

PIC Wire & Cable

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Termination Instructions

T-110813

Approved : *TW*
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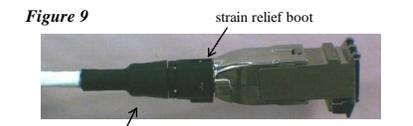
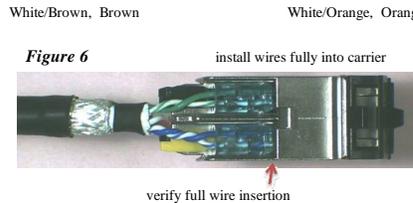
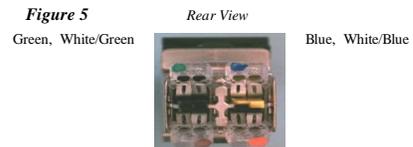
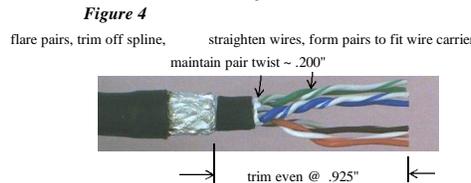
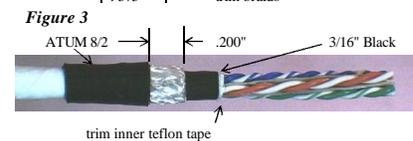
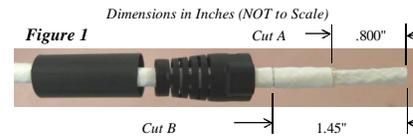
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Termination Instructions for Tera 4-Pair Cat 7 Panel Jack Connector for PIC P/N E6A3826 Ethernet Cable

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 ATUM 12/3 x 1.0" dual wall shrink tube, and black strain relief boot, small end first (Fig. 1). Make Cut A @ .800" from the end of the cable, through the jacket. Remove jacket and wire braids (Fig. 1).
- 2) Make Cut B @ 1.45" 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 .375" length (Fig. 2).
- 4) Install and shrink the ATUM 8/2 x .400" dual wall shrink tube, starting @ .200" from Cut B (Fig. 3) to capture all braid ends. Install Sumitomo B2-3/16"-Black x .200" shrink tube, and shrink onto inner teflon tape layer, starting up against braids (Fig. 3). Trim off inner teflon tape layer, just past 3/16" black shrink (Fig. 3).
- 5) Flare out the wire pairs, and trim off cable spline between pairs, as short as possible. 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 teflon tape layer (Fig. 4). Any crossing of pairs should occur right at the cable exit (Fig. 4). 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 squarely by .050" nominal length, to improve straightening and wire entry. With wires formed to match wire carrier (Figs. 5 & 6), trim all wires even @ .925" from front end of braids (Fig. 4).
- 7) Install the pairs into the wire carrier per the color code on wire carrier (Fig. 5). To aid wire entry, it may help to start insertion of all upper wires (Green & Blue pairs) and then insert lower pairs (Orange & Brown), or vice versa. Seat the cable firmly, maintaining pairs' twist between the cable exit and the wire carrier (Fig. 6). Inspect each wire to verify full insertion in each wire carrier cavity (Fig. 6).
- 8) Adjust the parallel clamping pliers height to crimp squarely on wire carriers (Fig. 7). 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. 7). Adjust the clamping pliers height as needed. *Regular adjustable pliers may suffice, if used with caution.*
- 9) Inspect for any stray braids or debris, clean as needed prior to installing connector covers. Install covers onto the connector shell until they snap into place (Fig. 8).
- 10) 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 slot onto the covers' rear end keying feature (Fig. 9).
- 11) Locate the 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 = + .100" nominal

Shrink ATUM 12/3 over boot & cable