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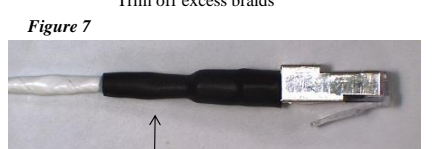
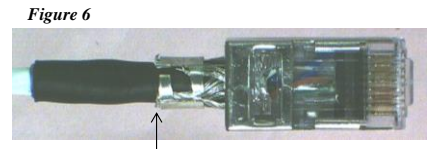
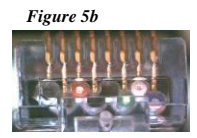
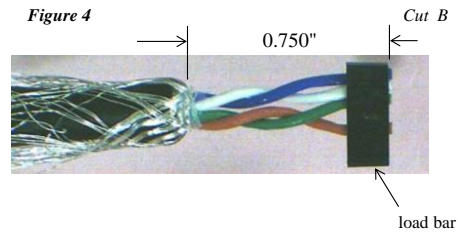
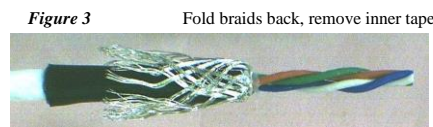
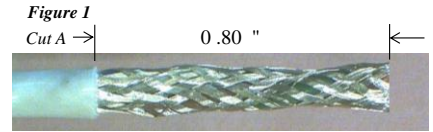
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Termination Instructions for PIC RJ45 Plug Connector P/N 110789
 (for PIC Ethernet Cable P/N E13426)

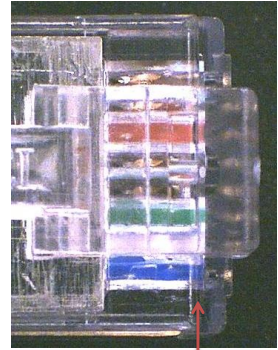
Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters, Magnifier
Required Tooling :	PIC 110288 RJ45 Crimp Tool, Heat Gun

Dimensions in Inches (NOT to Scale)

- 1) Install labels (if applicable). Install ATUM 8/2 x 1.375" then 8/2 x 1.0" dual wall shrink tube onto cable. Make Cut A @ .80" from cable end, through the cable jacket (Fig. 1). Do Not nick or cut into braids. Remove jacket.
- 2) Install and shrink the ATUM 8/2 x 1.0" dual wall shrink tube onto cable, starting at the end of jacket (Fig. 2). Fold braids back over ATUM, and trim off inner tape layer @ Cut A (Fig. 3). Do not nick or cut into the wire insulation; inspect wires to verify insulation integrity.
- 3) Untwist each pair, for approximately half of the stripped length, carefully straighten each wire. Align wires into desired wire configuration per work print, and install wires into the load bar (Fig. 4). Wire ends can be cut slightly shorter (up to .050") to aid entry into load bar.
- 4) Position the load bar front edge at .750" from Cut A (Fig 4). Trim off wire ends at Cut B, flush with the end of the load bar @ .750" from Cut A (Fig. 4).
- 5) Bend the RJ45 connector strain relief tab down to allow wires / load bar installation (Fig. 5a). With the load bar positioned at the end of the wires, install the connector body onto the wires / load bar. 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).
- 6) Return the strain relief tab up into original position. Verify all wires are fully seated per 110789-01 Inspection Criteria (below) before crimping. Crimp the connector using 110288 RJ45 crimp tool, keeping wires fully seated. Trim off excess braids past strain relief tab (Fig. 6).
- 7) Verify all wires are fully seated per 110789-01 Inspection Criteria. Use magnifier and contrasting color background to aid in inspection.
- 8) Slide the ATUM 8/2 x 1.375" shrink tube up to the back end of the RJ45 connector. Shrink the ATUM onto connector & cable (Fig. 7) while taking care to shield the RJ45 latching tab from excessive heat.



110789-01 Inspection Criteria



all wires fully seated

