

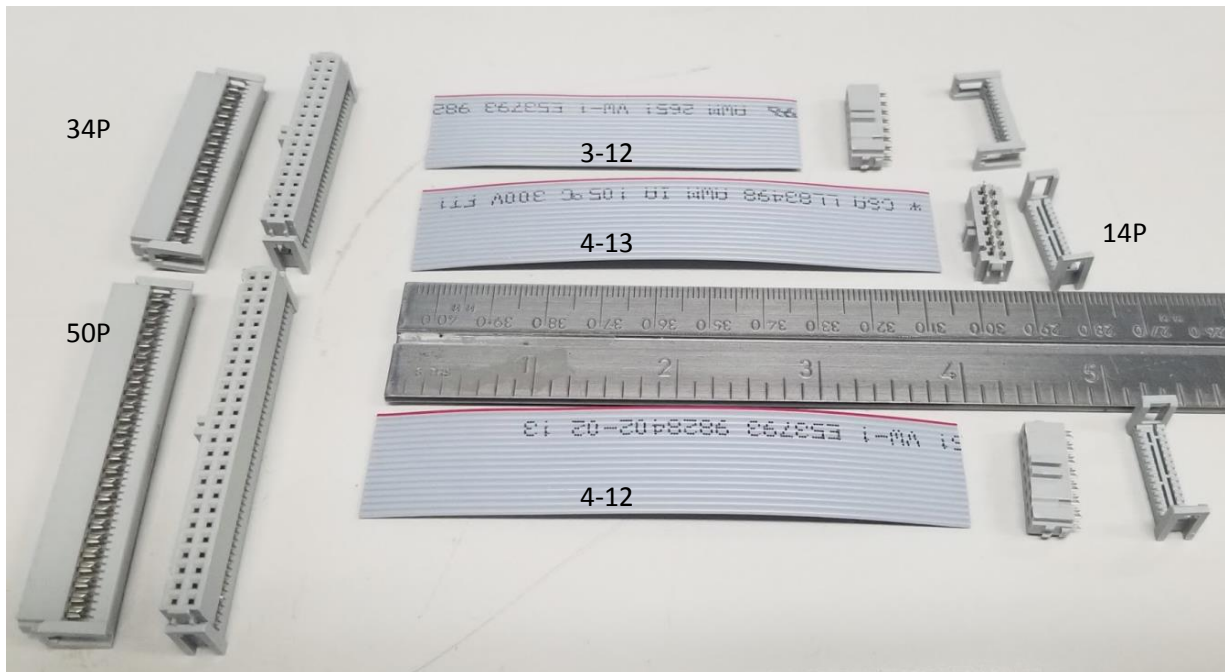
IT1335-015 Cable Kit Work Instructions

Materials needed:

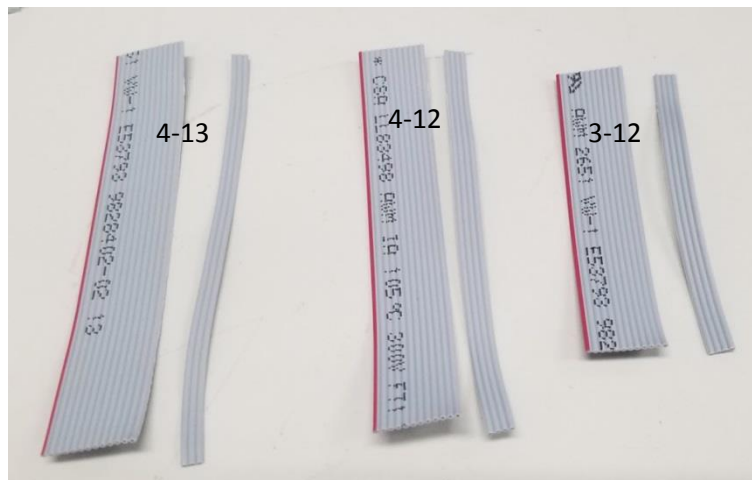
1. (11") – 16 conductor Ribbon Cable, AMP 1-57040-6 (or equivalent, minimum 14 conductor)
2. (3) – 14P IDC polarized connectors, 3M D89114-0131HK
3. (2) – 34P IDC polarized connectors, 3M 89134-0103
4. (2) – 50P IDC polarized connectors, 3M 89150-0103
5. (2) – Euro Terminal Block Connectors, Phoenix Contact 1714977
6. (20") – 18-22AWG wire, 2 10" lengths, preferably Red/Black or White/Black

Ribbon Cable Assembly Procedure:

1. Cut Ribbon cable into 3 pieces, (2) – 4" and (1) – 3":



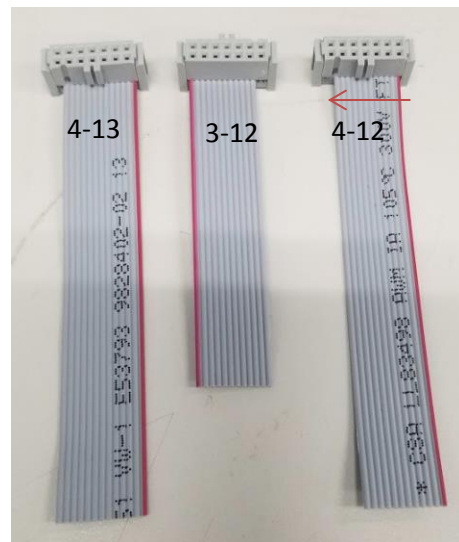
2. Trim 3" and one 4" piece down to 12 conductors, and trim other 4" piece down to 13 conductors:



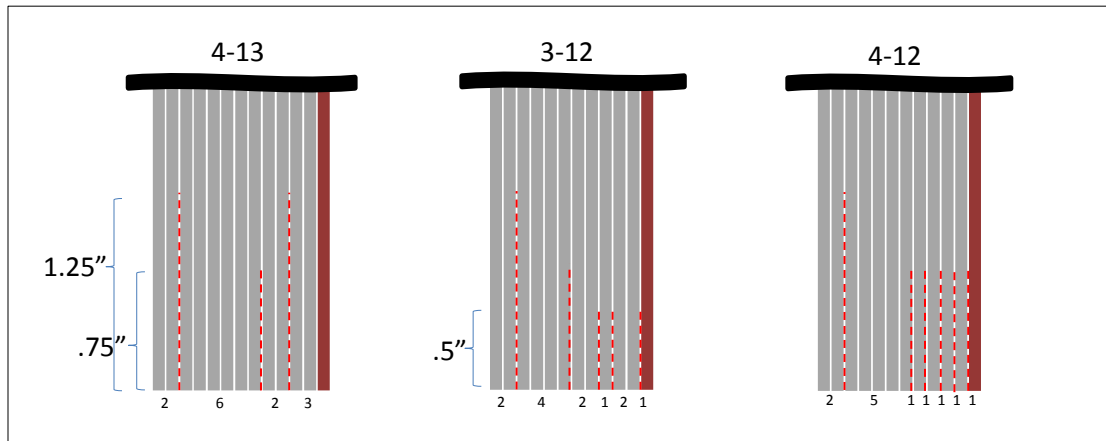
3. Assemble the ribbons and the 14P connectors as shown (Note the orientation of each set):

a. EDIT: 4-12 should be to the left, not the right.

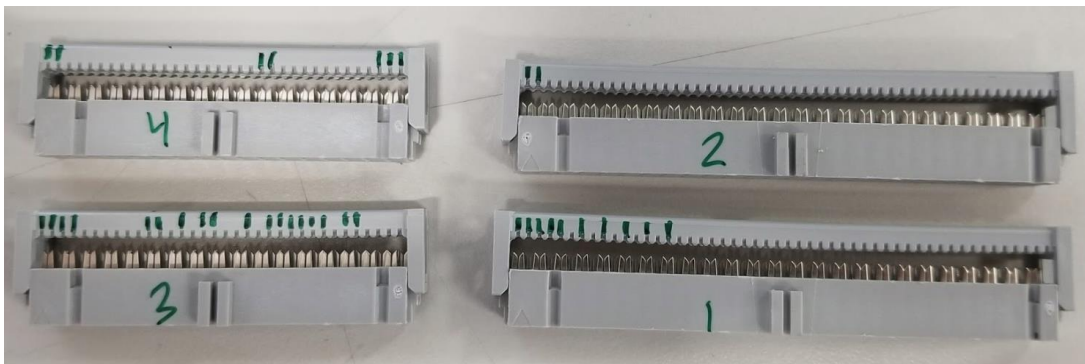
- b. GENTLY use a soft-jawed vise or arbor press to compress the two halves of the connector, piercing the ribbon cable and making the electrical connection:



4. Cut or tear the ribbon cables as shown (NOTE: Make sure not to damage or nick the individual wires):

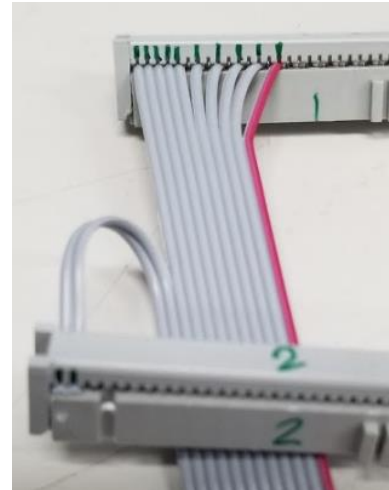


5. Use a fine tip marker to mark the connectors with their number designator and tick marks over each position to be connected:

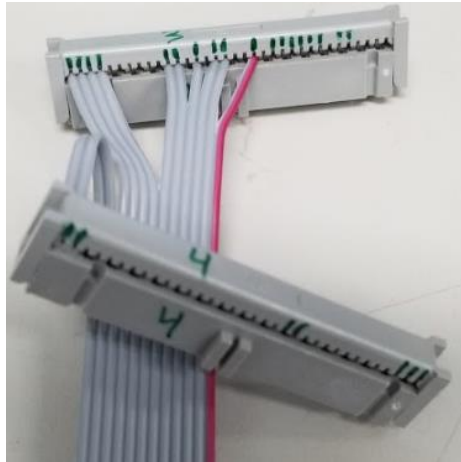


- a. From Right to Left (M=mark, S=skip): **4:** M2, S18, M2, S9, M3. **2:** M2
3: M4, S6, M2, S1, M1, S1, M2, S2, M1, S1, M6, S1, M2.
1: M5, S1, M1, S1, M1, S1, M1, S1, M1, S1, M1

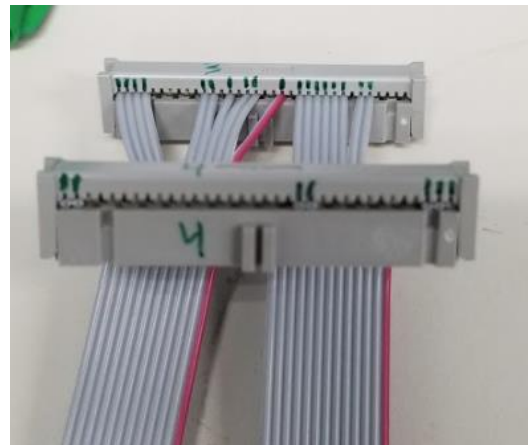
6. Insert 4-12 into Connectors 1 & 2 (1 should enter the connector from the front, and 2 should enter from the back):



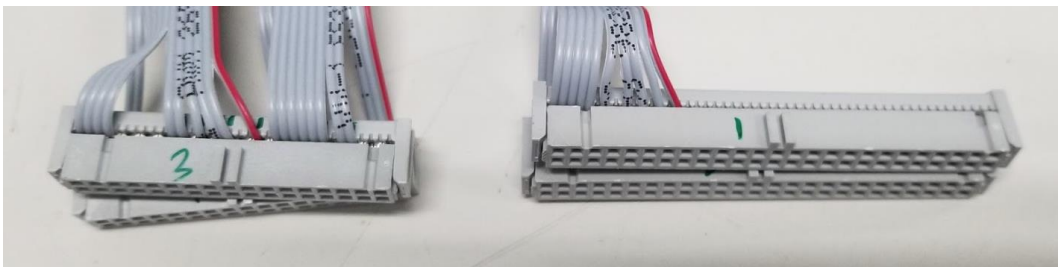
7. Insert 3-12 into the left side of 3 & 4 (3 should enter the connector from the front, and 4 should enter from the back):



8. Insert 4-13 into the right side of 3 & 4 (3 should enter the connector from the front, and 4 should enter from the back):



9. Roll 1&2 and 3&4 towards each other:



Power Cable Assembly Procedure:

1. Strip all 4 ends of the wire back $\approx 3/16"$:



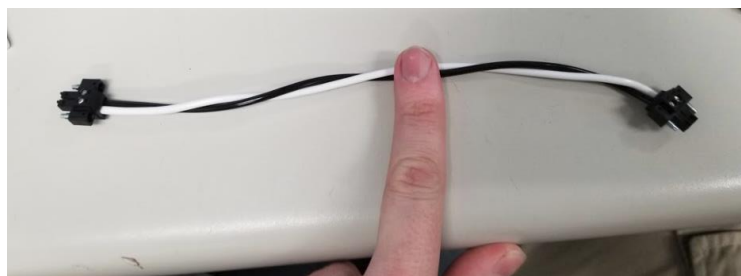
2. Insert the black wire into the right terminal, and the white or red wire into the left terminal. Tighten with a small flat head driver until gutenteit:



3. Gently twist the wires together:



4. Repeat step 2 on other end, adjusting the wire twist so both connectors face up:



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