PIC Wire & Cable	Termination Instructions	T-110361
A Division of the Angelus Corporation	Approved : PFT	Date : 02/23/07
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Termination Instructions for PIC RJ45 Shielded Plug P/N 110361

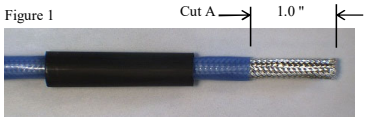
(for E50824, E50824-X, G50824 & G53824 Ethernet Cables)

Required Tooling :	PIC P/N 110288 Crimp Tool (Sentinel P/N 900007), Heat Gun
Recommended Tooling :	X-acto Knive, Sharp Razor, Wire Cutters, Locking Tab Heat Shield, Eye Loupe / Magnifier

Dimensions in Inches (NOT to Scale)

1) Install labels (if applicable). Install ATUM heat shrink (8/2 x 1.375") on cable. Make Cut A @ 1.0" from cable end, through the cable jacket (Fig. 1). Remove jacket, braids, foil, and teflon tape. Do Not nick or cut into the wire insulation. Inspect wire insulation to verify insulation integrity

Figure 1



2) Fold each pair back, and trim off the center spline as short as possible, using caution to avoid nicking or cutting into the wires (Figs 2a, 2b). Inspect wire insulation to verify insulation integrity.

Figure 2a

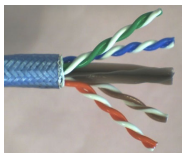
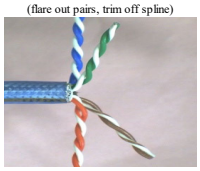


Figure 2b
(flare out pairs, trim off spline)



3) Arrange the wires into the desired configuration, and install the wires into the Load Bar (Figs 3a, 3b). If connector orientation is critical, then orient pairs prior to untwisting any pairs. If necessary, longer wires can be trimmed nearly as short as the shortest wire, to allow easier entry into the Load Bar. Position the Load Bar so that the front edge is 0.85" from Cut A (as shown). Trim off the end of the wires at Cut B (0.85" from Cut A, as shown). All wires should be trimmed evenly, and flush with the end of the Load Bar.

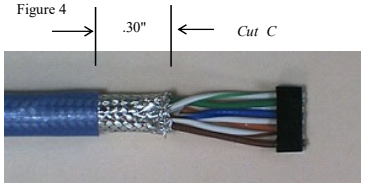
Figure 3a (568A shown)

Figure 3b

trim wires flush

4) Make Cut C (0.30" from Cut A) through the Jacket (Fig. 4). Do Not nick or cut into wire braids. Score the 0.30" section of Jacket lengthwise and remove the jacket only.

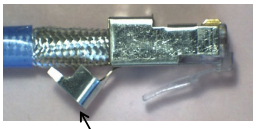
Figure 4



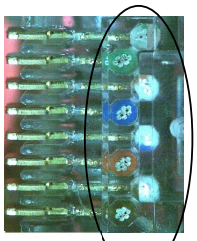
5) Bend the connector body strain relief tab down (Fig. 5a) to allow wires / load bar installation. With the load bar positioned at the end of the wires, install the connector body onto the wires / load bar (Fig. 5a). Seat all wires fully into the connector, until the stranded conductors of each wire are visible through the front end of the connector body (Fig. 5b).

Figure 5b (568A shown)

Figure 5a



Strain Relief Tab



ALL stranded wires visible

6) After verifying full insertion, ensure the exposed shield is aligned with the Metal Strain Relief as shown (Fig 6). Crimp the connector using PIC 110288 Crimp Tool.

7) Slide up the 1.375" piece of heat shrink to the back of the boot and shrink, ensuring heat is kept away from boot or it will deform and start to melt with too much heat (Fig 7).

8) Verify all wires are fully seated per 110361 Inspection Criteria below (Fig. 8).

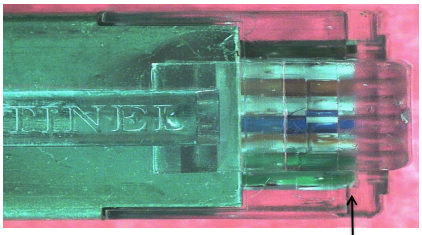


Figure 8

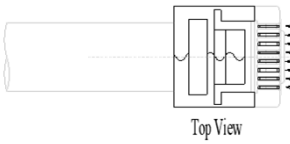
ALL wires fully seated

Figure 6

Figure 7

Latching Tab

RJ45 Wiring Configuration for 568A or 568B



Pin	568A Configuration	568B Configuration
1	White / Green	White / Orange
2	Green	Orange
3	White / Orange	White / Green
4	Blue	Blue
5	White / Blue	White / Blue
6	Orange	Green
7	White / Brown	White / Brown
8	Brown	Brown