

1. Before Soldering, the bend relief and back housing need to be slipped onto the wire, Figure 3 shows what these two black pieces look like.
2. After soldering wires to the pins, insert the pin block into the front metal housing (figure doesn't show wires on the pins but wires do need to be soldered on prior to inserting the pin block). Position it as shown in Figure 1, and then push forward until it snaps into place (approximately 1/4" forward of where it is shown).



Figure 1

3. The strain relief clamp is placed under the tab on the back of the metal housing. When crimped, the clamp will hold the wire down against the tab. After the strain relief is crimped, use the small metal plate to make a complete metal cylinder housing.



Figure 2

4. The bend relief and back housing should have already been slipped onto the wire, at this time, the back housing can slide up and cover the strain relief. The bend relief (or cord guard piece) snaps into the back housing.



Figure 3

5. Remove the spring retainer from the forward housing, the retainer, shown to the left, is used only for shipping and can be discarded.



Figure 4

6. Insert the metal housing into the forward plastic housing as shown, and then snap all parts together. The bend relief is shown not snapped in yet, if it was already snapped in, just snap on the forward housing.



Figure 5