

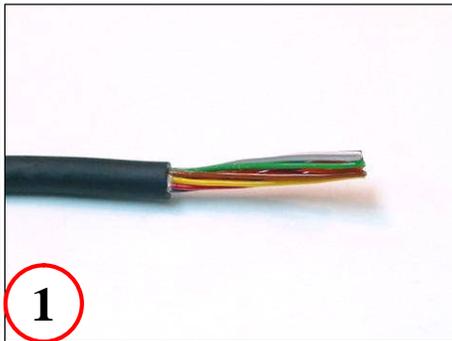
## 80 SERIES CABLEJACK ASSEMBLY INSTRUCTIONS

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

5639266, 5791942, 6217391, 6368159, 6419526, 6602097,  
6877222, 6964587, 7048590, 7086909, 7568950, 7686650

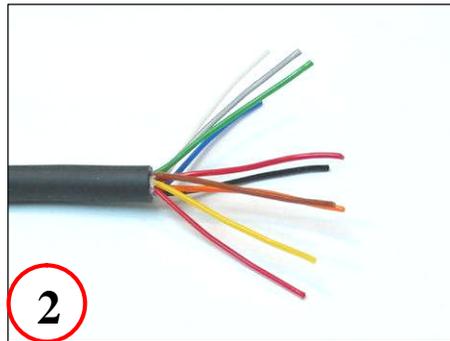
### Assembly steps 1 – 11:

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



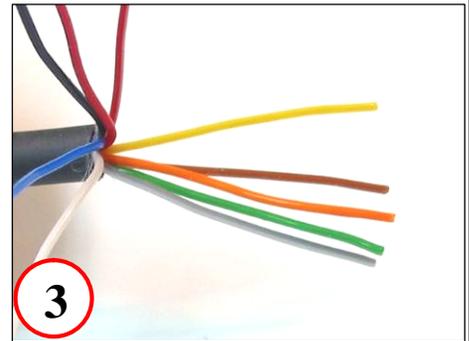
1

Strip off approximately 1 ¼ inch of cable jacket



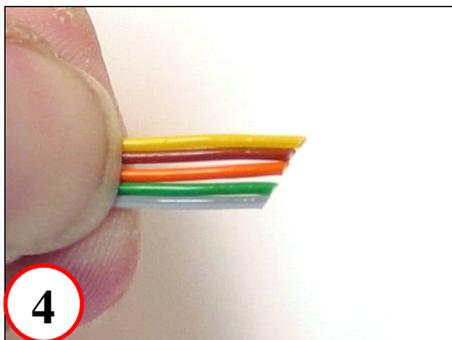
2

Spread apart wires, untwist pairs if necessary



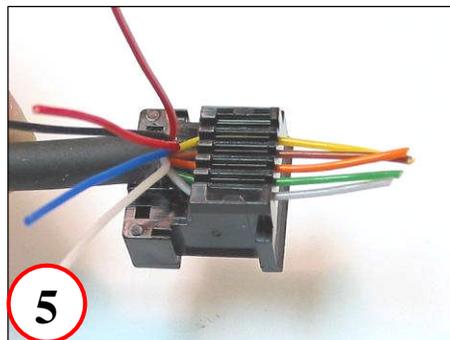
3

Align lower row conductors, fold upper conductors out of way



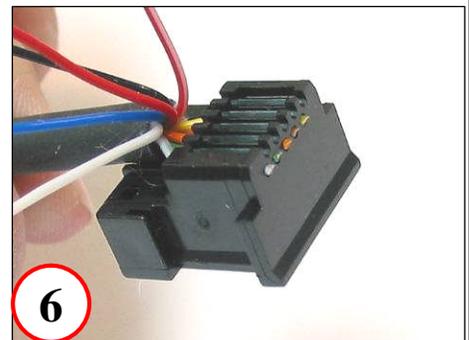
4

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



5

Place lower row conductors into load bar

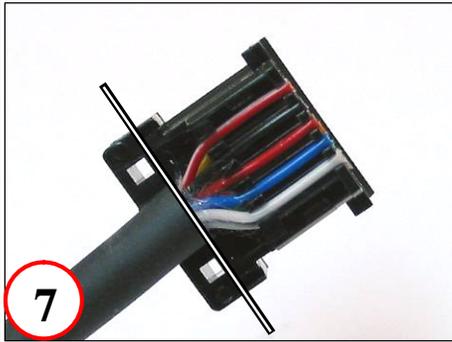


6

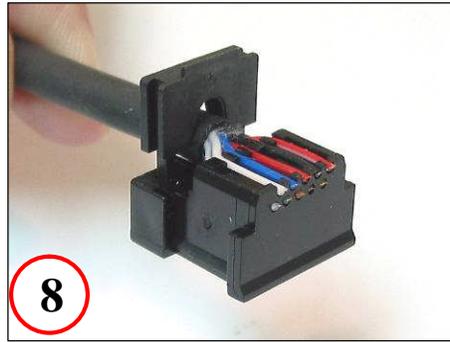
Trim lower row flush with front of load bar

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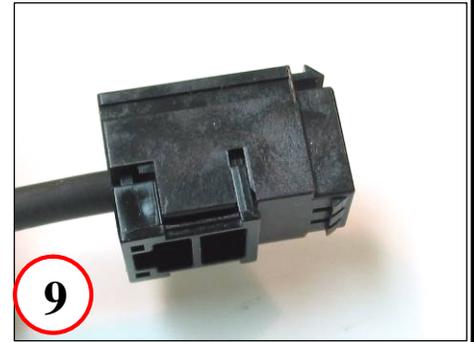
Assembly steps 1 – 11: (Cont.)



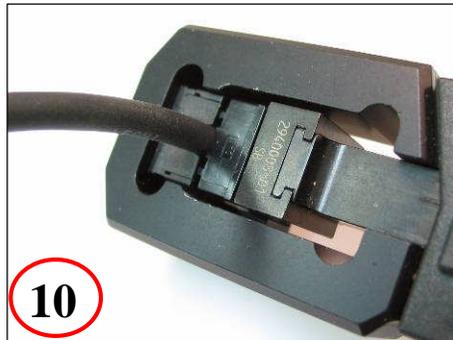
**7**  
Snap upper row conductors into place. Cable jacket ends in front of square holes



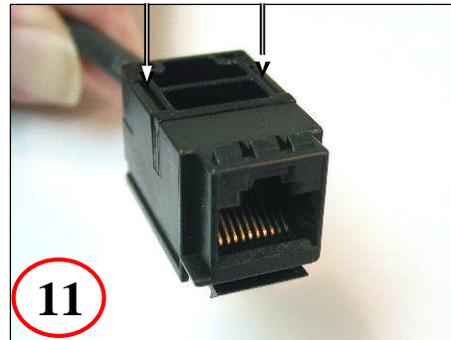
**8**  
Place strain relief over cable



**9**  
Place completed rear assembly into housing



**10**  
Place jack into crimper tool and crimp



**11**  
Assembly complete. Verify both sides are latched