

80 SERIES CABLEJACK ASSEMBLY INSTRUCTIONS

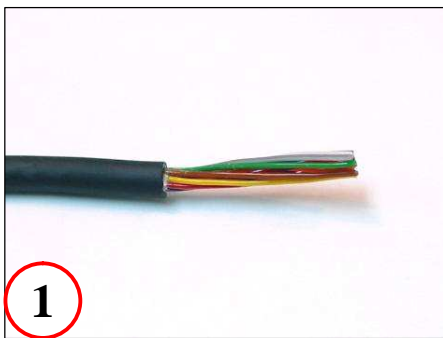
This product may be protected by one or more of the following US Patents.

5791942, 6217391, 6368159, 6419526, 6602097, 6877222

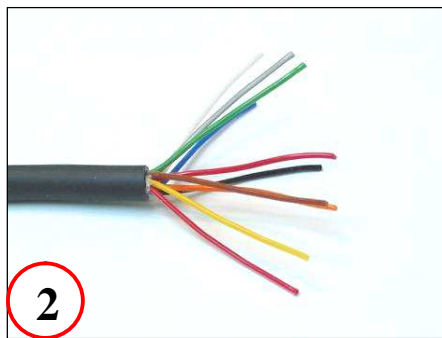
6964587, 7048590, 7086909, 7568950, 7686650

Assembly steps 1 – 11:

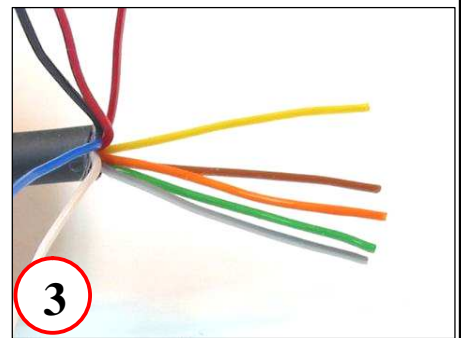
This document shows the assembly of a 10 position jack. Wire order and color may vary with application



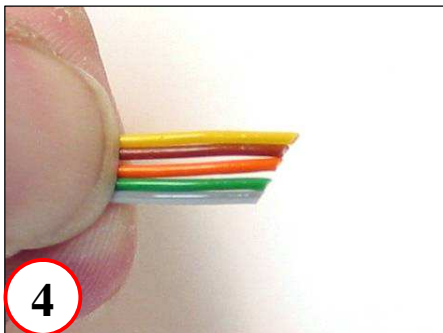
Strip off approximately 1 ¼ inch of cable jacket



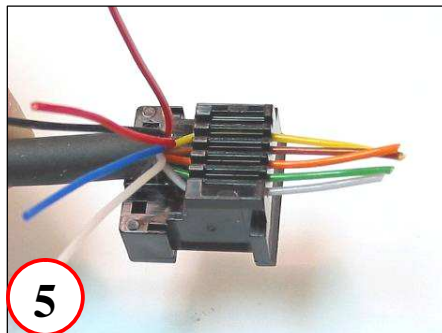
Spread apart wires, untwist pairs if necessary



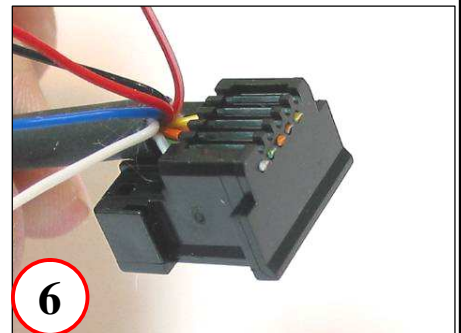
Align lower row conductors, fold upper conductors out of way



Trim lower row conductors @ <math>< 45^\circ</math> angle



Place lower row conductors into load bar



Trim lower row flush with front of load bar

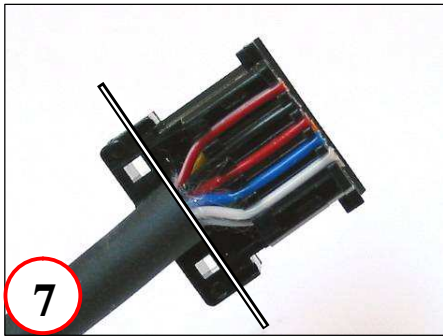
Stewart Connector

80 SERIES UNSHIELDED CABLEJACK
ASSEMBLY INSTRUCTIONS

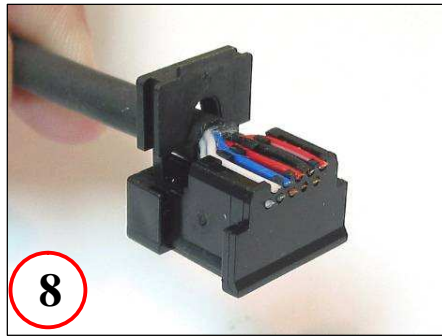
11118 Susquehanna Trail South Glen Rock, PA 17327

80 SERIES CABLEJACK ASSEMBLY INSTRUCTIONS

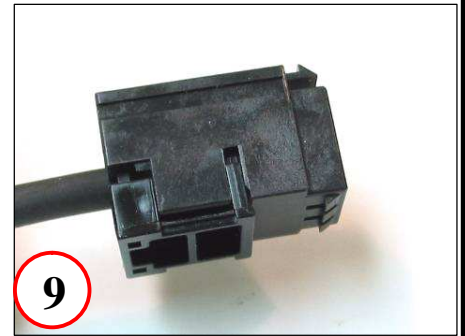
Assembly steps 1 – 11: (Cont.)



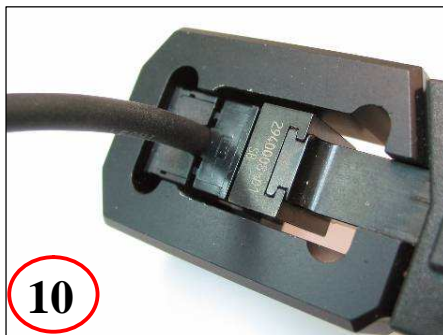
7
Snap upper row conductors into place. Cable jacket ends in front of square holes



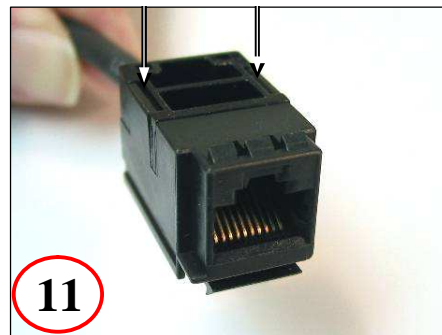
8
Place strain relief over cable



9
Place completed rear assembly into housing



10
Place jack into crimper tool and crimp



11
Assembly complete. Verify both sides are latched