

PIC Wire & Cable

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Termination Instructions

T-190007-SQ1

Approved

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Rev. 0

Distribution : USER

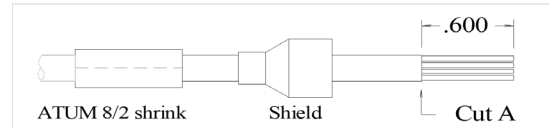
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Termination Instructions for PIC 190007 Shielded RJ45 Plug Connectors On PIC E50424 Star-Quad Cable

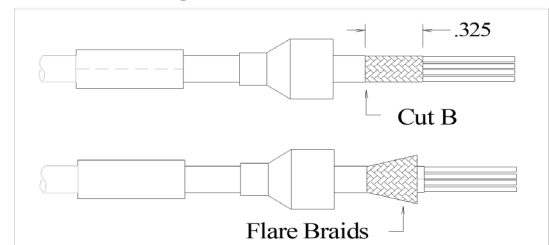
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| Recommended Hand Tools : | X-acto Knife, Sharp Razor, Wire Cutters |
| Required Tooling | PIC 110274 Crimp Tool or PIC 110340 Crimp Tool |
| <i>PIC 190007 RJ45 Plug modification: OMIT the Strain Relief Sleeve, ADD Raychem ATUM 8/2 Dual Wall shrink tube x .750" length</i> | |

- 1 Install Raychem ATUM 8/2 Dual Wall shrink tube x .750" length onto the cable. Install metal Rear Shield, w/ wider end towards the cable end.
- 2 Make Cut A (.600" from end) through Jacket. DO NOT nick or cut into the wires. Remove jacket, braids, and foil. Separate and straighten wires, and arrange them into the desired configuration.
- 3 Make Cut B (.325" from Cut A), through Jacket. Do not cut into wires. Remove jacket, and moderately flare the ends of the braids, to allow installation of the inner ferrule. Leave the foil intact.
- 4 Install the Inner Ferrule, over the wires, over the foil, but under the flared braids. Seat firmly down to Cut B, but under the braids.
- 5 Verify the arrangement of the wires to the desired configuration, in preparation for insertion into the connector. Trim off the ends of the pairs squarely, using a sharp wire cutters, or razor (to avoid undue flattening of the wire insulation). Trim off no more than .050" Max .
- 6 Just prior to insertion into the connector Front Body, arrange wire # 2 upwards, so that it is offset from wires 1 and 3, corresponding to the offset inside the connector (see illustration). Install wires into the connector body, keeping alignment intact. To complete full insertion, push while gripping braids over the ferrule. Proper insertion is indicated by viewing ALL of the wire conductors through the front end of the connector body. The Inner Ferrule may contact the Front Body when wires are fully inserted. Clean off any stray braids with compressed air.
- 7 Slide the Rear Shield into place against the Front Body. Grip the Front Body to help keep the wires in the correct positions. The end of Cut B should be visible outside of rear of the Shield.
- 8 Verify full insertion before crimping the connector. Crimp using PIC 110274 Crimp Tool or PIC 110340 Crimp Tool.
- 9 Shrink the ATUM 8/2 shrink tube on the connector and cable, with the ATUM shrink starting at the end of the tapered section of the rear shield (as shown below). Heat with Steinel heat gun, using the heat setting # 3 (or 360° F).

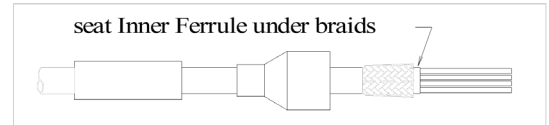
Step 2 NOT TO SCALE



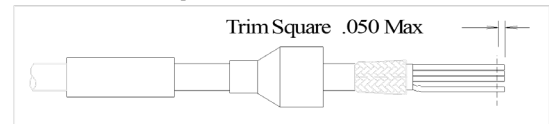
Step 3 NOT TO SCALE



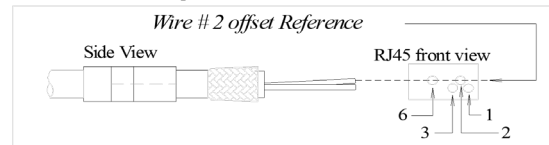
Step 4



Step 5 NOT TO SCALE

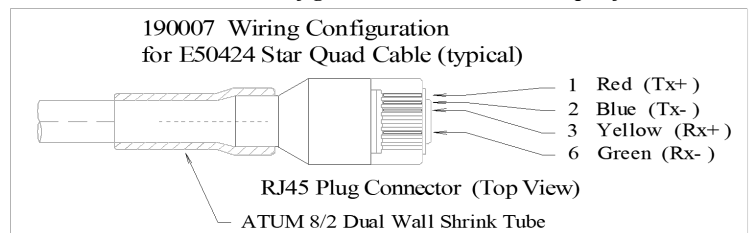


Step 6



Step 9

E50424 Configuration, unless otherwise specified



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