With **Orange** on left and **Brown** on right, 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.

**INDIVIDUALLY SHIELDED PAIRS**
For Cable with Overall Shield See Page 6

1. **Trim off approx. 1.75 to 2.00 inches of cable jacket**
   - Do not nick shield

2. **Fold shield back over cable jacket**

3. **Spread apart pairs**
Trim individual pair shields, leaving approximately 0.375 inches (3/8”) sticking out beyond cable jacket.

Untwist pairs back to ends of shields.

Here, Brn pair has incorrect alignment. Add ½ twist as low as possible.

Here, Blu pair has incorrect alignment. Add ½ twist as low as possible.

Brn pair is now in correct alignment.

Blu pair is now in correct alignment.
Fold Green pair back

Split Green pair around Blue pair, then fold back

Trim ends of Orange, Blue, and Brown pairs at a slight angle to make loading easier

Insert Orange, Blue, and Brown pairs into load bar
Leave load bar near end of pairs

Bring up Green pair and trim so it fits into load bar
**Shielded 39200 Series Assembly Instructions**

Individually Shielded Pair Cable

11118 Susquehanna Trail South Glen Rock, PA 17227

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**Slide load bar down to base of pairs**

**Trim off wire ends at approx. 0.2 inches (3/16”)**

**Slide load bar to end of pairs to make loading into housing easier**

**Gently insert assembly into housing**
16. Close shield fingers by hand

17. Verify wires are visible through end of plug

18. Crimp contacts and shield fingers. Trim off excess shield
OVERALL SHIELD
For Cable with Individual Shielded Pairs See Page 1

1. Trim off approx. 1.75 to 2.00 inches of cable jacket
   Do not nick shield

2. Fold shield back over cable jacket

3. Wrap drain around cable ¼” (0.25”) behind end of jacket

4. Remove any inner insulating jacket
Untwist individual pairs to approximately 0.375 inches (3/8") beyond cable jacket.

Here, Grn pair has incorrect alignment. Add ½ twist as low as possible.

Grn pair is now in correct alignment.

Fold Grn pair back.

Split Grn pair around Blu pair, then fold back.
Trim ends of **Org**, **Blu** and **Brn** pairs @ slight angle to make loading easier

Insert **Org**, **Blu** and **Brn** pairs into load bar
Leave load bar near end of pairs

Bring up **Grn** pair and trim so it fits into load bar

Slide load bar down to base of pairs
Trim off wire ends at approx. 0.2 inches (3/16”)

Slide load bar to end of pairs to make loading into housing easier

Gently insert assembly into housing

Close shield fingers by hand
Keep drain wire entirely under fingers
17 Verify wires are visible through end of plug

18 Crimp contacts and shield fingers

19 Trim off excess foil shield