

80 SERIES CABLEJACK ASSEMBLY INSTRUCTIONS

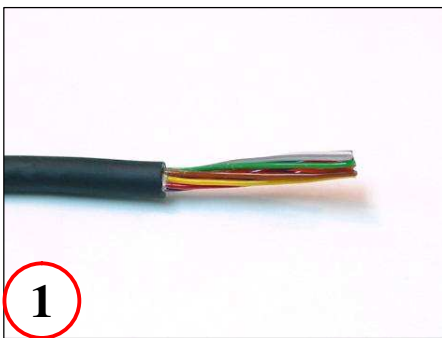
This product may be protected by one or more of the following US Patents.

5791942, 6217391, 6368159, 6419526, 6602097, 6877222

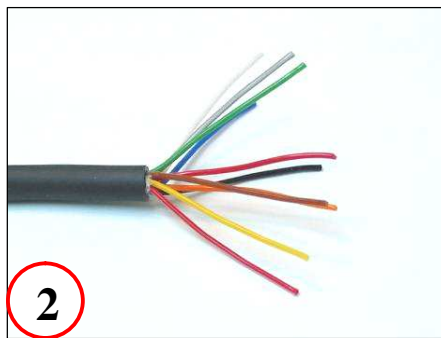
6964587, 7048590, 7086909, 7568950, 7686650

Assembly steps 1 – 11:

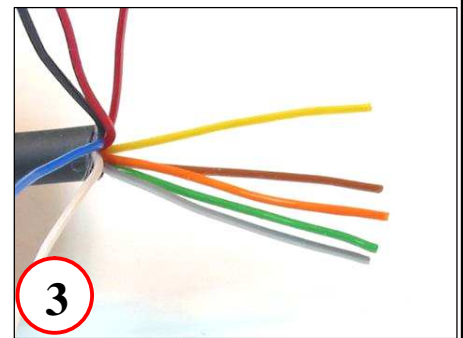
This document shows the assembly of a 10 position jack. Wire order and color may vary with application



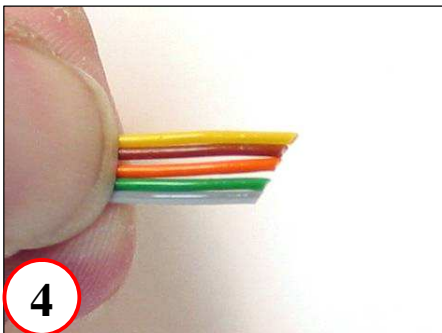
Strip off approximately 1 ¼ inch of cable jacket



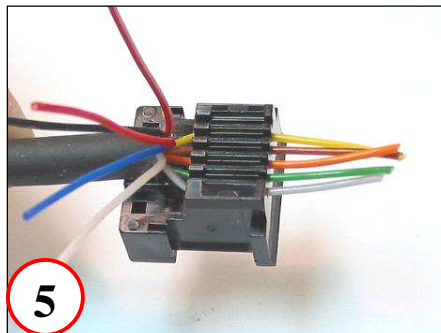
Spread apart wires, untwist pairs if necessary



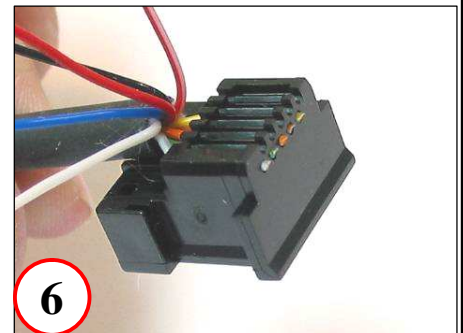
Align lower row conductors, fold upper conductors out of way



Trim lower row conductors @ < 45° angle



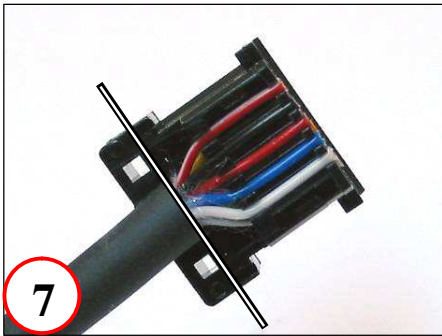
Place lower row conductors into load bar



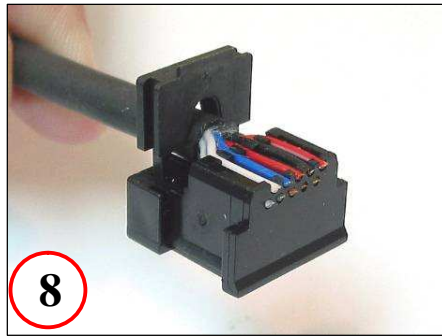
Trim lower row flush with front of load bar

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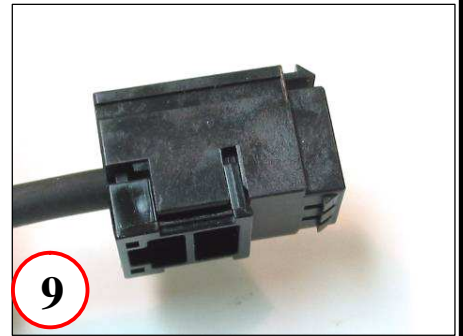
Assembly steps 1 – 11: (Cont.)



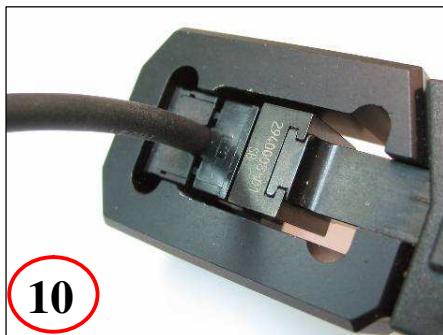
7 Snap upper row conductors into place. Cable jacket ends in front of square holes



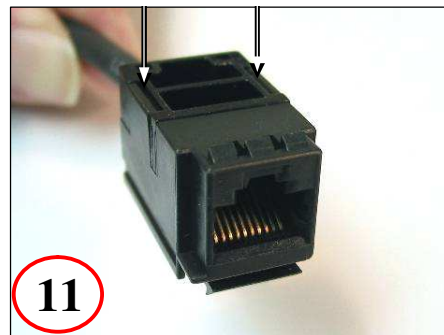
8 Place strain relief over cable



9 Place completed rear assembly into housing



10 Place jack into crimper tool and crimp



11 Assembly complete. Verify both sides are latched