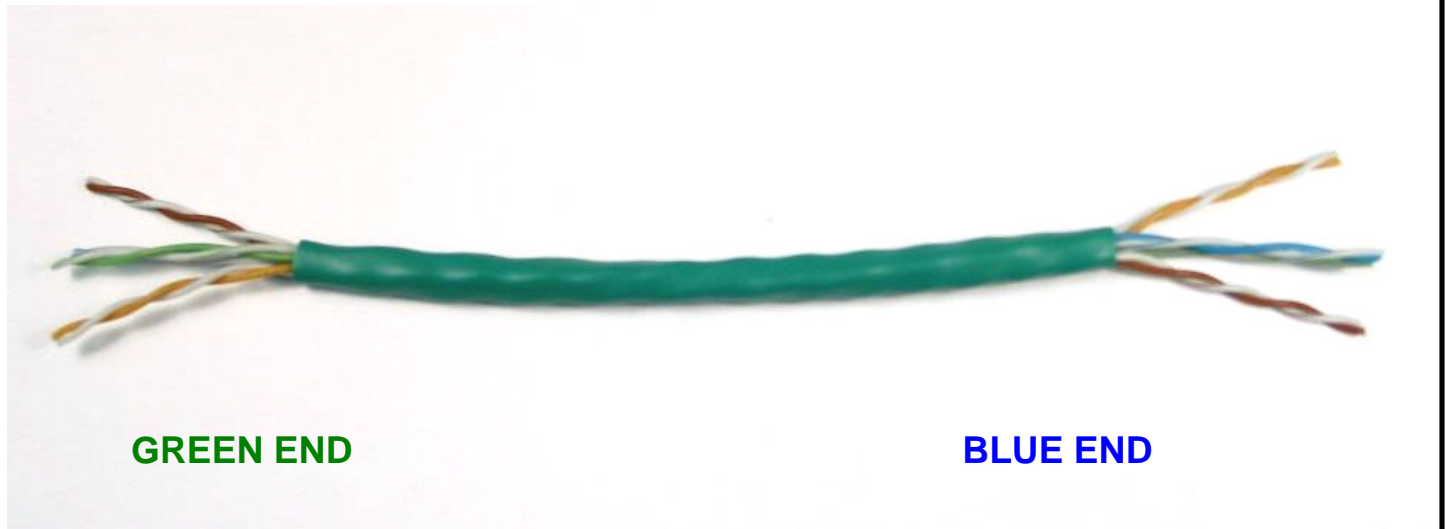


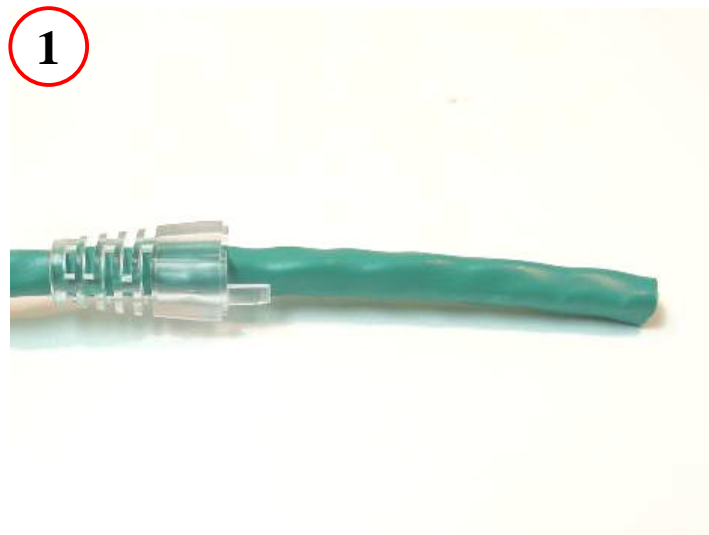
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39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS



One end of cable has **Green** on top, other end has **Blue** on top. **Green** end steps will be shown on left, **Blue** steps shown on right. Common steps will be in the middle.



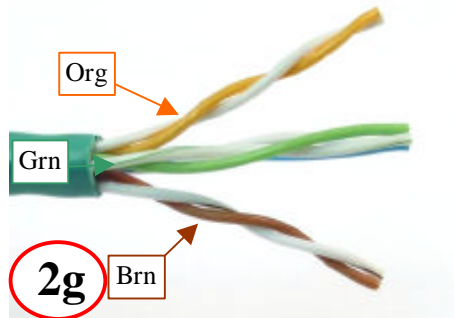
Slide Strain Relief onto cable

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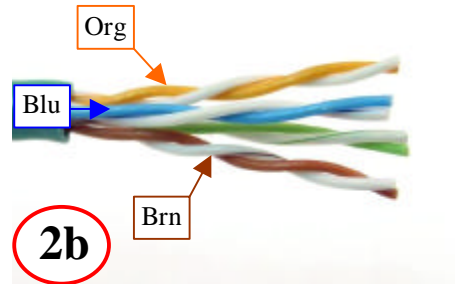
39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS

GREEN

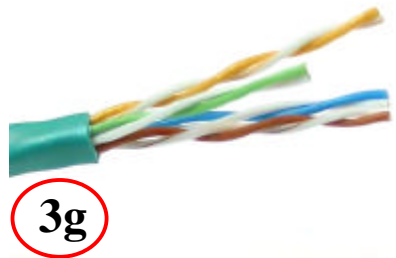


Strip off approximately 1 ¼ inch of cable jacket

BLUE



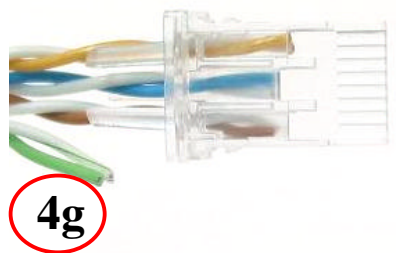
Strip off approximately 1 ¼ inch of cable jacket



Separate Grn pair and trim ¼" off end



Separate Blu pair and trim ¼" off end



First insert Org, Blu, Brn pairs into lower row of load bar, then insert Grn into upper row



First insert Org, Grn, Brn pairs into lower row of load bar, then insert Blu into upper row

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39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS

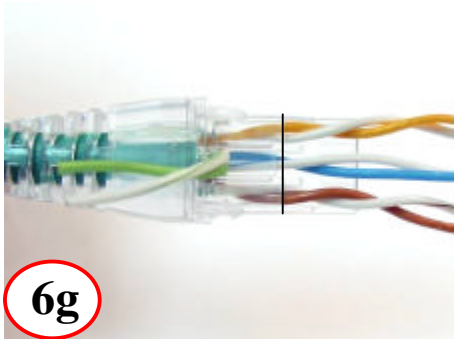


5

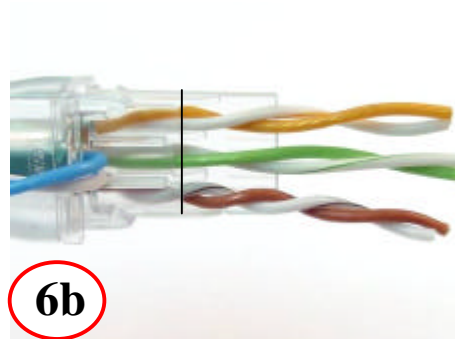
Latch strain relief onto load bar

GREEN

BLUE

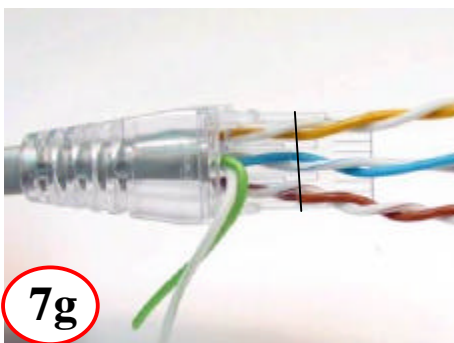


6g

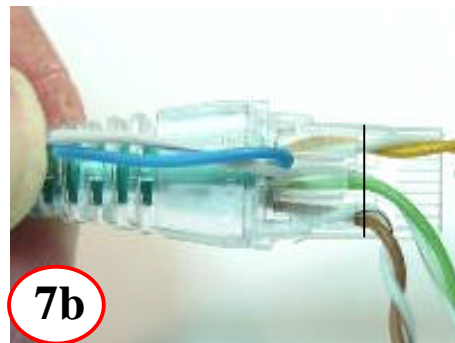


6b

Check wire alignment – here, Org is aligned wrong, needs $\frac{1}{2}$ twist



7g



7b

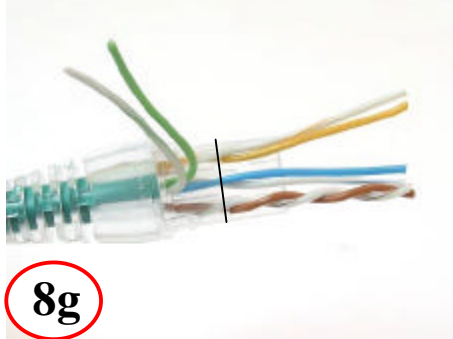
Add $\frac{1}{2}$ twist so Org pair is aligned correctly –
PAIRS MUST HAVE $\frac{1}{2}$ to 1 TWIST ONLY

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39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS

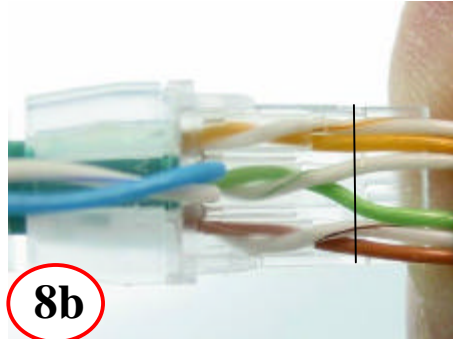
GREEN



8g

Untwist lower three pairs back to ends of side walls

BLUE



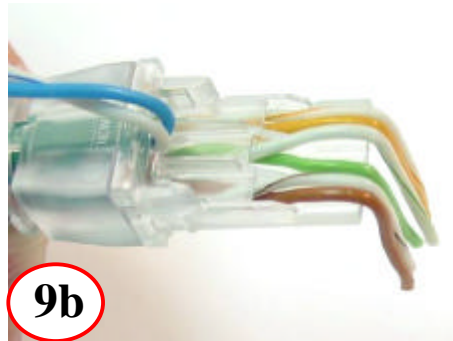
8b

Untwist lower three pairs back to ends of side walls. Spread Grn pair

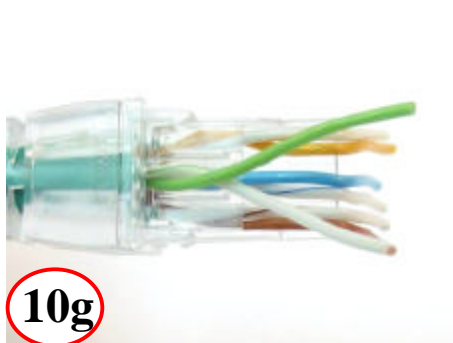


9g

Bend lower pairs back at @90° angle

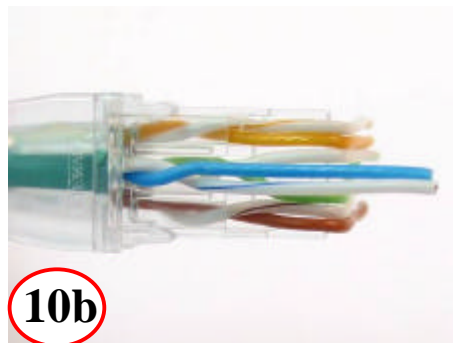


9b



10g

Check Grn pair for alignment
Add ½ twist if necessary



10b

Check Blu pair for alignment
Add ½ twist if necessary

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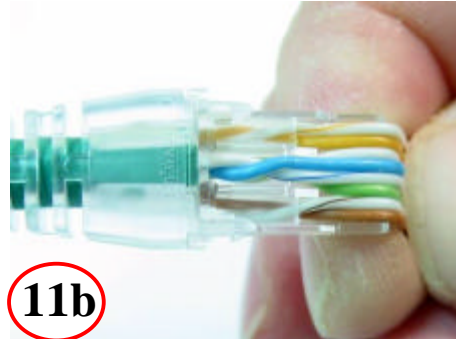
39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS

GREEN

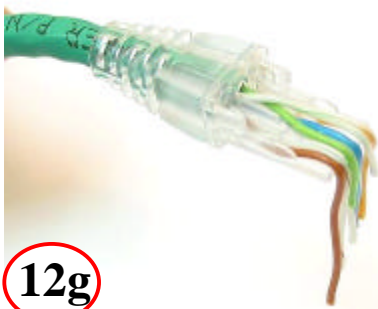


Form Grn pair so it fits around Blu pair

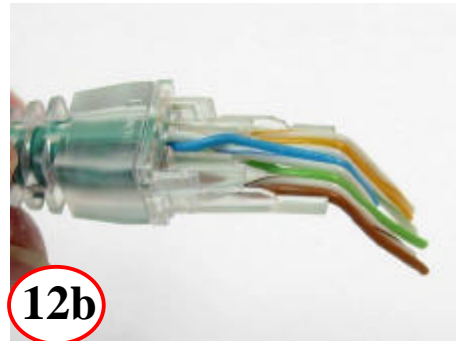
BLUE



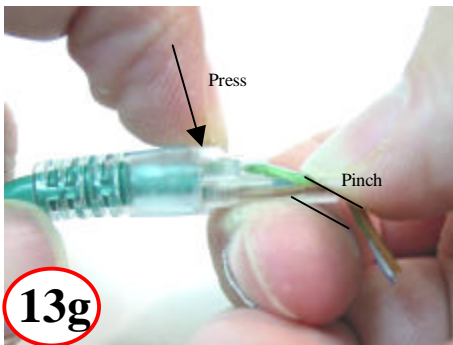
Fit Blu pair inside Grn pair



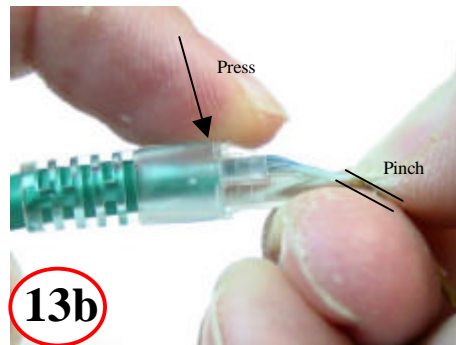
Place Grn pair and bend back @ 90° like lower pairs



Bend Blu pair back @ 90° like lower pairs



Pinch load bar end, then press on back to set wires in place



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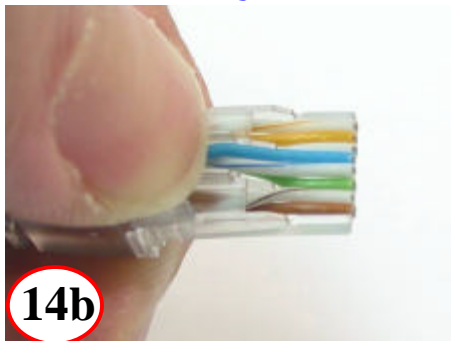
39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS

GREEN



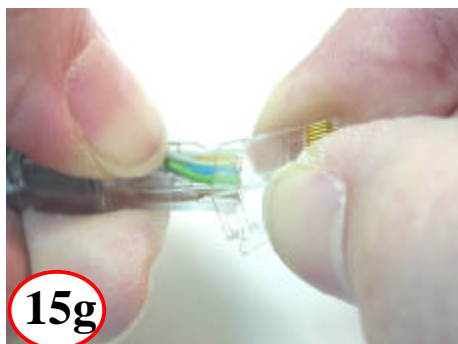
14g

BLUE

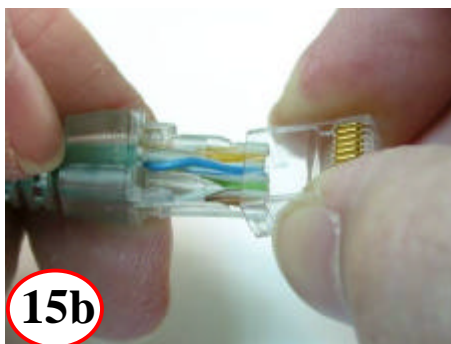


14b

Trim wire ends flush with end of load bar



15g

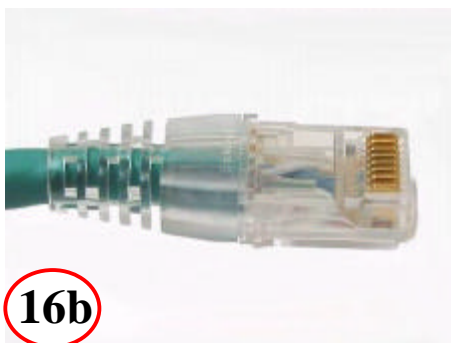


15b

Place load bar assembly into housing



16g



16b

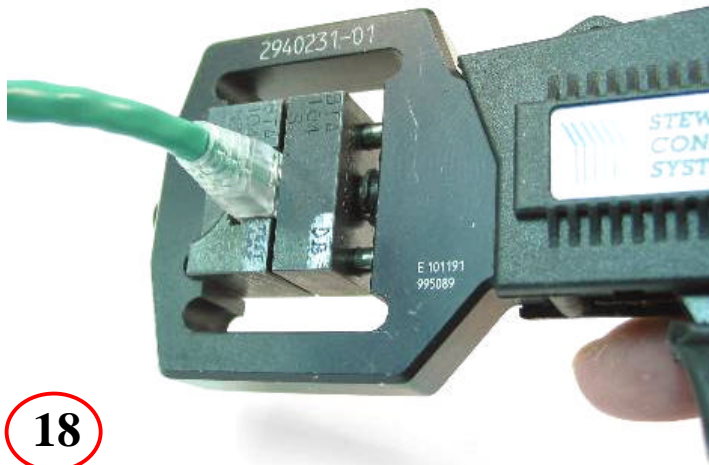
Snap housing and load bar assembly together

39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS



17

Verify that wires went all the way to front of housing



18

Crimp contacts. Assembly complete