



**AI85048-01**

## **Assembly Instruction**

# **EL OCHITO WHITE CONTACTS**

**1000BASE-T/10GBASE-T**

**TYPE I: PIN 858-003-01/SKT 858-004-01**

**CABLE 963-003-26 S/UTP**

### **Revision History**

<b>Rev</b>	<b>Date</b>	<b>Initiated By</b>	<b>Approved</b>
1	06/26/18	WLL	GH

### **1.0 Tools**

Tools are to be suitable for the purpose intended and shall not cause damage to the parts. Examine all elements of tools and equipment.

## 1.1 Related Tools and Equipment

- M22520/2-01 AFM8 Crimper & Positioner or Equivalent.
- M22520/5-01 Hex Crimp Tool w/ Y143 Die



*Figure 1*



*Figure 2*

- 600-235 & 600-236 Alignment Tools



*Figure 3*

- 600-242 Insert Tool



*Figure 4*

- Cable Cutter, Exacto Knife, Tweezer, Wire Cutter, Caliper



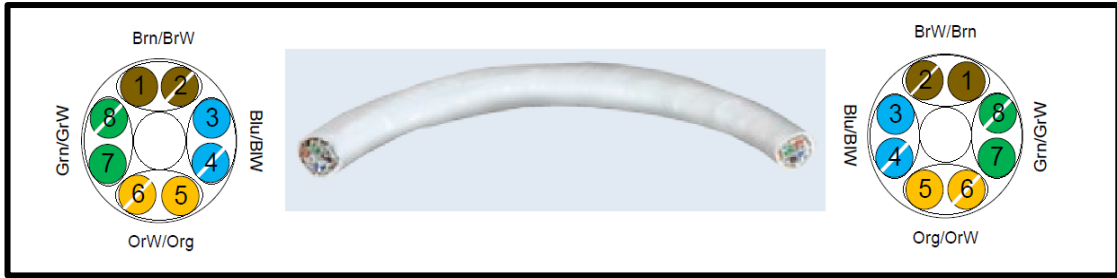
*Figure 5*

- Hot Tweezers



*Figure 6*

- **Twisted Pair Color Orientation of Cable**

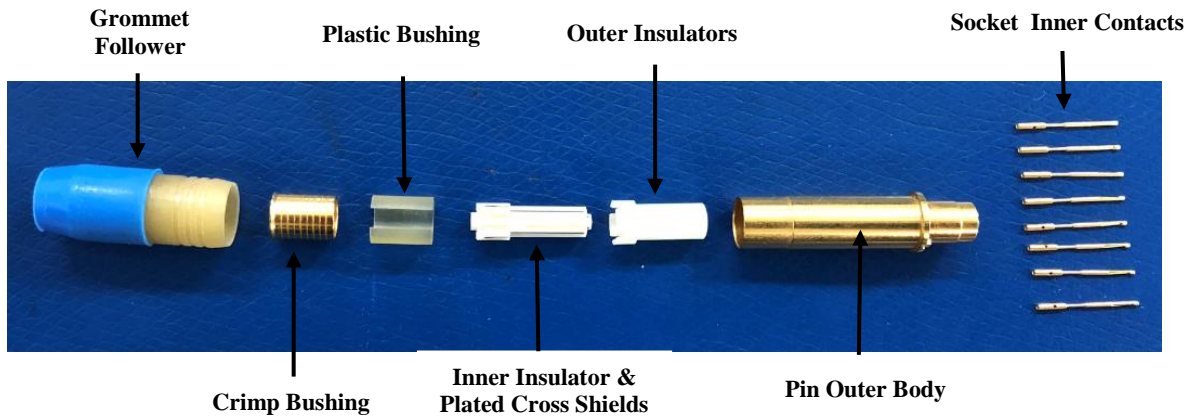


**Cable Layout for Pin Contact  
858-003-01**

**Cable Layout for Socket Contact  
858-004-01**

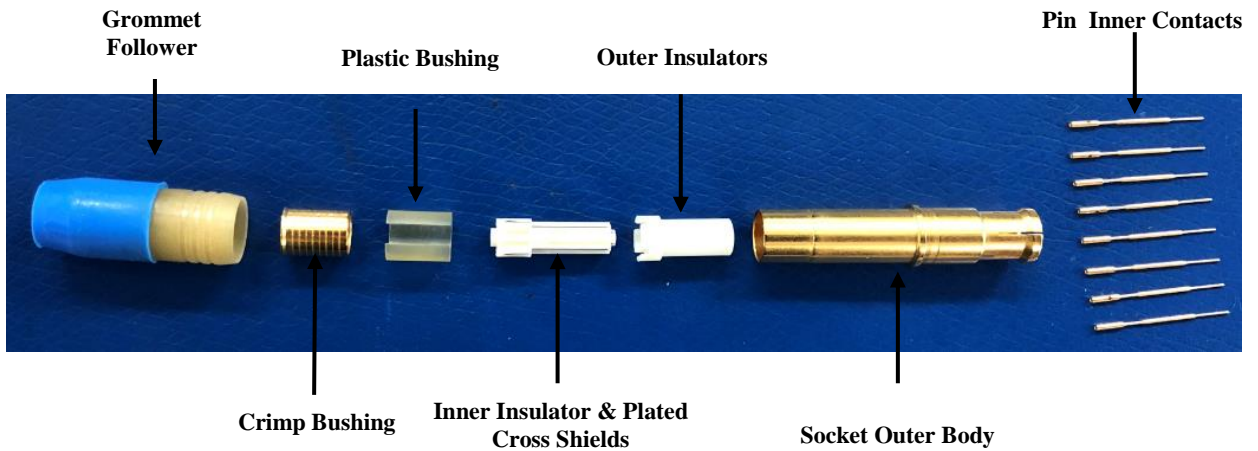
*Figure 7*

- **Pin Contact Part Number 858-003-01**



*Figure 8*

- **Socket Contact Part Number 858-004-01**



*Figure 9*

## 2.0 Procedure

### Step 1: Grommet Follower

Slide grommet follower onto cable. Cable ends must be cut cleanly and at right angle to the cable axis with circular cable cutter.



*Figure 10*

### Step 2: Cable Jacket Removed

Remove cable jacket (0.720") to expose the braid shield.



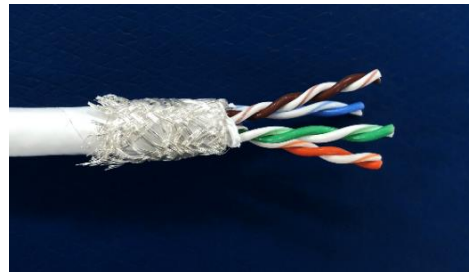
*Figure 11*

### Step 3: Center Conductor Removed

Flare cable braid to expose the inner bundle per Figure 12. Remove inner wrap and flare wire bundle away from center filler. Trim the center filler as close to jacket as possible per Figure 13.



*Figure 12*



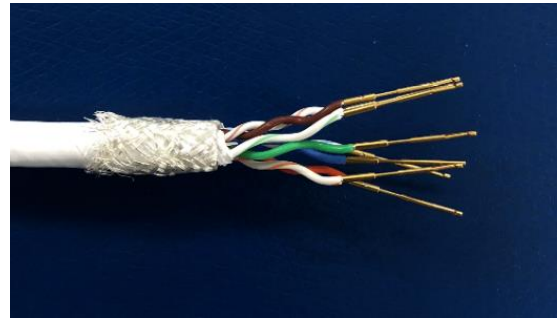
*Figure 13*

#### Step 4: Crimp Conductors

Identify cable twisted pair color orientation to match **Figure 7** for Pin or Socket contacts. Remove insulation of the conductors to 0.115" per **Figure 14**. Install inner contacts (8X) over conductor until fully seated. Make sure the conductor is visible through the inspection hole. Crimp the inner contacts using crimp tool **M22520/2-01** and positioner **Daniels P/N K1906 (Glenair P/N 859-101)**, Setting #3 for 26 AWG.



*Figure 14*



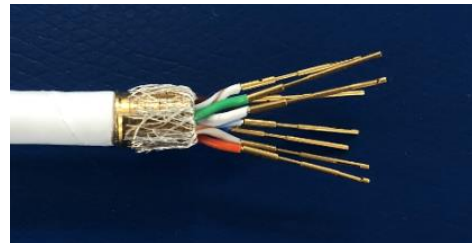
*Figure 15*

#### Step 5: Crimp Bushing

Slide crimp bushing over the cable braid until it bottoms out on the cable jacket. Comb braid out and fold back. Trim braid just short of the crimp bushing.



*Figure 16*



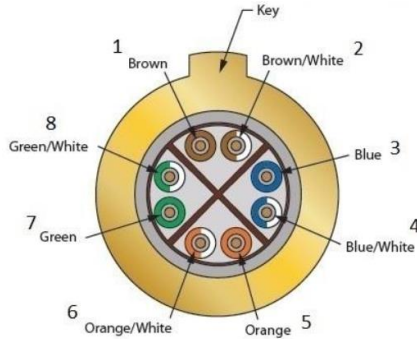
*Figure 17*



## Step 6: Loading Contacts into Insulator for Pin Contact Part Number 858-003-01

Identify the wire colors (See below for recommended color code as shown in **Figure 18**). Slide the inner insulator (with cross shields) into middle of inner contacts. Pay attention to the orientation of the wires. Snap the contacts in place of the insulator slot cavities.

**Note:** The twisted pairs are essentially parallel to the axis of the bundle with no crossover.



**Figure 18**

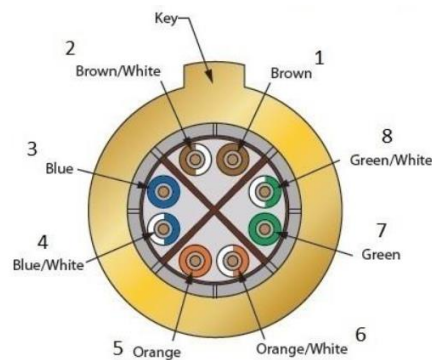


**Figure 19**

## Step 7: Loading Contacts into Insulator for Socket Contact Part Number 858-004-01

Identify the wire colors (See below for recommended color code as shown in **Figure 20**). Slide the inner insulator (with cross shields) into middle of inner contacts. Pay attention to the orientation of the wires. Snap the contacts in place of the insulator slot cavities.

**Note:** The twisted pairs are essentially parallel to the axis of the bundle with no crossover.



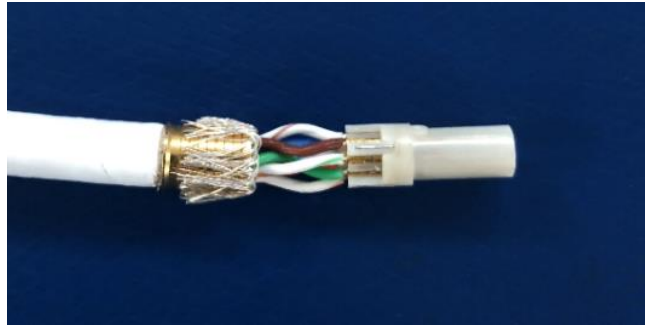
**Figure 20**



**Figure 21**

### Step 8: Install Outer Insulator

Slide outer insulator over inner insulator. Place the outer insulator such as its key is in orientation with color code as shown in **Figure 18 & Figure 20**. Push the outer insulator in until outer and inner tabs nest together.



*Figure 22*

### Step 9: Plastic Bushing Installed

Slide plastic bushing over outer insulator. Squeeze the plastic bushing down below the 4 tabs of inner insulator. Push the crimp bushing forward such that the plastic bushing has a very tight space against the inner insulator and crimp bushing.

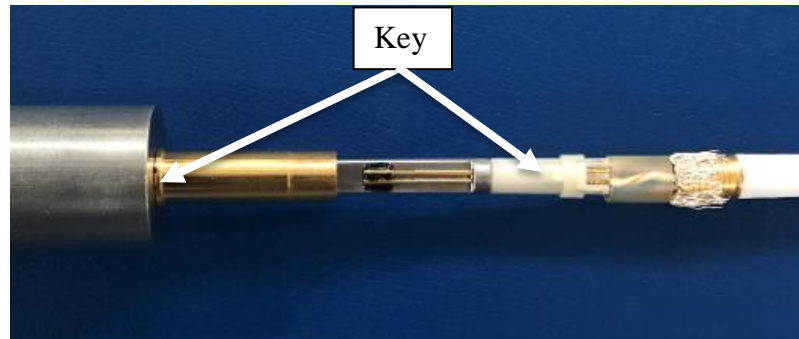


*Figure 23*

**Inspection Step:** the gap between the plastic bushing and the adjacent component shall be less than 0.010”.

### Step 10: Outer Body Installed

Install outer shell body in tool **600-235** or **600-236**. Ensure the male polarization key of the shell is engaged into the female key locator on the tool. Mate tool into cable assembly. Ensure the polarization key of the outer insulator is lined up with the polarization key of the shell body per **Figure 24**. Use insert tool **600-242** to slide cable assembly into shell body using **600-235** or **600-236** as a guide per **Figure 25**. Ensure crimp bushing is fully seated.



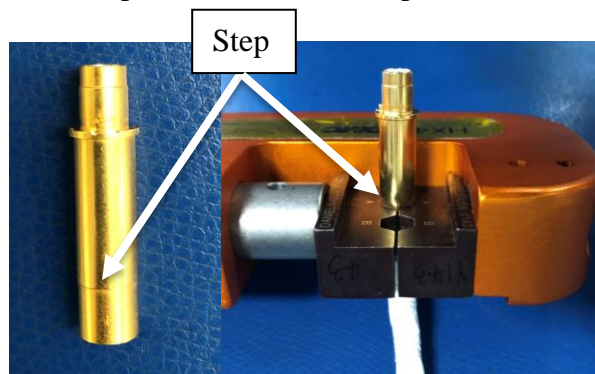
*Figure 24*



*Figure 25*

### Step 11: Crimp Outer Body

Use crimp tool **Daniels HX4 M22520/5-01** with die **Y143**. Load contact assembly into side A. Locate the step at the back of the contact. Ensure the step is flush with the top face of the die, crimp contact.



*Figure 26*