

INTRODUCTION

The detail shown within this instruction sheet gives guidance for the assembly of the chosen cable to connector. (Refer to the tables for the applicable connector part numbers covered by this document).

The assembly instructions are in sketch form, which show the sequence of how to assemble.

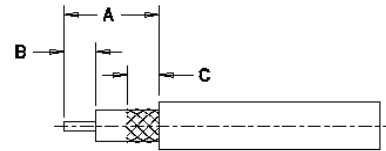
The sketches are relevant for both jacks and plugs. For clarity, only one type of connector is shown.

Cable preparation should be undertaken in accordance with normal safety precautions using commercially available cable stripping tools.

PART NUMBERS, CABLE PREPARATION AND TOOLING

TABLE

Die Aperture sizes are shown against either the die set or the handtool. Contact aperture is always the smaller. If a die set part number is not shown, the handtool is supplied assembled with the die integral.



VERSION 1

connector P/N	Cable Strip Dimensions			Hand Tool Part No.	Die Set Part No.		connector P/N	Cable Strip Dimensions			Hand Tool Part No.	Die Set Part No.
	A	B	C					A	B	C		
1-1337410-0	16.5	4.0	8.0	9-1478239-0 2.6 & 10.2	integral		1-1337443-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5
1-1337412-0	19.5	3.5	10.0	9-1478239-0 2.6 & 10.2	integral		1-1337444-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5
1-1337413-0	16.5	3.5	7.0	9-1478240-0	9-1478246-0 2.7 & 5.5		1-1337462-0	25.5	2.0	7.0	9-1478240-0	9-1478242-0 5.6 only
1-1337414-0	16.0	3.5	8.0	9-1478239-0 2.6 & 10.2	integral		1-1337477-0	11.0	2.5	5.0	9-1478240-0	9-1478248-0 3.4 only
1-1337415-0	16.5	4.0	8.0	9-1478240-0	9-1478246-0 2.7 & 10.8		1-1337489-0	15.5	3.5	7.5	9-1478240-0	9-1478243-0 1.75 & 8.2
1-1337416-0	16.5	4.0	8.0	9-1478240-0	9-1478242-0 2.6 & 5.6		1-1337495-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1337426-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6		1-1337496-0	15.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1337427-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6		1-1337501-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5
1-1337428-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5		1-1337511-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1337429-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5		1-1337514-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1337430-0	15.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75		1-1337515-0	15.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1337431-0	15.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75		1-1337516-0	15.5	3.5	7.5	9-1478240-0	9-1478243-0 1.75 & 8.2
1-1337432-0	15.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75		1-1337517-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5
1-1337433-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6		1-1337520-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5
1-1337434-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6		1-1337525-0	12.5	2.5	7.0	9-1478240-0	9-1478242-0 1.75 & 6.5
1-1337435-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5		1-1337530-0	15.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1337436-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5		1-1337531-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1337438-0	12.5	2.5	7.0	9-1478240-0	9-1478242-0 6.5 only		1-1337537-0	16.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1337439-0	12.5	2.5	7.0	9-1478240-0	9-1478245-0 1.75 & 4.75		1-1337538-0	16.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1337440-0	12.5	2.5	7.0	9-1478240-0	9-1478245-0 1.75 & 4.75		1-1337544-0	12.5	2.5	7.0	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1337441-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6		1-1337545-0	12.5	2.5	7.0	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1337442-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6		1-1337546-0	12.5	2.5	7.0	9-1478240-0	9-1478245-0 1.75 & 4.75

connector P/N	Cable Strip Dimensions			Hand Tool Part No.	Die Set Part No.		connector P/N	Cable Strip Dimensions			Hand Tool Part No.	Die Set Part No.
	A	B	C					A	B	C		
1-1337548-0	16.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75		1-1478073-0	12.5	2.5	7.0	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1337549-0	16.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75		1-1478074-0	12.5	2.5	7.0	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1337550-0	13.5	2.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6		1-1478075-0	12.5	2.5	7.0	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1337579-0	11.5	2.5	5.5	9-1478240-0	9-1478248-0 0.65sq & 2.8		1-1478076-0	12.5	2.5	7.0	9-1478240-0	9-1478242-0 1.75 & 6.5
1-1337580-0	11.5	2.5	5.5	9-1478240-0	9-1478248-0 0.65sq & 3.4		1-1478077-0	12.5	2.5	7.0	9-1478240-0	9-1478242-0 1.75 & 6.5
1-1337587-0	10.5	2.2	4.6	9-1478240-0	9-1478248-0 0.65sq & 2.8		1-1478078-0	12.5	2.5	7.0	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1337588-0	10.5	2.2	4.6	9-1478240-0	9-1478248-0 0.65sq & 3.4		1-1478079-0	12.5	2.5	7.0	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1337597-0	10.5	2.2	5.0	9-1478240-0	9-1478248-0 3.4 only		1-1478080-0	12.5	2.5	7.0	9-1478240-0	9-1478247-0 1.75 & 7.5
1-1337601-0	11.0	2.5	5.0	9-1478240-0	9-1478248-0 3.4 only		1-1478081-0	12.5	2.5	7.0	9-1478240-0	9-1478247-0 1.75 & 7.5
1-1337608-0	12.5	2.5	6.0	9-1478240-0	9-1478248-0 0.65sq & 3.4		1-1478082-0	12.5	2.5	7.0	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1337611-0	15.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75		1-1478083-0	12.5	2.5	7.0	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1337613-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6		1-1478084-0	12.5	2.5	7.0	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1337614-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6		1-1478085-0	12.5	2.5	7.0	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1337615-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6		1-1478088-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5
1-1337616-0	16.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75		1-1478089-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5
1-1337625-0	19.5	4.0	8.0	9-1478240-0	9-1478242-0 2.6 & 5.6		1-1478090-0	16.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1337626-0	19.5	3.5	10.0	9-1478239-0 2.6 & 10.2	integral		1-1478091-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1337627-0	16.5	3.5	7.0	9-1478240-0	9-1478246-0 2.7 & 5.5		1-1478092-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1337628-0	19.5	3.5	10.0	9-1478240-0	9-1478246-0 2.7 & 10.8		1-1478093-0	16.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1337629-0	16.5	4.0	8.0	9-1478239-0 2.6 & 10.2	integral		1-1478094-0	16.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1337630-0	16.5	4.0	8.0	9-1478240-0	9-1478246-0 2.7 & 10.8		1-1478095-0	16.5	3.5	7.5	9-1478240-0	9-1478247-0 1.75 & 7.5
1-1337631-0	16.5	4.0	8.0	9-1478240-0	9-1478242-0 2.6 & 5.6		1-1478096-0	16.5	3.5	7.5	9-1478240-0	9-1478247-0 1.75 & 7.5
1-1337632-0	16.0	3.5	8.0	9-1478239-0 2.6 & 10.2	integral		1-1478097-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1337633-0	16.0	3.5	8.0	9-1478240-0	9-1478242-0 2.6 & 5.6		1-1478098-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1337634-0	16.0	3.5	8.0	9-1478240-0	9-1478246-0 2.7 & 10.8		1-1478099-0	16.5	3.5	6.5	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1478005-0	11.5	2.5	5.5	9-1478240-0	9-1478248-0 0.65sq & 2.8		1-1478100-0	16.5	3.5	6.5	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1478006-0	11.5	2.5	5.5	9-1478240-0	9-1478248-0 0.65sq & 3.4		1-1478101-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1478015-0	15.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75		1-1478102-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1478016-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5		1-1478103-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5
1-1478056-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5		1-1478104-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5
1-1478057-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5		1-1478105-0	15.5	3.5	7.5	9-1478240-0	9-1478247-0 1.75 & 7.5
1-1478058-0	16.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75		1-1478106-0	15.5	3.5	7.5	9-1478240-0	9-1478247-0 1.75 & 7.5

1-1478059-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6		1-1478107-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1478060-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6		1-1478108-0	15.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1478061-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5		1-1478109-0	7.0	3.2	1.0	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1478062-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5		1-1478110-0	7.0	3.2	1.0	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1478063-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6		1-1478111-0	11.5	2.7	5.3	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1478064-0	16.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75		1-1478112-0	11.5	2.7	5.3	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1478065-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6		1-1478180-0	16.5	4.0	8.0	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1478066-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 6.5		1-1478181-0	16.5	4.0	8.0	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1478067-0	16.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75		1-1478182-0	16.5	4.0	8.0	9-1478240-0	9-1478246-0 2.7 & 10.8
1-1478068-0	16.5	3.5	7.5	9-1478240-0	9-1478245-0 1.75 & 4.75		1-1478183-0	16.5	4.0	8.0	9-1478240-0	9-1478246-0 2.75 & 10.8
1-1478069-0	16.5	3.5	7.5	9-1478240-0	9-1478247-0 1.75 & 7.5		1-1478184-0	16.5	4.0	8.0	9-1478239-0 2.6 & 10.2	integral
1-1478070-0	16.5	3.5	7.5	9-1478240-0	9-1478247-0 1.75 & 7.5		1-1478185-0	16.5	4.0	8.0	9-1478239-0 2.6 & 10.2	integral
1-1478071-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6		1-1478210-0	16.0	4.5	9.0	9-1478240-0	9-1478246-0 2.75 & 10.8
1-1478072-0	16.5	3.5	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6							

Connector P/N	Cable Strip Dimensions			Hand Tool Part No.	Die Set Part No.
	A	B	C		
1-1478210-0	16.0	4.5	9.0	9-1478240-0	9-1478246-0 2.7 & 10.8
1-1478211-0	22.5	4.5	10.0	9-1478240-0	9-1478246-0 2.7 & 10.8
1-1478212-0	16.0	3.5	8.0	9-1478240-0	9-1478242-0 2.6 & 5.6
1-1478213-0	22.5	4.5	10.0	9-1478240-0	9-1478246-0 2.7 & 10.8
1-1478214-0	19.5	3.5	10.0	9-1478240-0	9-1478246-0 2.7 & 10.8
1-1478422-0	12.5	2.5	7.0	9-1478240-0	9-1478245-0 1.75 & 4.75
1-1478994-0	15.0	4.0	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6
1-1478995-0	15.0	4.0	7.5	9-1478240-0	9-1478242-0 1.75 & 5.6

End of part number tables.

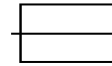
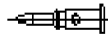
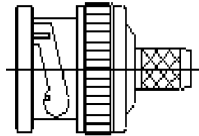
ASSEMBLY DIAGRAM FOLLOWS ON NEXT PAGE.

ASSEMBLY DETAILS.

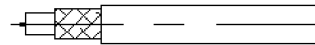
MAIN BODY

CONTACT PIN

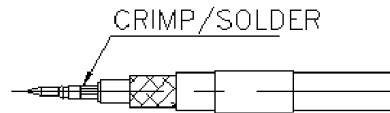
FERRULE



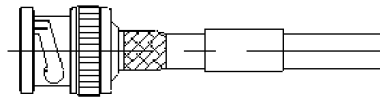
STEP 1



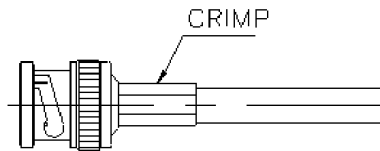
STEP 2



STEP 3



STEP 4



REVISION RECORDS

REVISION	DESCRIPTION	DRAWN BY	CHECKED BY	APPROVED BY	DATE
A	RELEASE FOR PRODUCTION	R.GOODALL	F.W-KING	F.W-KING	12 NOV 2001