

Positive Isolation Solenoid Link

ZG.20352-01GB Specification Document

Version 1.1

Internal Part Number: ZG.20352-01GB

External Part Number: ZG.20352-01GB

Date: 04/08/2025

Overview

This document specifies the requirements and assembly instructions for the Heavy Duty Double Insulated Ring Terminal Splitter Assembly (ZG.20352-01GB) designed by MAN-TBUK. This assembly ensures reliable electrical connectivity with robust insulation



QTY	Description	M/F - P/N	
520mm	Red Wire – 1.5mm ² Thin Wall (Max Current Rating 21 Amps)	TW1.5R.500	
x1	M10 Ring – CR2-10 – Heavy Duty	TE 160038	
x2	M4 Ring – CR1-4	TE 32185	
492mm	Red Adhesive Lined Heat Shrink - Flame Retardant, Self-extinguishing	ESB4.8 RED	
60mm	Black Adhesive Lined Heat Shrink - Flame Retardant, Self-extinguishing	ATUM-6/2-0-STK	
X1	Hellerman Small Label – Text – ZG.20xxx-01GB	596-09320 TAG9TD3-323-CL/WH	

Material Preparation**Wire Preparation**

- Cut two pieces of red wire (1.5 mm² Thin Wall) to 260 mm each.
- Strip one end of each wire to 10 mm and the opposite end to 6 mm.
- *Wire Machine Settings:*
 - *Strip Setting: 10/6/260/3/6/55/12*
 - *Speed Setting: 8/2/8*

Heat Shrink Preparation

- Cut two pieces of red adhesive-lined heat shrink to 246 mm each.
- Cut two pieces of black adhesive-lined heat shrink to 15 mm each.
- Cut one piece of black adhesive-lined heat shrink to 30 mm

Assembly

Step 1: Apply Red Heat Shrink

Slide one piece of red heat shrink (246 mm) over each red wire, ensuring the wire is in the centre.

Place the assembly in an oven and bake at 110°C for 3 minutes to secure the heat shrink.



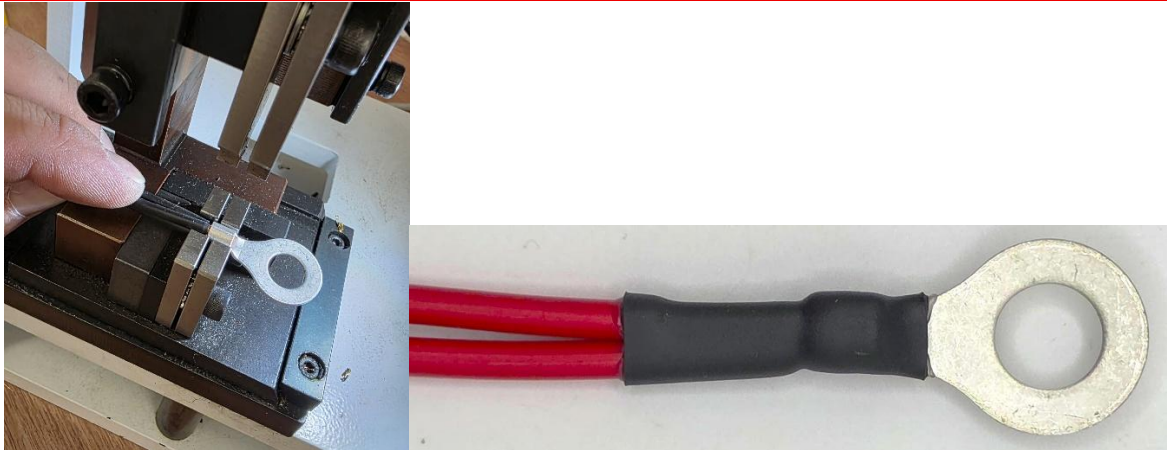
Step 2: Crimp M10 Ring Terminal

Slide the 30 mm black heat shrink over both wires, leaving 10 mm of insulation exposed.

Align the 10 mm stripped ends of both wires and crimp them together with the M10 ring terminal using a butt press machine.

Slide the black heat shrink over the crimped junction.

Use a hot air gun at 250°C to shrink the heat shrink securely.



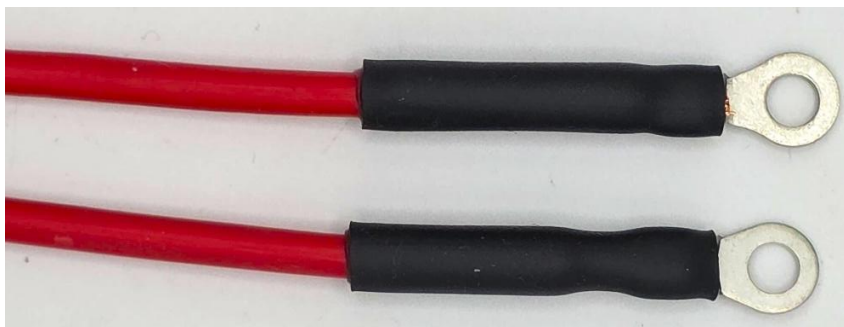
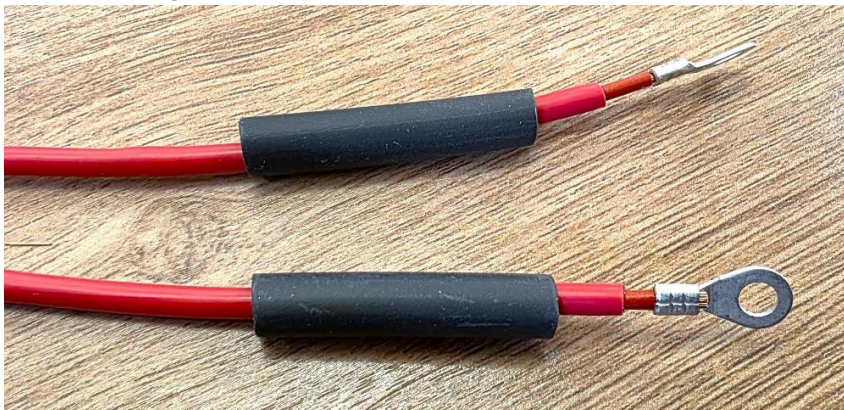
Step 3: Crimp M4 Ring Terminals

Slide one 15 mm black heat shrink over the 6 mm stripped end of each wire.

Crimp an M4 ring terminal onto each wire using the butt press machine.

Slide the black heat shrink over each crimped junction.

Use a hot air gun at 250°C to shrink the heat shrink securely.



Step 4: Apply Label

Attach the Hellerman label (Text: ZG.20xxx-01GB) to the middle of one wire.



Step 5: Final Inspection

Straighten the wires by running them through your fingers to remove creases.

Conduct a thorough visual and functional inspection to ensure compliance with specifications.



