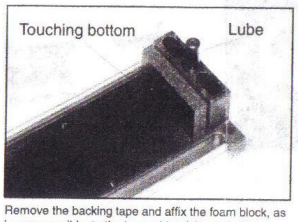
Speed Jig Patent Pending

deans

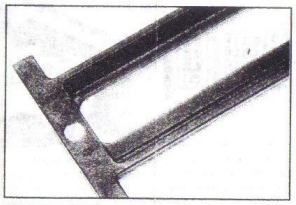
Assembly

Foam Block/Lube



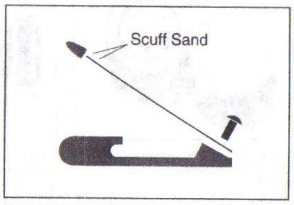
Remove the backing tape and affix the foam block, as low as possible, to the inner side of the main frame. **Lubricate the posts with a light coat of Vaseline,** this allows the plate to be removed much easier, and helps prevent breakage of the posts.

Foam Strips



Affix the two long foam strips to the underside of the top plate.

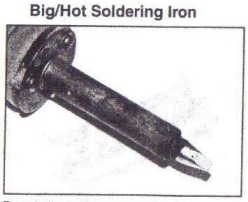
Clamp Assembly



First, for maximum glue adhesion, scuff with sandpaper the end of the flat spring **opposite the hole.** Place the plastic tip onto the end of the flat spring. Now put a drop of instant glue to secure it. With the curve of the spring facing up, attach the spring to the clamp with the 4/40 button head screw.

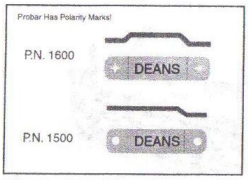
Needed:

Big/Hot Soldering Iron



Do not attempt to use a small or low powered soldering iron! You will need a 3/16 - 1/4" tip /40+ watt @ 700 - 800 degrees. A lower powered iron will need longer to complete the joint and will damage both the clamp and your very expensive new cells!

Bars



Different cells need different bars.

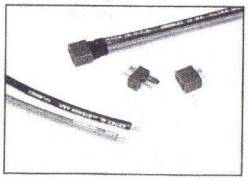
Probar 2.0 - R/C 2000 or 1700 Cells.

Deans Bar - SC, SCR or SCRC Cells.

Solder

Silver or Gold plating requires a special solder. Ordinary solder causes a chemical reaction which will degrade the joint. Deans Racing Solder is 2% silver with high activity ProFlux.

Plugs/Wire



Ultra Wire - High quality 12 Ga. 660 strands.

Wet Noodle - 12 Ga. 1600 strands, super flexable!

Ultra Plug - Lowest resistance available!

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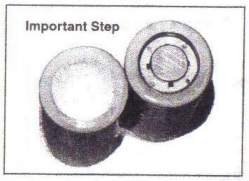
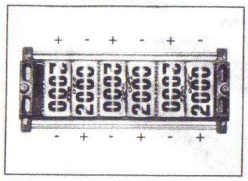
Use

Scuff Cells



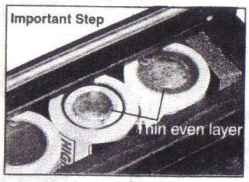
Lightly sand the surface on each end of the cells. This gives the solder maximum adhesion to the cell.

Insert Cells



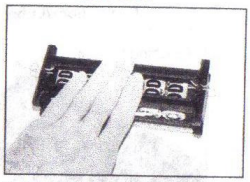
Place six cells into the frame, with the positive and negative ends (also the labels) alternating. Rotate the cells untill they look good, then install the top plate and secure with the clips.

Pre-Tin Cells



Pre-tin the cells with a very small amount of solder. Distribute it evenly, using a circular motion with the soldering iron.

Seat Cells



Seat the cells by pressing lightly on the center of the top plate.

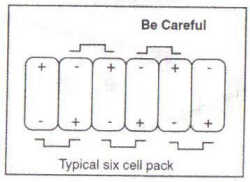
Warning

Do Not - Put a bar at both ends of the same pair of cells. This is a dead short and is very dangerous if the cells are charged.

Do Not - Remove the upper plate quickly or unevenly. The jig is molded from a hi-tech polymer which is very rigid. The posts cannot flex and will break.

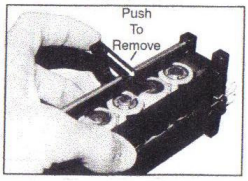
Do Not - Attempt to solder for longer than five seconds. Damage to both the cell and the clamp will result.

Bar Placement



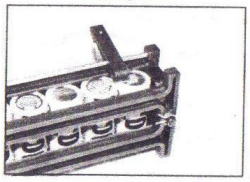
Bars will be installed as shown. **Do NOT put bars directly across from each other.** This is a dead short and the cells may **explode.**

Clamp Operation



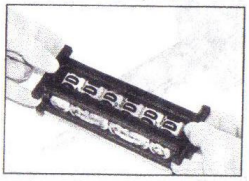
The clamp will snap into position. It may then be slid or removed and reclamped at the next location. To remove clamp press **forward** as shown.

Clamp Bar



Place the battery bar on the cell and clamp in place. Solder the bar in place, adding solder as needed. Each solder joint should be completed in 2 - 3 seconds.

Remove Top Plate



Remove the top plate using thumbs as shown. After removal from the jig, the pack can be glued w/shoe goo. Store the jig with the cells removed and the top plate in place.

Limited Warranty

This product has a 30 day limited warranty. Damage due to improper use will void this warranty. Proof of purchase date required.