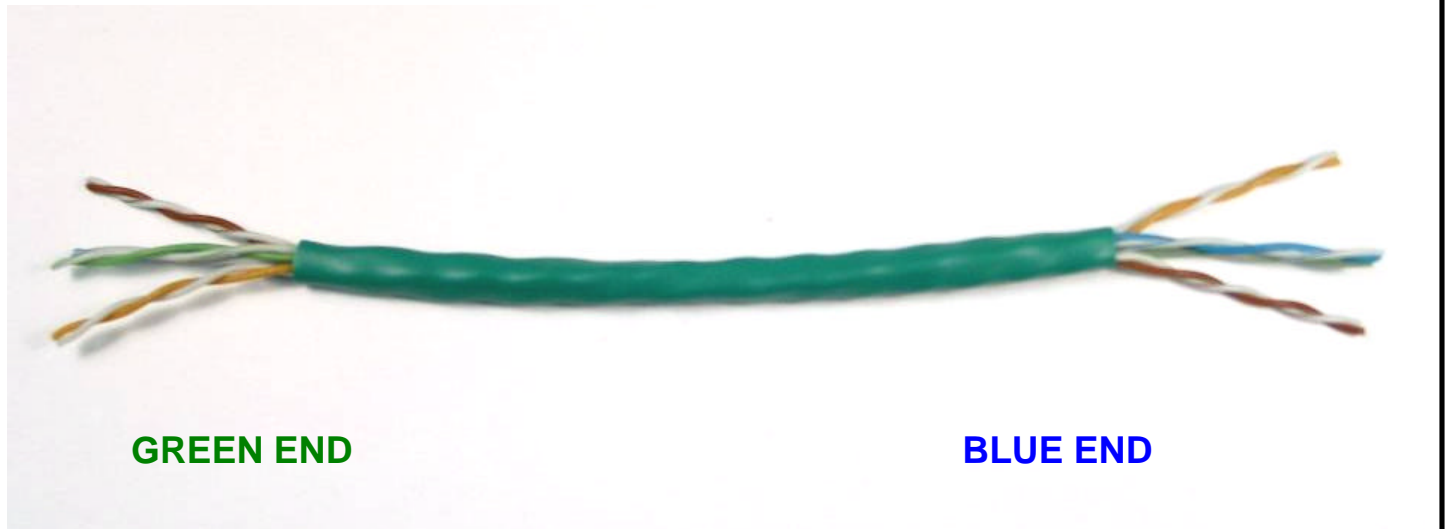


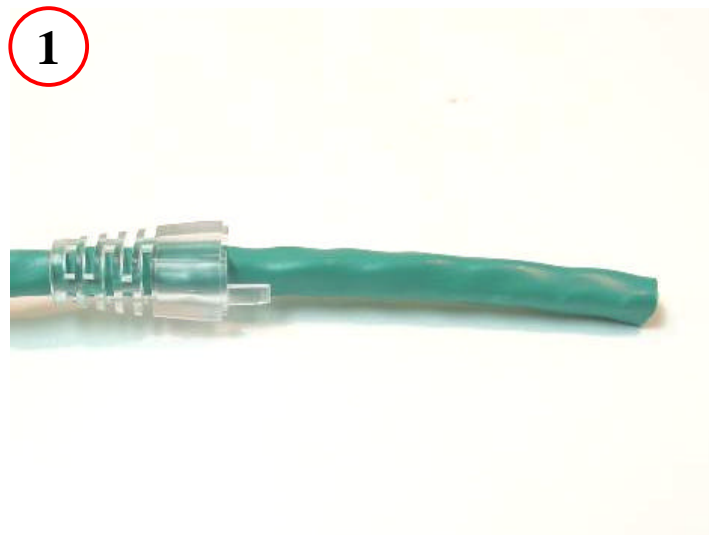
# Bel Stewart Connector

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## 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.



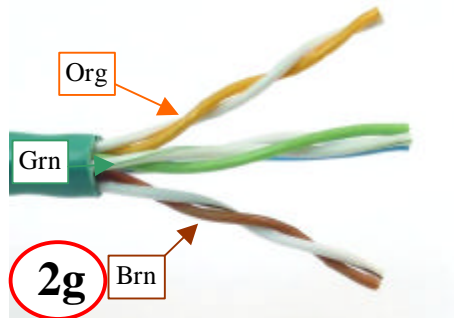
Slide Strain Relief onto cable

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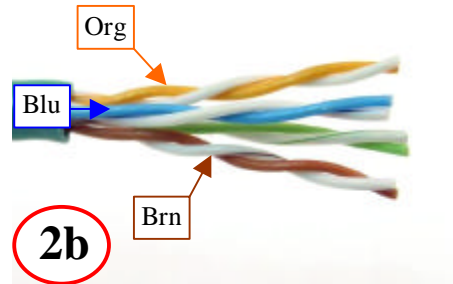
## 39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS

**GREEN**

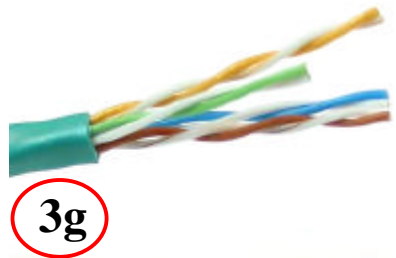


Strip off approximately 1 ¼ inch of cable jacket

**BLUE**



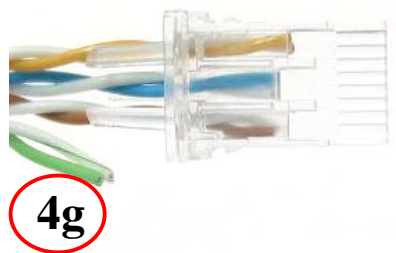
Strip off approximately 1 ¼ inch of cable jacket



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

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## 39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS

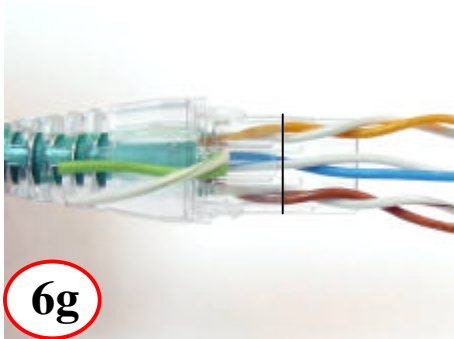


5

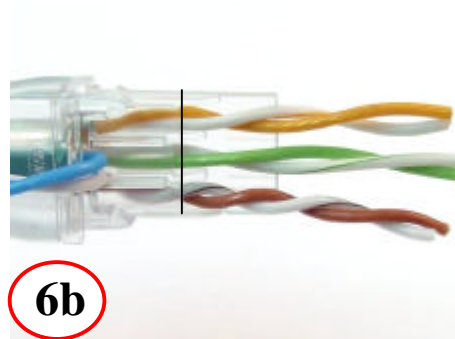
Latch strain relief onto load bar

GREEN

BLUE

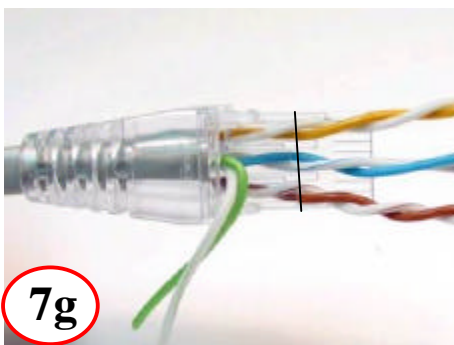


6g

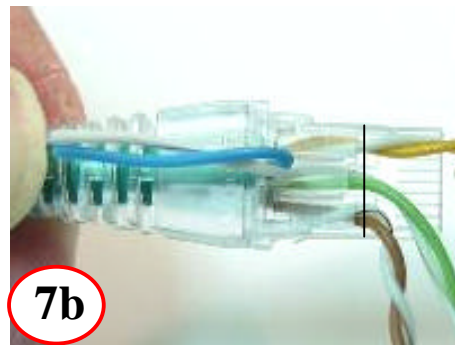


6b

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



7g



7b

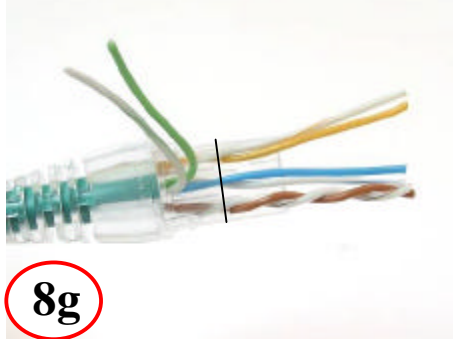
Add  $\frac{1}{2}$  twist so Org pair is aligned correctly –  
**PAIRS MUST HAVE  $\frac{1}{2}$  to 1 TWIST ONLY**

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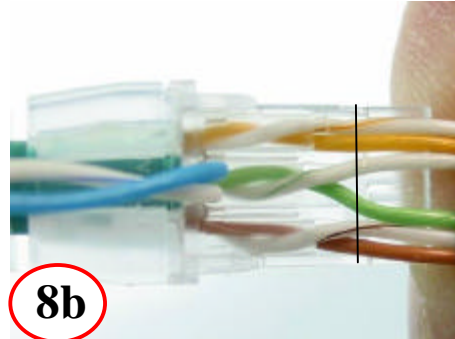
## 39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS

**GREEN**



Untwist lower three pairs back to ends of side walls

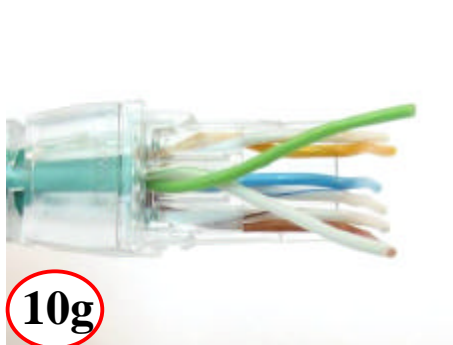
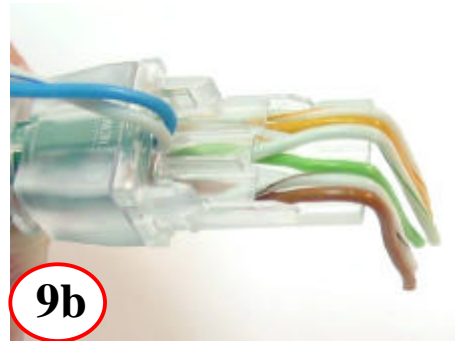
**BLUE**



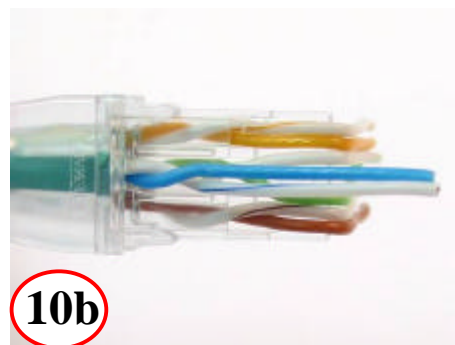
Untwist lower three pairs back to ends of side walls. Spread Grn pair



Bend lower pairs back at @90° angle



Check Grn pair for alignment  
Add ½ twist if necessary



Check Blu pair for alignment  
Add ½ twist if necessary

# Bel Stewart Connector

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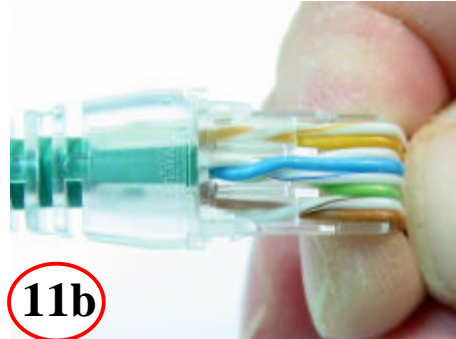
## 39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS

**GREEN**

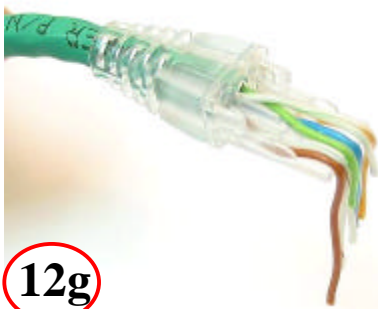


Form Grn pair so it fits around Blu pair

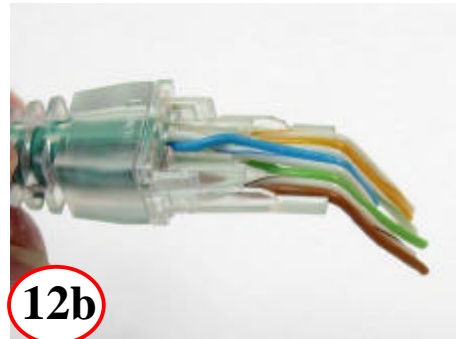
**BLUE**



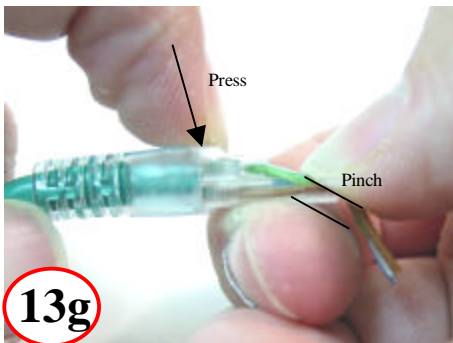
Fit Blu pair inside Grn pair



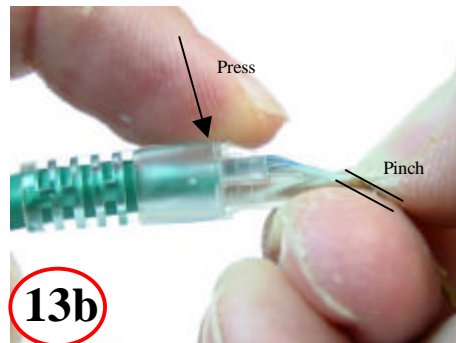
Place Grn pair and bend back @ 90° like lower pairs



Bend Blu pair back @ 90° like lower pairs



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



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## 39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS

**GREEN**



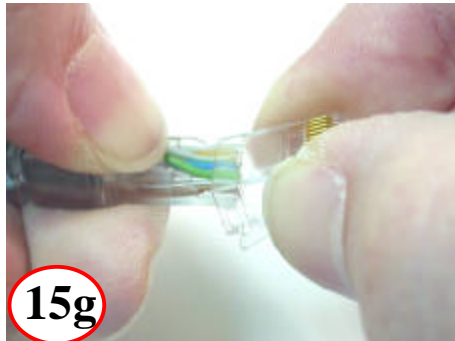
**14g**

**BLUE**

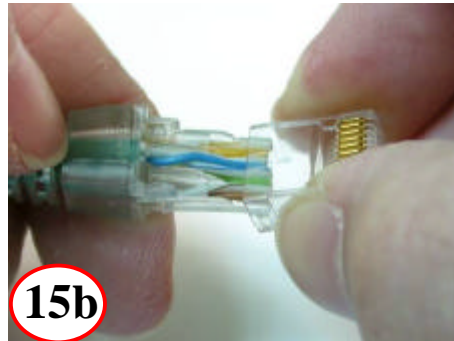


**14b**

**Trim wire ends flush with end of load bar**



**15g**

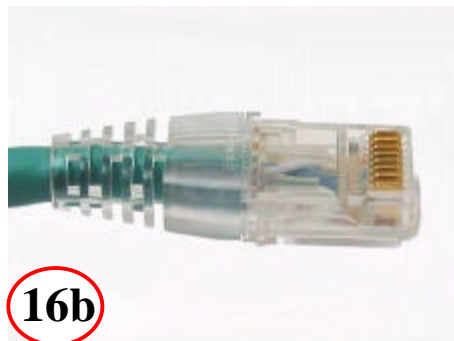


**15b**

**Place load bar assembly into housing**



**16g**



**16b**

**Snap housing and load bar assembly together**

# Bel Stewart Connector

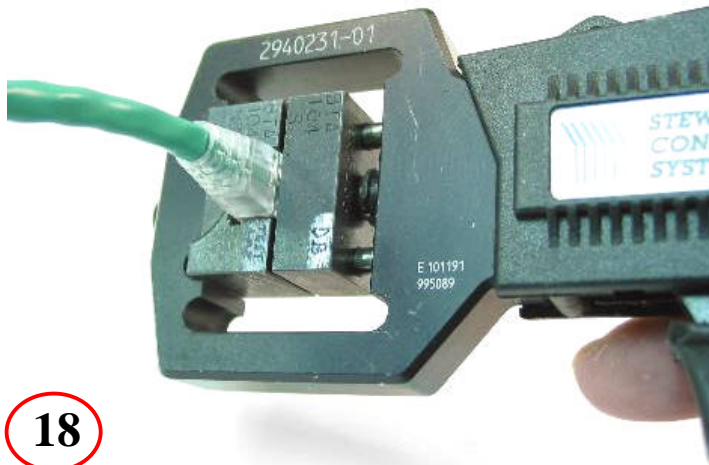
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## 39 SERIES UNSHIELDED ASSEMBLY INSTRUCTIONS



**17**

Verify that wires went all the way to front of housing



**18**

Crimp contacts. Assembly complete