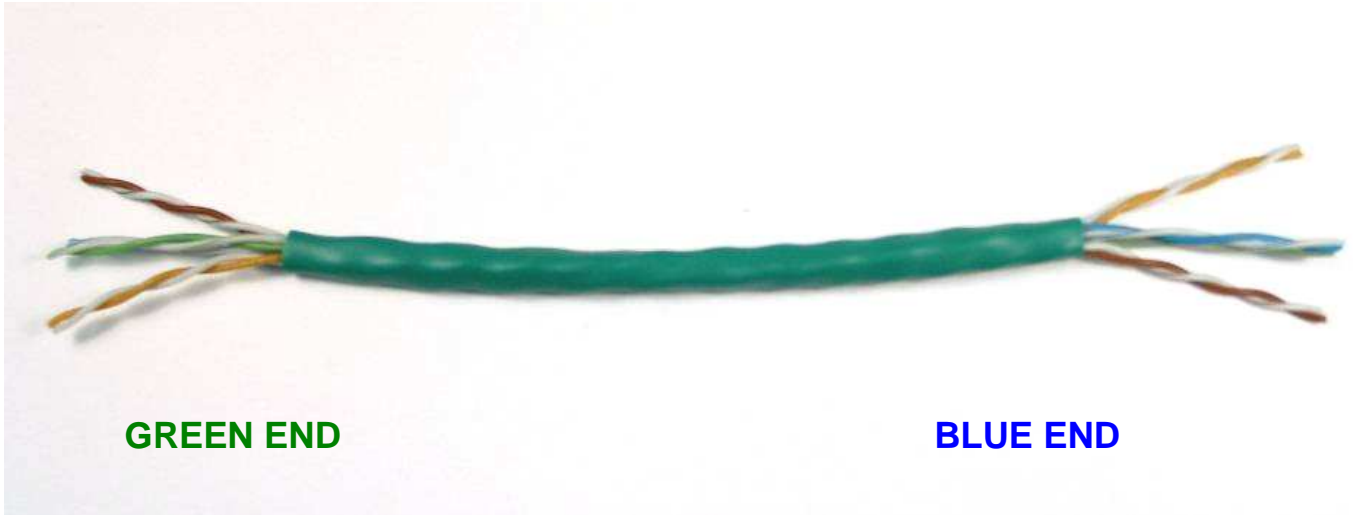


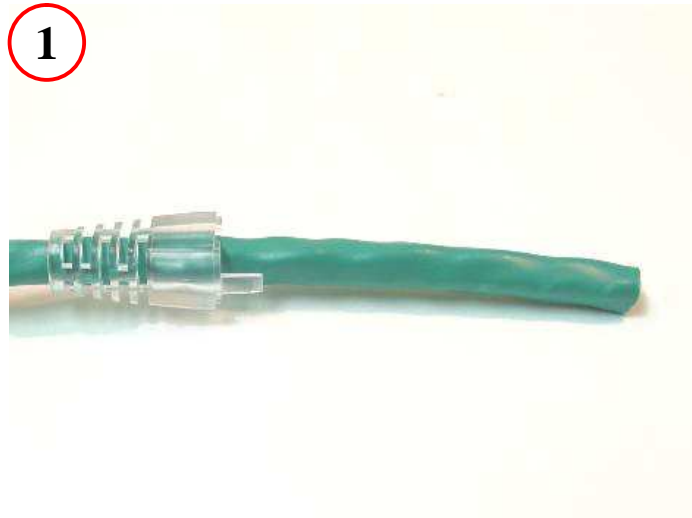
Stewart Connector

11118 Susquehanna Trail South Glen Rock, PA 17327

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.



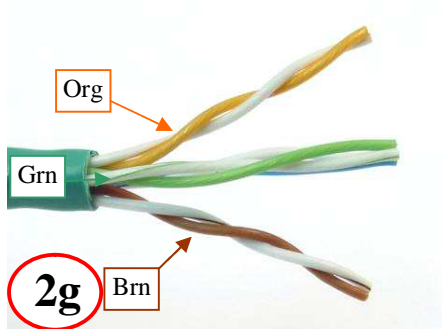
Slide Strain Relief onto cable

Stewart Connector

11118 Susquehanna Trail South Glen Rock, PA 17327

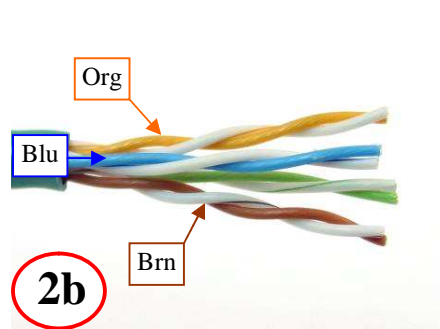
39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS

GREEN

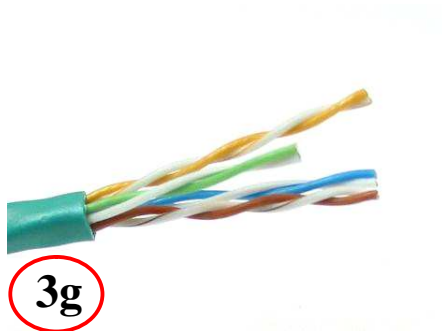


Strip off approximately 1 ¼ inch of cable jacket

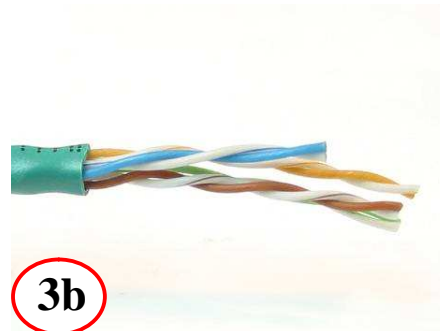
BLUE



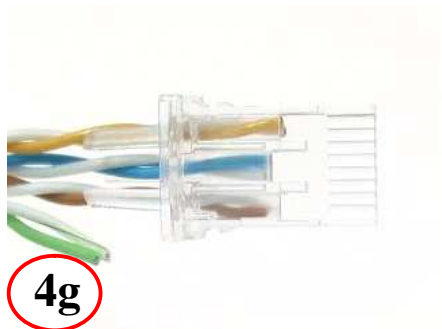
Strip off approximately 1 ¼ inch of cable jacket



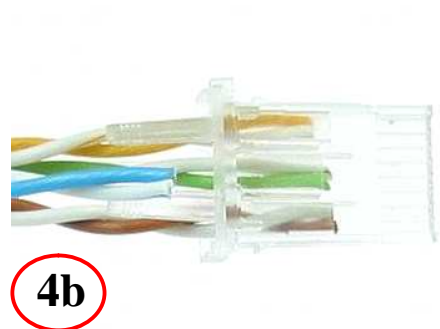
Separate Grn pair and trim ¼" off end



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

Stewart Connector

11118 Susquehanna Trail South Glen Rock, PA 17327

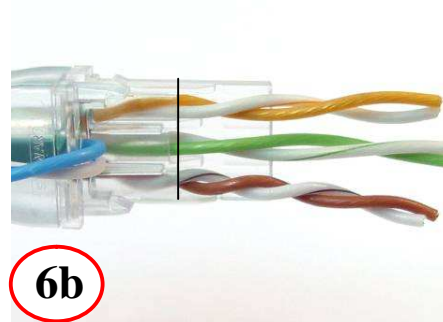
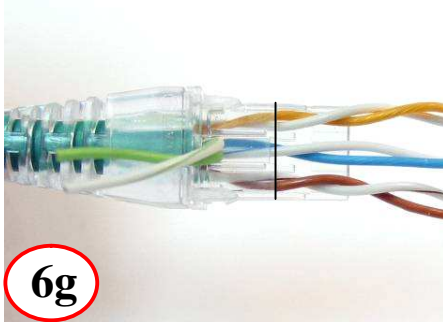
39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS



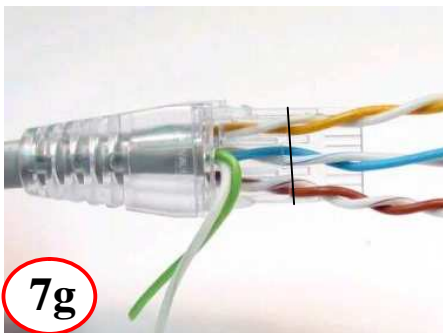
Latch strain relief onto load bar

GREEN

BLUE



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



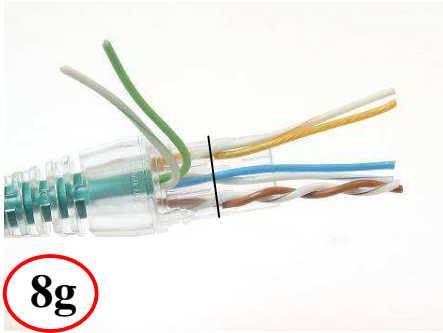
Add $\frac{1}{2}$ twist so Org pair is aligned correctly –
PAIRS MUST HAVE $\frac{1}{2}$ to 1 TWIST ONLY

Stewart Connector

11118 Susquehanna Trail South Glen Rock, PA 17327

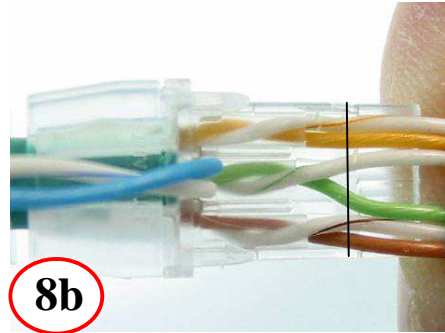
39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS

GREEN

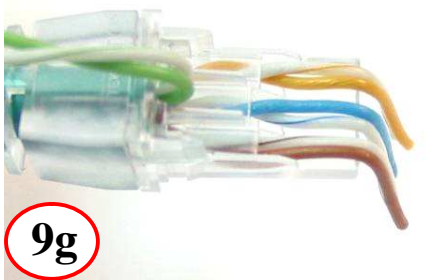


Untwist lower three pairs back to ends of side walls

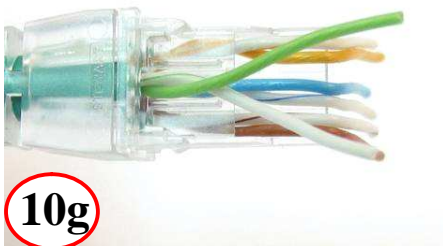
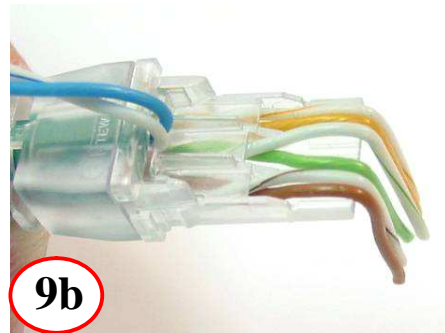
BLUE



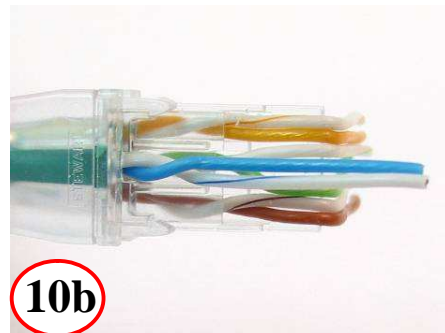
Untwist lower three pairs back to ends of side walls. Spread Grn pair



Bend lower pairs back at $\cong 90^\circ$ angle



Check Grn pair for alignment
Add $\frac{1}{2}$ twist if necessary



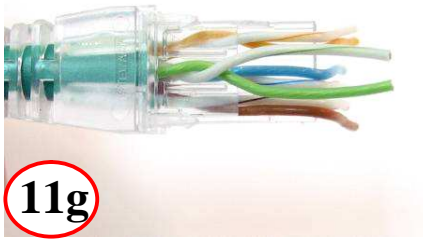
Check Blu pair for alignment
Add $\frac{1}{2}$ twist if necessary

Stewart Connector

11118 Susquehanna Trail South Glen Rock, PA 17327

39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS

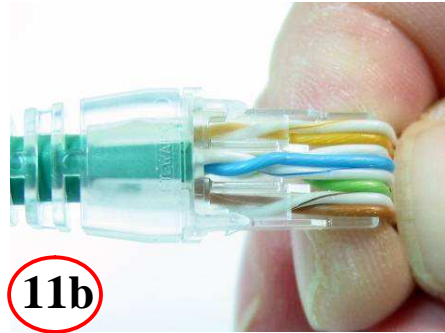
GREEN



11g

Form Grn pair so it fits around Blu pair

BLUE



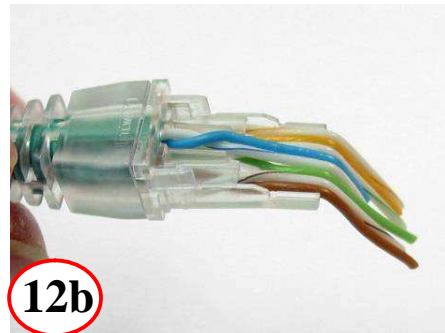
11b

Fit Blu pair inside Grn pair



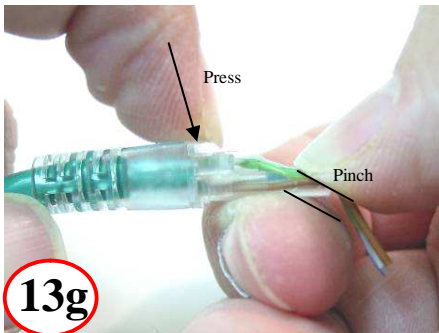
12g

Place Grn pair and bend back \cong 90° like lower pairs



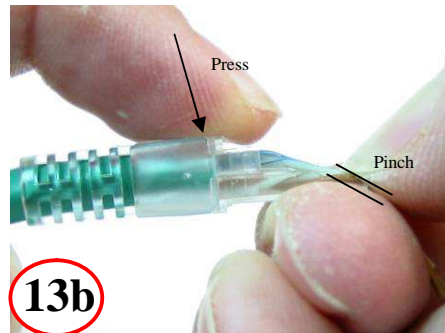
12b

Bend Blu pair back \cong 90° like lower pairs



13g

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



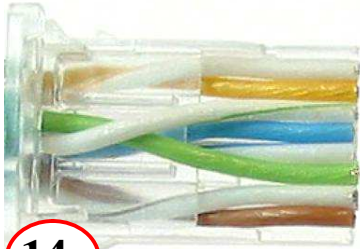
13b

Stewart Connector

11118 Susquehanna Trail South Glen Rock, PA 17327

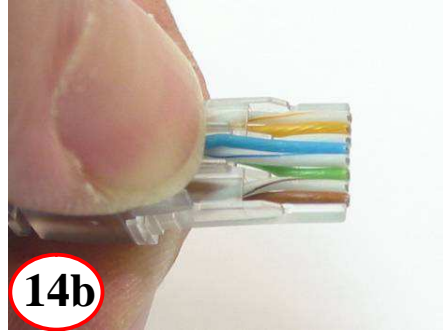
39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS

GREEN



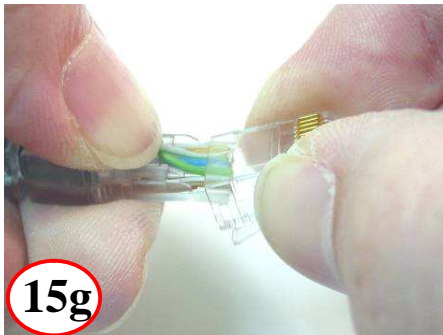
14g

BLUE

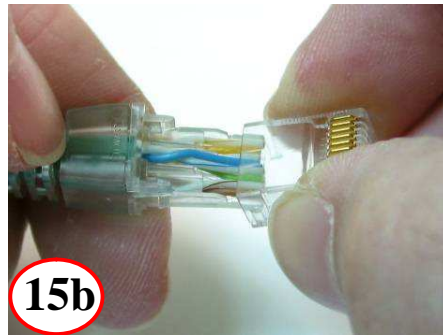


14b

Trim wire ends flush with end of load bar



15g

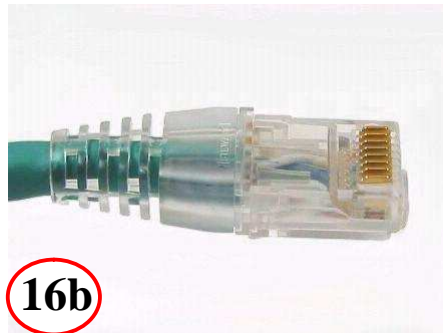


15b

Place load bar assembly into housing



16g



16b

Snap housing and load bar assembly together

Stewart Connector

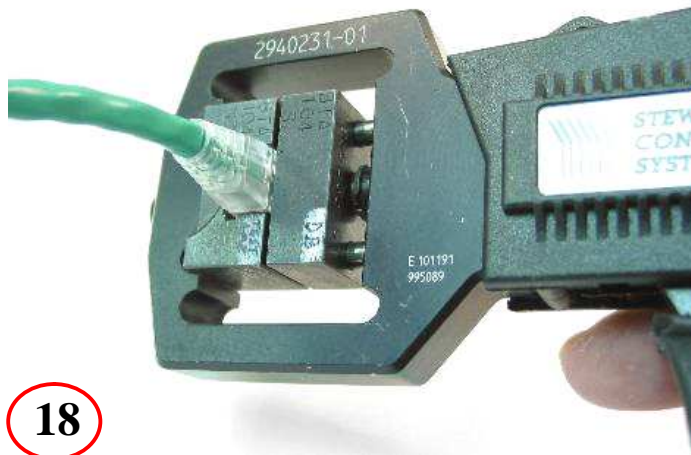
11118 Susquehanna Trail South Glen Rock, PA 17327

39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS



17

Verify that wires went all the way to front of housing



18

Crimp contacts. Assembly complete