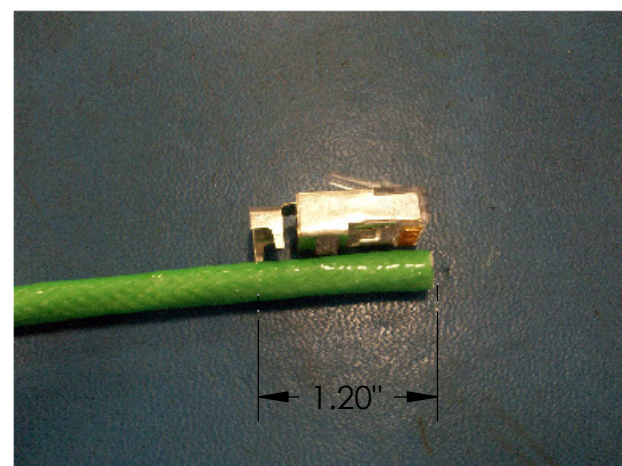


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STEP-BY-STEP ASSEMBLY PROCESS

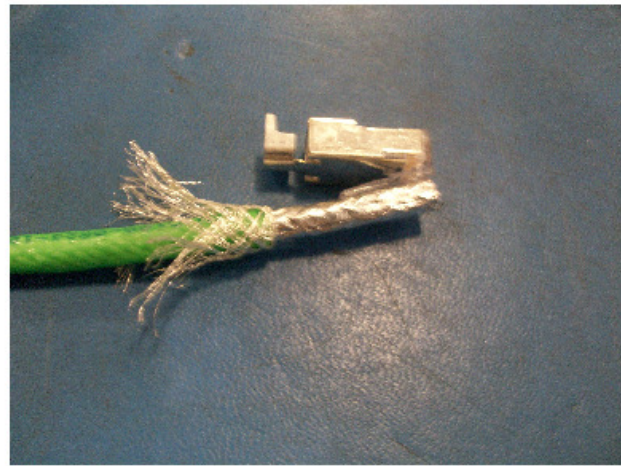
REV	REVISION	DATE	ECO#	INTL
C04	REVISE NOTES FOR CLARITY	06/13/2013	0603-13	VML

STEP 1



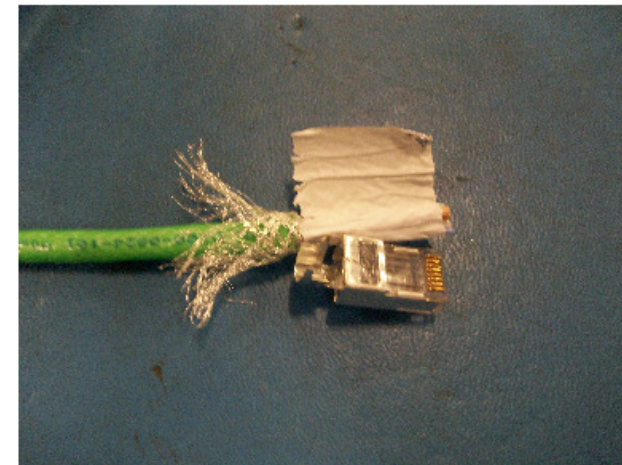
STRIP BACK 1.20"

STEP 2



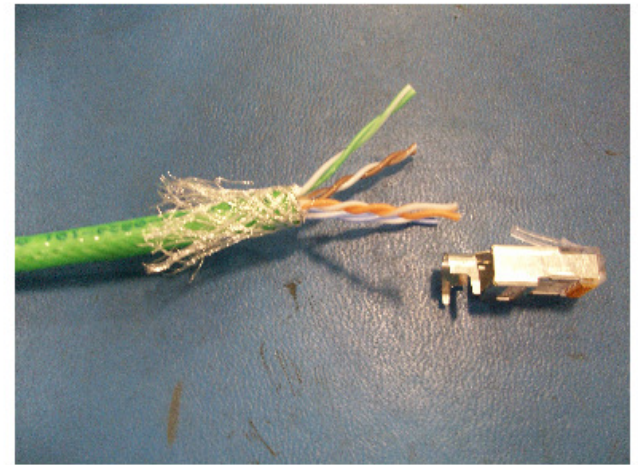
FOLD BACK BRAID

STEP 3



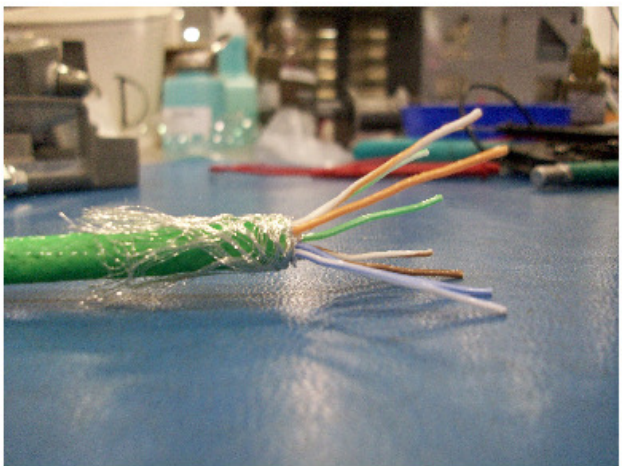
REMOVE ANY ADDITIONAL MATERIALS AT THIS TIME

STEP 4



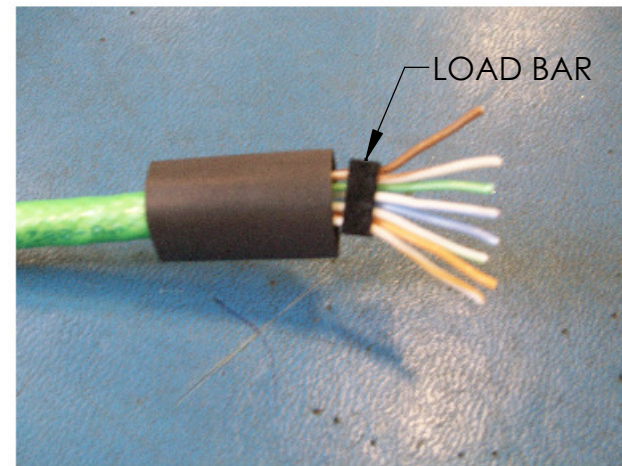
SEPARATE PAIRS

STEP 5



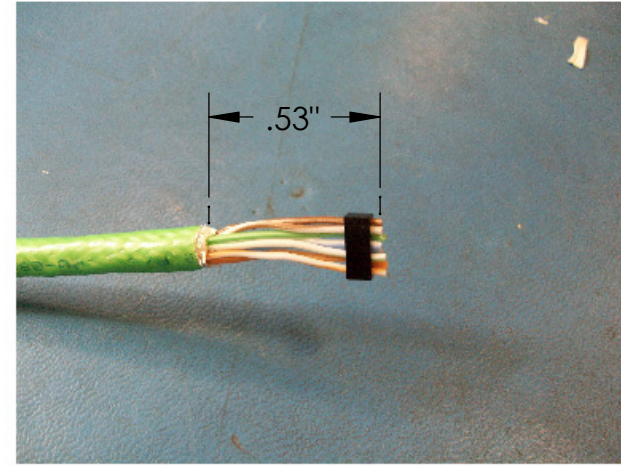
SEPARATE INDIVIDUAL CONDUCTORS INTO PROPER POSITION

STEP 6

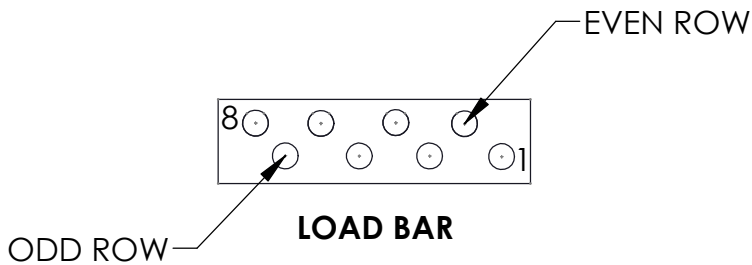


ADD HEATSHRINK DR-25-1/4"-0 TO BE USED TO COVER EXPOSED BRAID LATER IN ASSEMBLY, ALSO INSTALL ANY OTHER LABELS NEEDED FOR ASSEMBLY. INSTALL LOAD BAR (IF REQUIRED) (SEE CHART FOR LOCATION)

STEP 7



CUT FINAL LENGTH TO .53" GROUND PREVENTING HEATSHRINK NOT SHOWN FOR CLARITY



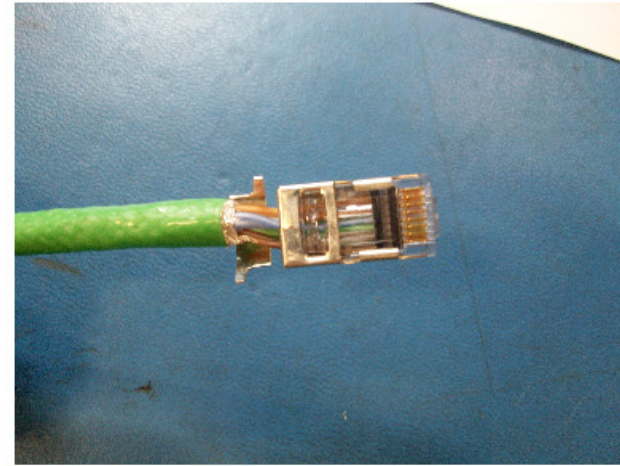
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MATERIAL	DRAWING UNITS: INCHES	DRAWN	 5349 S. EMMER DRIVE NEW BERLIN, WI 53151 PHONE: (262) 679-6170 FAX: (262) 679-6175 CAGE CODE: 06WH3
	TOLERANCES UNLESS OTHERWISE NOTED .X = ± 0.1 .XX = ± 0.03 .XXX = ± 0.010 ANGLES = ± 1°	V. LEX	
FINISH	 DO NOT SCALE DRAWING	DATE	DESCRIPTION
		09/26/2011	CABLE TERMINATION AND STRIPPING INSTRUCTIONS
PMA/STC? No	 DO NOT SCALE DRAWING	CHECKED	DWG. NO.
		A. LIPOWSKI	ES-106-4
		DATE	SCALE 1:1
		06/13/2013	SIZE B
		APPROVED	SHEET 1 OF 2
		B.KOJIS	
		DATE	
		06/13/2013	

REV	DATE	ECO#	INTL
C04	06/13/2013	0603-13	VML

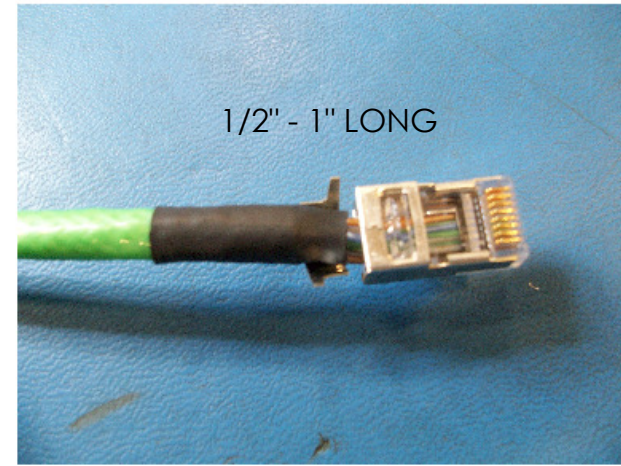
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STEP 8



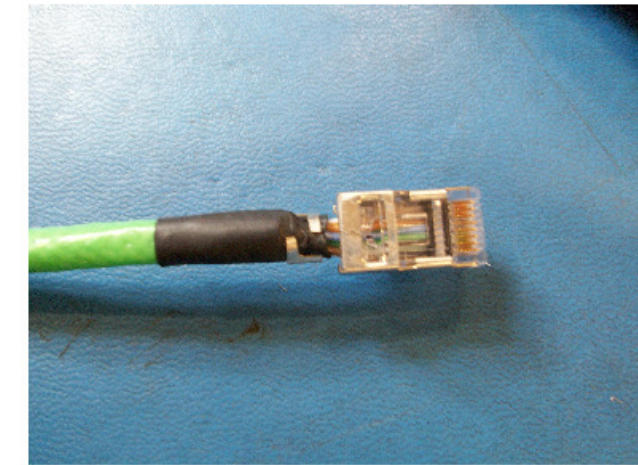
PUSH CABLE INTO PLUG HOUSING AT APPROX A 30° ANGLE WHILE CONTINUING TO PINCH JACKET. PUSH ALL CONDUCTORS UNDER THE IOC CONTACTS AND AS FAR INTO THE HOUSING AS POSSIBLE
GROUND PREVENTING HEATSHRINK NOT SHOWN FOR CLARITY

STEP 9



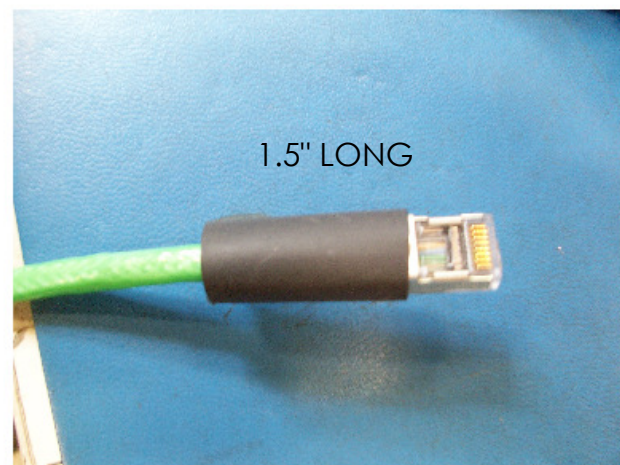
ADD GROUND PREVENTING HEATSHRINK

STEP 10



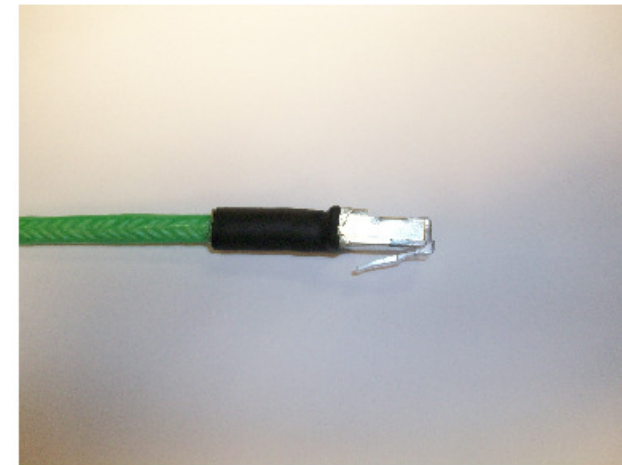
USE SENTINEL TOOL # 900007

STEP 11



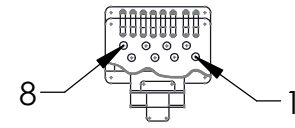
ADD BLACK ATUM OVER CONNECTOR
P/N: ATUM1/2"-BLK

STEP 12



SHRINK ATUM OVER END OF CONNECTOR AS SHOWN

FRONT VIEW OF CONNECTOR



PIN OUT CHART

568-A		568-B	
WHT/GRN _____	1	POSITION 1 _____	WHT/ORG
GREEN _____	2	POSITION 2 _____	ORG
WHT/ORG _____	3	POSITION 3 _____	WHT/GRN
BLUE _____	4	POSITION 4 _____	BLUE
WHT/BLU _____	5	POSITION 5 _____	WHT/BLU
ORANGE _____	6	POSITION 6 _____	GREEN
WHT/BRN _____	7	POSITION 7 _____	WHT/BRN
BROWN _____	8	POSITION 8 _____	BROWN

EMTEQ 5349 EMMER DRIVE
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CAGE CODE: 06WH3

DWG. NO. ES-106-4

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