

AI85146-01

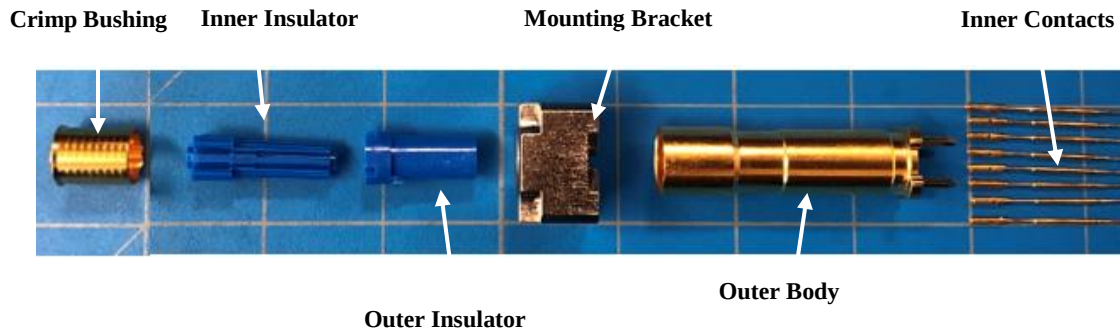
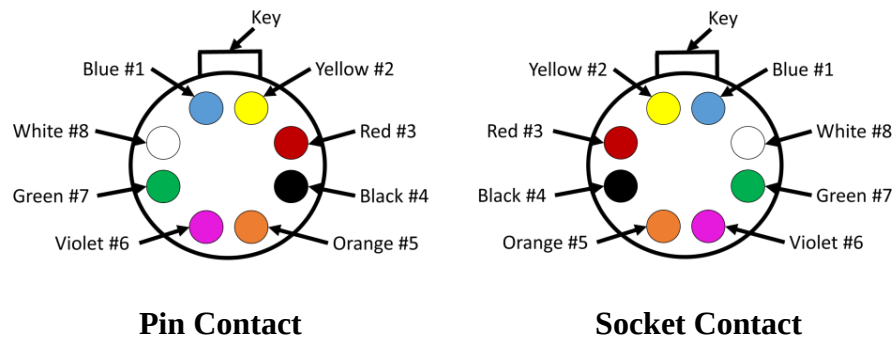
Revision History

Rev	Date	Initiated By	Approved
1	11/08/19	WLL	GH

Tools needed:

- M22520/2-01 AFM8 w/K1906 Crimper & Positioner
- M22520/5-01 Hex Crimp Tool w/859-186 Die

Twisted Pair Color Orientation of Cable



Procedure

Step 1:

Cut cable end cleanly at right angle to the cable axis with circular cable cutter. Remove cable jacket (1.00") to expose the braid shield.



Step 2:

Fold cable braid back and remove outer Teflon wrap.



Step 3:

Mark Teflon wrapped pairs (0.200") away from jacket per **Figure 15**. Trim Teflon and braid to mark per **Figure 16**. **Do not** cut the drain wire inside of foil.



Figure 15

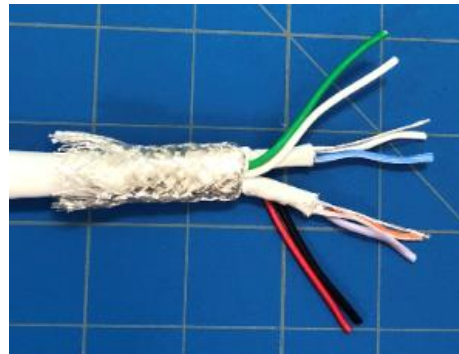


Figure 16

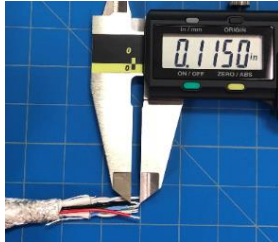
Step 3:

Trim conductors (0.500") away from jacket. **Do not** trim drain wires from twisted pairs.



Step 4:

Identify cable twisted pair color orientation to match **Figure 1**. Remove insulation of conductors to (0.115"). **Red and black conductors are 24 awg and use the larger inner contacts.** Install larger inner contacts over the red and black conductors. Install remaining inner contacts over other conductors. Make sure the conductor is visible through the inspection hole. Crimp the red and black inner contacts using crimp tool **M22520/2-01** and positioner **Daniels P/N K1906**, Setting #4 for 24 AWG. Crimp the other inner contacts using crimp tool **M22520/2-01** and positioner **Daniels P/N K1906**, Setting #3 for 26 AWG.



Step 5:

Slide crimp ferrule over all braid, conductors, and drain wires until it bottoms out on cable jacket. Fold braid and drain wires back over ferrule and trim excess.



Step 6:

When connecting to a Pin Ochito use **Figure 1** pinout. When connecting to a Socket Ochito use **Figure 2**. When connecting two 858-025 Ochito's back to back use **Figure 1** and **Figure 2**. Slide the inner insulator into middle of inner contacts. Pay attention to the orientation of the wires. Snap the contacts in place of the insulator slot cavities.

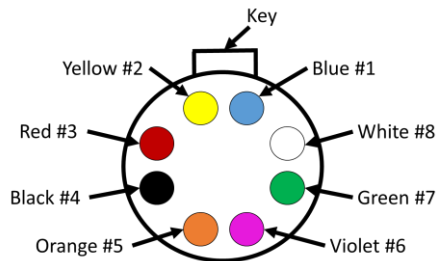


Figure 1

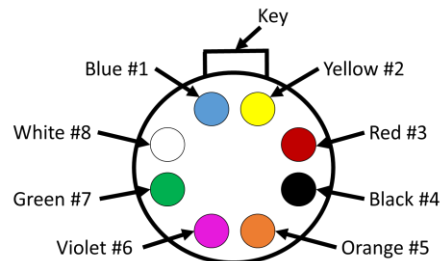


Figure 2

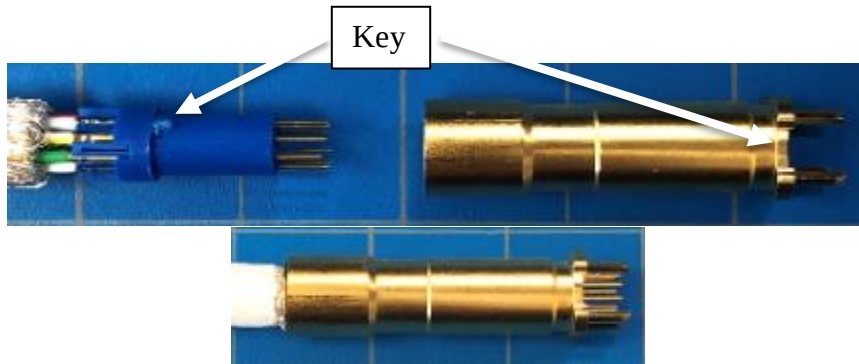


Step 7:

Slide outer insulator over inner insulator. Place the outer insulator key in the orientation with the color code as shown on **Figure 1** and **Figure 2**. Push the outer insulator in until outer and inner tabs nest together. Slide mounting bracket over assembly. Ensure the nesting face is towards the contact assembly.

**Step 8:**

When inserting assembly into contact body ensure the internal key way lines up with the external key on the outer insulator. After insertion the crimp ferrel should be completely inside contact body.

**Step 9:**

Use crimp tool **Daniels HX4 M22520/5-01** with die **859-186**. Load contact assembly into die. Ensure the entire crimp area is covered by the die, crimp contact.

