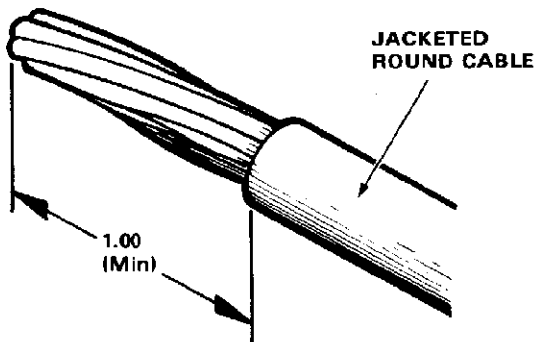


ASSEMBLY PROCEDURES

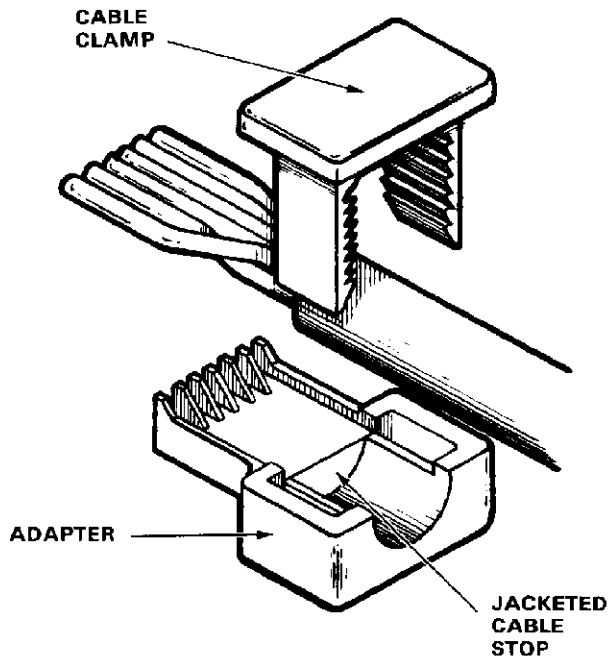
1. Strip round cable outer jacket 1-in. minimum.
2. Unravel the individual conductors into a reasonably flat position.



3. Lay cable in adapter and butt jacket against stop.
4. Place cable clamp over cable and push it into adapter.

NOTE

Needle-nose pliers may be used to squeeze the cable clamp and adapter together for better retention of the cable.

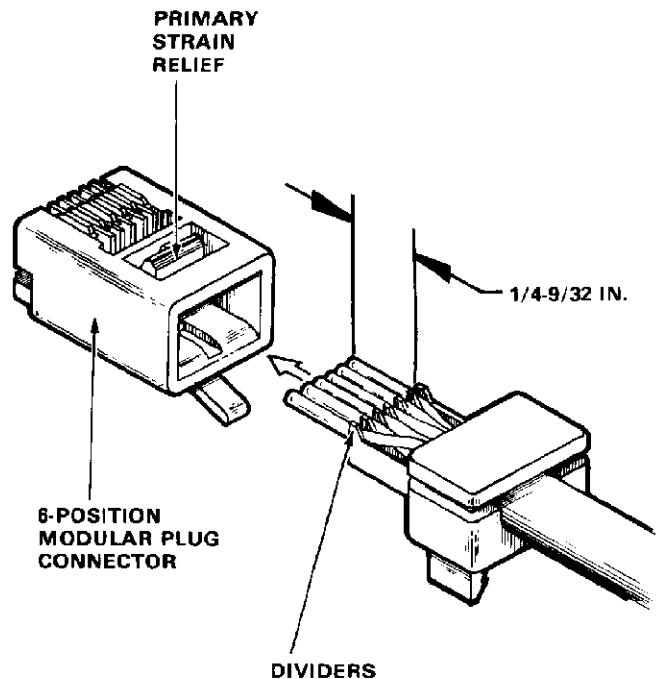


5. Orient the individual conductors in the proper sequence and place them between the dividers. Once laced, the conductor length should be trimmed evenly so that 1/4 to 9/32 in. protrudes from the end of the adapter.

6. Insert conductors and divider section of adapter into modular plug connector. Terminate connector with AMP Hand Tool 231652-2. Refer to IS 3156, packaged with the tool, for proper termination procedures.

NOTE

The primary strain relief will latch just behind the adapter dividers, permanently locking the adapter to the plug.



NOTE

If the cable clamp ends protrude below the adapter, they may be cut off for easier access to the plug locking tab.

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