CONNECTOR, WEDGE, PLUG, 2-PIN, WP-2S
7	985477	12	TERMINAL, SOCKET, 12-14GA, DEUTSCH SOLID
8	1017818	1	HEAT SHRINK, 1.000 ID POLYOLEFIN, DUAL WALL, W/SEALANT, 4' STICK

NOTES:

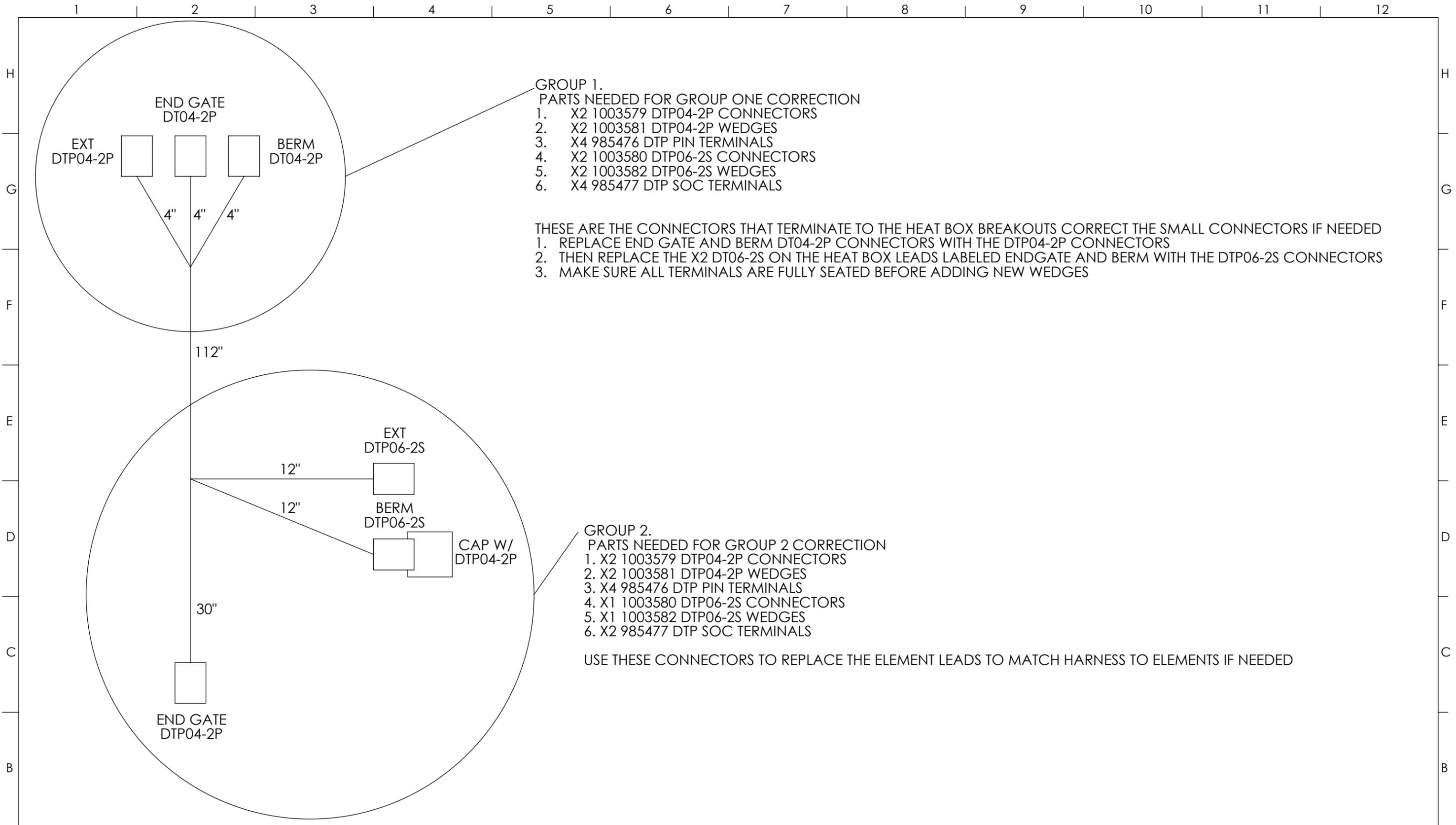
- 1030204-SRV IS A FEILD SERVICE KIT THAT SHOULD INCLUDE THE CONNECTORS THAT MAY BE DIFFERENT DEPENDING ON MACHINE BUILD DATE
- SHEET 2 SHOWS THE CONNECTORS BROKE DOWN INTO GROUPS TO SHOW A DETAILED INSTRUCTIONS OF THE CHANGES NEEDED
- PLEASE REPLACE ANY HEAT SHRINK IF ANY CUT DURING REPLACMENT PROCESS TO PREVENT ANY WATER DAMAGE OR OTHER ISSUES
- PLEASE DOUBLE CHECK ALL TERMINALS ARE FULLY SEATED AND LOCKED INTO PLACE WITH WEDGE

**1030203 X2
LABEL 1 LEFT
AND 1 RIGHT.**



**MANUFACTURE HARNESS IAW PER
LEEBOY ELECTRICAL STANDARD 1013676**

<p>GENERAL FABRICATION TOLERANCE - INCH</p> <table border="1"> <tr> <td>></td> <td>0.000</td> <td>3.000</td> <td>12.000</td> <td>24.000</td> <td>48.000</td> <td>96.000</td> <td>120.000</td> <td>240.000</td> <td>0.000</td> <td>1.000</td> <td>3.000</td> <td>6.000</td> <td>12.000</td> <td>36.000</td> </tr> <tr> <td>≤</td> <td>3.000</td> <td>12.000</td> <td>24.000</td> <td>48.000</td> <td>96.000</td> <td>120.000</td> <td>240.000</td> <td>~</td> <td>1.000</td> <td>3.000</td> <td>6.000</td> <td>12.000</td> <td>36.000</td> <td>~</td> </tr> <tr> <td>±</td> <td>0.015</td> <td>0.031</td> <td>0.063</td> <td>0.094</td> <td>0.125</td> <td>0.188</td> <td>0.250</td> <td>0.500</td> <td>0.005</td> <td>0.010</td> <td>0.015</td> <td>0.031</td> <td>0.063</td> <td>0.094</td> </tr> </table>														>	0.000	3.000	12.000	24.000	48.000	96.000	120.000	240.000	0.000	1.000	3.000	6.000	12.000	36.000	≤	3.000	12.000	24.000	48.000	96.000	120.000	240.000	~	1.000	3.000	6.000	12.000	36.000	~	±	0.015	0.031	0.063	0.094	0.125	0.188	0.250	0.500	0.005	0.010	0.015	0.031	0.063	0.094	<p>SURFACE: 250</p>		<p>GENERAL MACHINING TOLERANCE</p>				<p>SURFACE: 125</p>		<p>DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED</p>		<p>APPROVALS</p>		<p>DATE</p>		<p>1030204-SRV</p>	
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<p>REFER TO TABLES FOR GENERAL TOLERANCES</p>														<p>ST ENGINEERING LEEBOY, dba LEEBOY</p>		<p>500 LINCOLN COUNTY PARKWAY EXT</p>		<p>INFORMATION CONTAINED ON THIS DRAWING IS THE SOLE PROPERTY OF LEEBOY. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF LEEBOY IS PROHIBITED</p>		<p>REV</p>																																																						
<p>ANGLE</p>														<p>±0.5°</p>		<p>±1.0°</p>		<p>±2.0°</p>		<p>±3.0°</p>		<p>±0.1°</p>		<p>±0.3°</p>		<p>±0.5°</p>		<p>SHEET SCALE: 1:2</p>		<p>THIRD ANGLE PROJECTION</p>		<p>SHT SIZE: B</p>		<p>SHT 1 OF 2</p>		<p>PART WEIGHT: 0.88 LBS</p>		<p>A</p>																																				



- GROUP 1.**
PARTS NEEDED FOR GROUP ONE CORRECTION
1. X2 1003579 DTP04-2P CONNECTORS
 2. X2 1003581 DTP04-2P WEDGES
 3. X4 985476 DTP PIN TERMINALS
 4. X2 1003580 DTP06-2S CONNECTORS
 5. X2 1003582 DTP06-2S WEDGES
 6. X4 985477 DTP SOC TERMINALS

THESE ARE THE CONNECTORS THAT TERMINATE TO THE HEAT BOX BREAKOUTS CORRECT THE SMALL CONNECTORS IF NEEDED

1. REPLACE END GATE AND BERM DT04-2P CONNECTORS WITH THE DTP04-2P CONNECTORS
2. THEN REPLACE THE X2 DT06-2S ON THE HEAT BOX LEADS LABELED ENDGATE AND BERM WITH THE DTP06-2S CONNECTORS
3. MAKE SURE ALL TERMINALS ARE FULLY SEATED BEFORE ADDING NEW WEDGES

- GROUP 2.**
PARTS NEEDED FOR GROUP 2 CORRECTION
1. X2 1003579 DTP04-2P CONNECTORS
 2. X2 1003581 DTP04-2P WEDGES
 3. X4 985476 DTP PIN TERMINALS
 4. X1 1003580 DTP06-2S CONNECTORS
 5. X1 1003582 DTP06-2S WEDGES
 6. X2 985477 DTP SOC TERMINALS

USE THESE CONNECTORS TO REPLACE THE ELEMENT LEADS TO MATCH HARNESS TO ELEMENTS IF NEEDED

<p>DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED</p> <p>DIMENSIONS APPLY TO FINISHED PART. ROUGH CUTS MUST INCLUDE APPROPRIATE STOCK ALLOWANCE FOR MACHINED PARTS.</p> <p>(REFERENCE DIMENSIONS)</p> <p>REFER TO TABLES FOR GENERAL TOLERANCES</p>													<p>APPROVALS</p> <p>DRAWN BY: CJL</p> <p>CHECKED BY: TWJ</p>		<p>DATE</p> <p>03/04/2025</p> <p>04/01/2025</p>		<p>1030204-SRV</p> <p>KIT, 1030204 HARNESS REPLACEMENT</p>																																															
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