



## Field Repair of Dead Battery

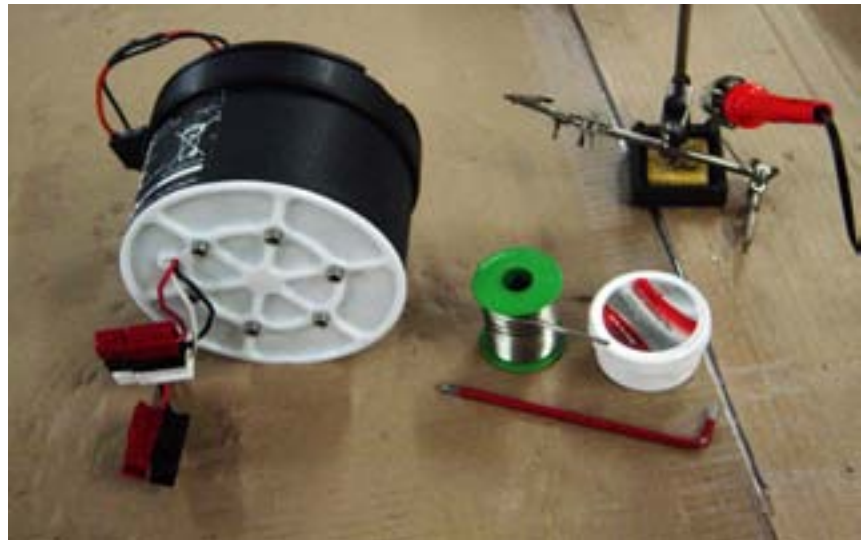
www.dive-xtras.com  
4433 Russell Rd, STE 106  
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**Problem:** Motor doesn't run. Test for voltage across the red and black connectors. If there is no voltage across the red and black connectors on either end, one of the welds holding the connecting tabs in place may be broken. These instructions show you how to repair this issue.

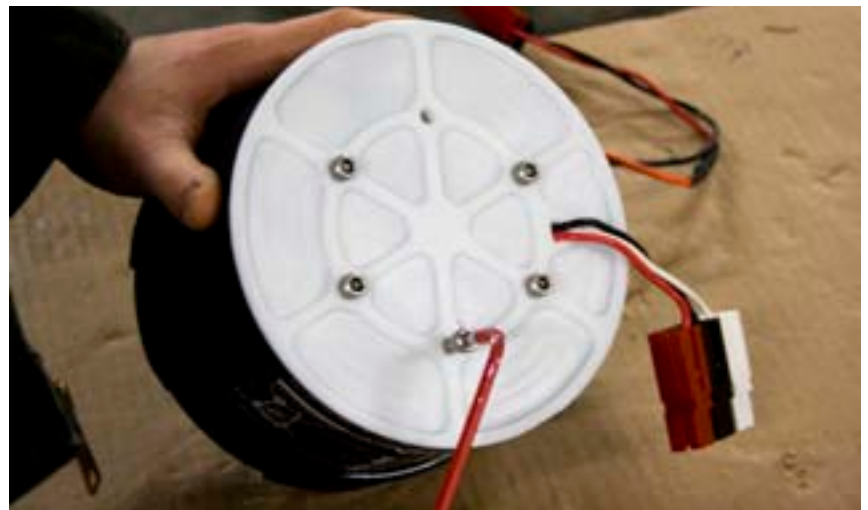
**Note:** It is recommended that you send your battery into Dive Xtras or Rabbit Tool. This technique is only recommended if you have no other options.

The tools needed for this repair are:

- 1 Soldering Iron (approx. 40W)  
*Do not use small Electronics Iron's*
- Soldering Flux
- Small Slotted Screw Driver
- Solder
- 3/16 Allen Wrench



Flip the battery inside down and unscrew all the bolts that are holding the bottom plate onto the battery casing.

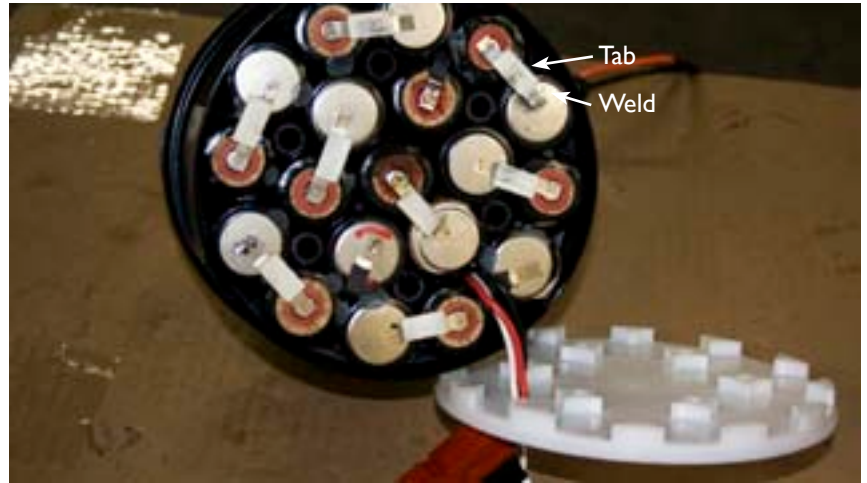




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Proceed to take off the bottom plate and let it hang off edge with the main wires still attached. See if you can spot the loose tab weld.



Gently take the screw driver and search for the loose tab by lifting up on where the tabs should be connected. Once the tab is found, carefully bend the tab up. It may be necessary to look on the other side of the cells. To remove the Battery top, loosen the nut on the cord Gland where the power wires enter the battery pack. Do not unscrew the body of the cord Gland as this will twist and damage the wires inside. Push the wires through the cord Gland enough to allow sufficient workspace.



Put a generous amount of Flux on both the tab and the battery terminal.





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Melt a large blob of solder onto the tab and let solidify.



To solder the tab back in place, first press the tab down using a screwdriver. Then melt the solder by pressing the iron down right where solder was applied to the tab. This will melt the solder and create the joint. As soon as the solder has melted remove the iron. The heat from the soldering iron is not good for the battery cells. If the solder does not fuse the tab and terminal together after 3-4 seconds remove iron, wait until the battery cell is cool to touch and try again.



After solder has melted, remove the iron while keeping pressure on the tab with the screw driver until solder has solidified. Check to make sure the tab is secure. If secure check to see if the battery now has voltage across terminals. If no, look for another broken tab. If yes, then reassemble battery.

