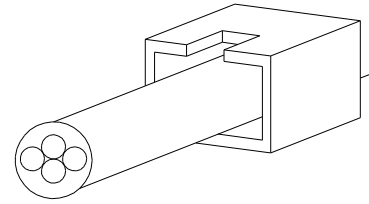


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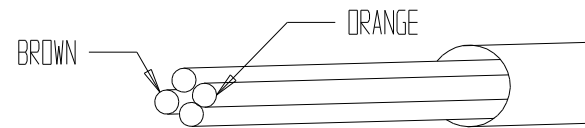
REV	REVISION	DATE	ER #	INTL
A04	NOTE 15 DIE# WAS 290655-01	10/20/2014	1477-14	ASL

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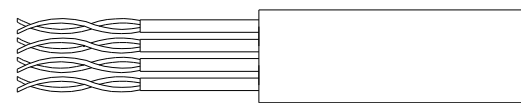
CABLE ASSEMBLY INSTRUCTION:



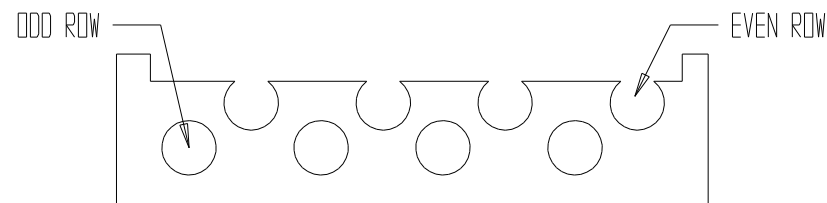
- 1.) SLIDE STRAIN RELIEF OVER CABLE.
- 2.) STRIP APPROX. 1" OF CABLE JACKET.
- 3.) FOLD OUTER SHIELDING AND DRAIN WIRE BACK OVER CABLE JACKET.
- 4.) SLIP SHIELDING FERRULE OVER OUTER SHIELD AND DRAIN WIRE.



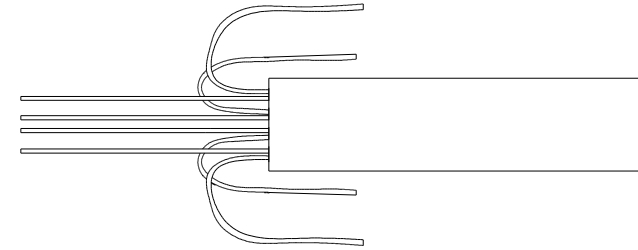
- 5.) CRIMP FERRULE WITH BROWN AND ORANGE PAIRS TO THE OUTSIDE.



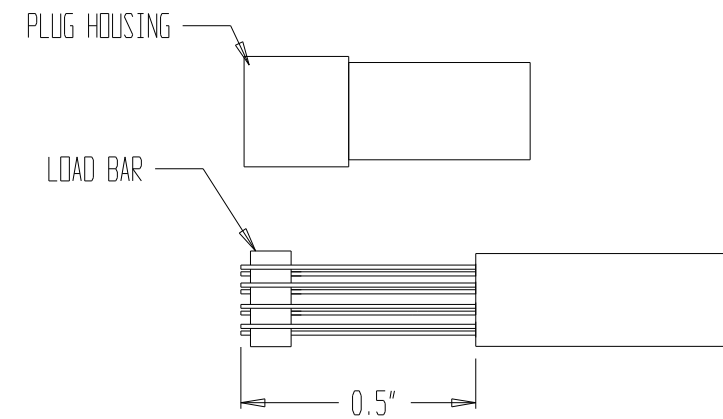
- 6.) REMOVE INDIVIDUAL PAIR SHIELDS.
- 7.) STRAIGHTEN AND ALIGN PAIRS. (TIA-586 B WIRING SHOWN)




- 8.) A264 MANAGEMENT LOAD BAR ODD AND EVEN ROWS.



- 9.) PULL EVEN (2, 4, 6, & 8) CONTACTS AWAY.
- 10.) TRIM ODD WIRES (1,3,5, & 7) AT AN ANGLE.
- 11.) INSERT ODD WIRES INTO ODD ROW OF LOAD BAR.
- 12.) LAY EVEN WIRES INTO EVEN ROW.



- 13.) TRIM OFF EXCESS LEAD LENGTH. USE PLUG HOUSING AS GUIDE.
- 14.) ENSURE WIRES ARE INSERTED FULLY INTO PLUG HOUSING.
- 15.) CRIMP CONTACTS USING HAND TOOL 2940231-01 AND DIE 2906253-01
- 16.) SLIDE STRAIN RELIEF OVER PLUG HOUSING.

MATERIAL	SCALE -	SIZE B	DATE 06/16/2006	 5349 S. EMMER DRIVE NEW BERLIN, WI 53151 (888) 679-6170
FINISH	TOLERANCES UNLESS NOTED .XX = ± .03 .XXX = ± .010 ANGLES ± 1°		DRAWN L. LUGO DESIGNED CHECKED V. LEX 10/20/2014 APPROVED K. BACHLEDA 10/20/2014 <small>CAO GENERATED AND MAINTAINED DRAWING -- DO NOT SCALE</small>	
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FILE: ES-106-1.prt