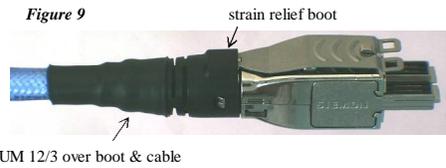
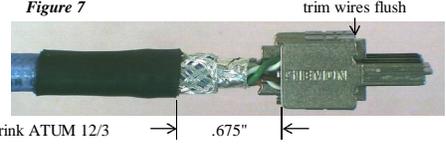
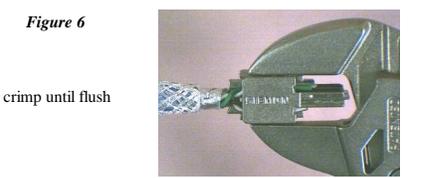
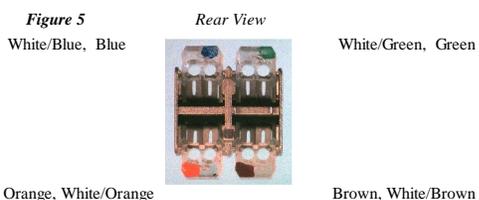
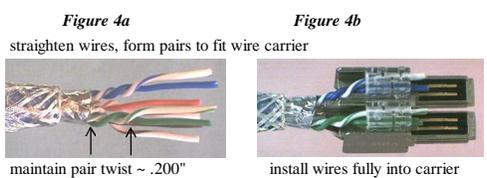
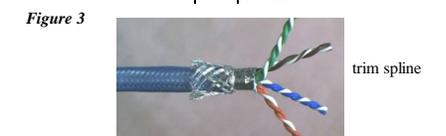
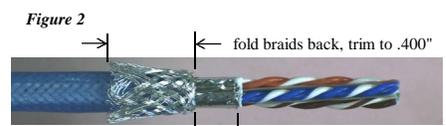
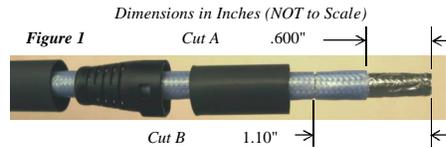


Termination Instructions for Tera Cat 7 4-Pair Plug Connector
 for E6A0824 / E6A2824 / E6A3824 / E50824 Ethernet Cables

Required Tooling: X-acto Knife, Sharp Razor, Small Diagonal Wire Cutters,
 Parallel Clamping Pliers (recommended) PIC P/N 110701 (see pic to right)
 Note : Adjustable Pliers may be used with caution.
 Heat Gun



- 1) Install an ATUM 12/3 x 1.0" dual wall shrink tube, the black strain relief boot, and remaining ATUM 12/3 x 1.0" shrink tube (Fig. 1) onto the cable. Make Cut A @ .600" from the end of the cable through the jacket. Remove jacket and wire braids (Fig. 1).
- 2) Make Cut B @ 1.10" from the end of the cable, scoring the jacket (Fig. 1). Do not nick or cut into wire braids.
- 3) Remove jacket at Cut B, flare out the wire braids and partially comb out. Fold the braids back over until laying flat on the jacket (Fig. 2). Trim braids to .400" length (Fig. 2).
- 4) Carefully score and remove foil @ .200" from end of braids (Fig. 2). Trim off teflon tape just past the end of foil. Do Not nick or cut into wire insulation. Inspect to verify insulation integrity on all wires.
- 5) Flare out the wire pairs, and trim off cable spline between pairs, as short as possible (Fig 3). Do Not nick or cut into wire insulation. Inspect to verify insulation integrity on wires.
- 6) Separate and straighten pairs for installation into the wire carrier, while maintaining pair twist where wires exit the foil/tape section (Fig. 4a). Form the wires to fit the spacing and wiring configuration per the color code markings on the wire carrier (Fig. 5). Wire ends can be trimmed off by .050" nominal length, to improve straightening and wire entry.
- 7) Install the pairs into the wire carrier per the color code on wire carrier (Fig. 4b). To aid wire entry, it may help to start insertion of all upper wires (Green & Blue pairs) and then insert lower pairs (Orange & Brown). Seat the cable firmly, maintaining pairs' twist between the cable exit and the wire carrier (Fig. 4b).
- 8) Adjust the parallel clamping pliers height to crimp squarely on wire carriers (Fig. 6). Keeping pairs firmly seated in the wire carrier (wire transition as short as possible), crimp wire carriers onto the contacts until flush with the connector shell (Fig. 6). Adjust the clamping pliers height as needed. *Regular adjustable pliers may suffice, if used with caution.*
- 9) Trim off wire ends flush with the end of the wire carrier; trimmed wire ends must not extend more than .030" beyond the front of the wire carrier (Fig. 7). Diagonal wire cutters must be small enough to trim wire ends on the inside corners.
- 10) Locate the ATUM 12/3 shrink tube over braids @ .675" from the connector shell, to capture all braid ends (Fig. 7), and shrink onto wire braids and cable. Use caution to avoid excessive heat on the connector. Inspect for any stray braids or debris, clean as needed prior to installing connector covers.
- 11) Install covers onto the connector shell until they snap into place. The latch clip must be located on top, over the Blue and Green pairs (Fig. 8).
- 12) Position the black strain relief boot onto the rear of the connector covers, until it snaps into place (Fig. 9). Note orientation of the boot to properly fit the rear end of the latch clip component (Figs. 8 & 9).
- 13) Locate the remaining ATUM 12/3 shrink tube onto the boot, and shrink onto the boot and cable. Use heat sparingly to avoid damage to the plastic boot (Fig. 9).



Note: Connector Length added to cable = + .330" nominal