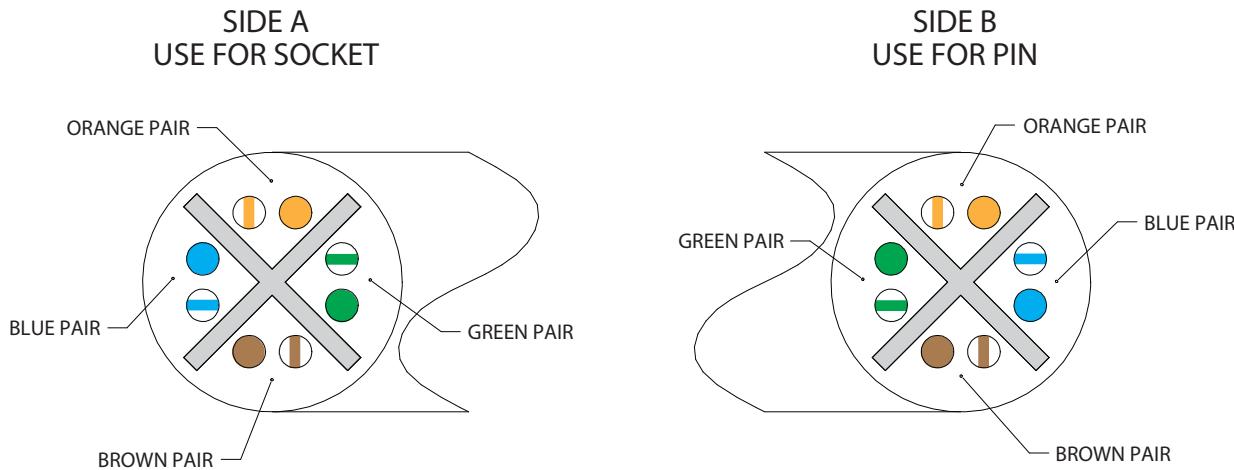


SPEEDMASTER Assembly Instructions



AI85082 SpeedMaster™ Contact Module Assembly Instructions



BEFORE BEGINNING ASSEMBLY

Verify the arrangement of wire colors in the cable to determine which side to use.

STEP 1

- Place o-ring onto thread ferrule so that it is seated behind the thread. (Figure 1)
- Slide retention ferrule with o-ring onto cable.

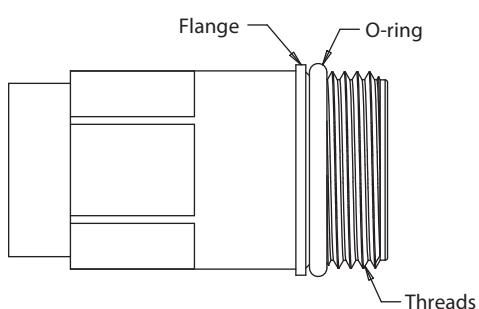


FIGURE 1

STEP 2

- Slide shield ferrule onto cable.
- Use proper tool to remove cable outer jacket to approximately 0.75 Inch.
- Comb braid out straight, and trim it to approximately .375 Inches. Fold braid back afterward.
- Trim outer tape, cable splice, and filler if any as close to the folded back braid shield as possible. (Figure 2)
- Use appropriate tool to strip the individual wires to .115 Inches max.

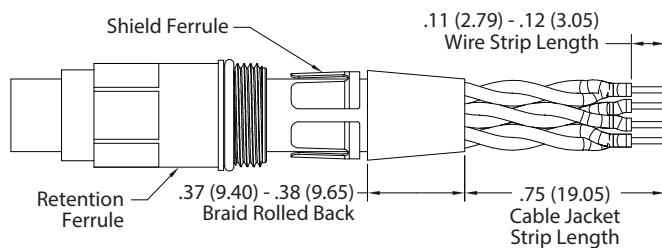


FIGURE 2

SPEEDMASTER Assembly Instructions



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STEP 3

Maintain twist of pairs as best as possible. If needed – undo half a twist, do not over twist

A. Crimp contacts onto each individual wire using:

- Crimp tool M22520/2-01 (Glenair PN 809-015)
- Positioner M22520/2-06 (Glenair PN 859-019) for sockets
- Positioner M22520/2-09 (Glenair PN 859-018) for pins

*There should be no exposed conductor behind the crimp barrel

B. Insert each pair of wires into the appropriate quadrant on the isolator according to figure 3 for socket modules, and figure 4 for pin modules.

NOTES:

- Crossing of pairs is not recommended. (cables should only be terminated as pin to socket).
- Assembly instructions use socket module (858-100) for illustrations. Pin module (858-101) is assembled in the same fashion.

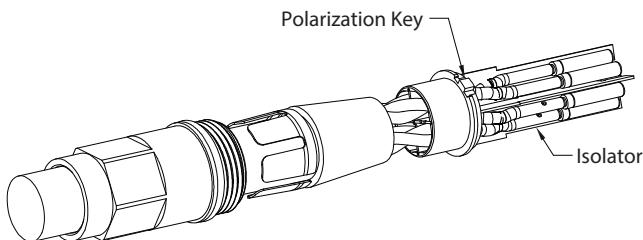


FIGURE 3

SOCKET MODULE PIN-OUT
FROM FRONT

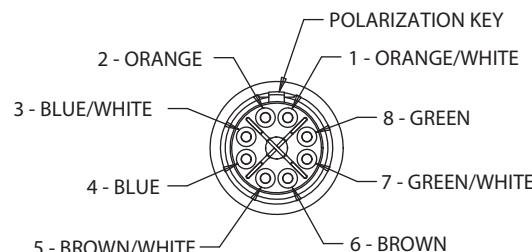
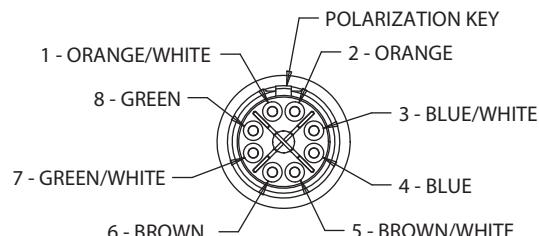


FIGURE 4

PIN MODULE PIN-OUT
FROM FRONT



STEP 4

- Push the cable all the way into the isolator so the wire pairs can be spread out easily
- Move the wires/contacts out of the way and insert the inner insulator on the isolator. Slide the inner insulator all the way onto the isolator.
- Snap each contact into the appropriate position on the inner insulator. Refer to figure 3 for sockets and figure 4 for pins.

Notes:

- Be sure to maintain twist of each pair as close to the insulator as possible to improve signal. Do not over twist

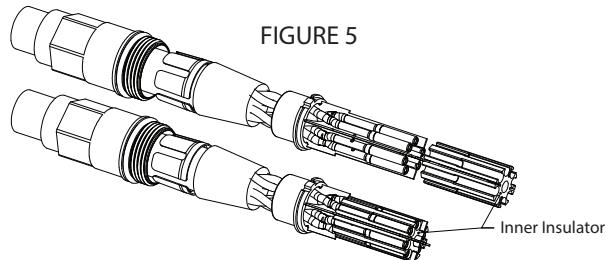


FIGURE 5

SPEEDMASTER Assembly Instructions



AI85082 SpeedMaster™ Contact Module Assembly Instructions

STEP 5

- A. Slide outer insulator onto module assembly. Be sure to align the slots/fins and polarization keys. (Figure 6 and 7)
- B. Fold braid shield forward onto termination zone. (Figure 7)
- C. Slide shield ferrule forward to the main shoulder, then slide the retention ferrule over it. (Figure 8)
- D. Trim excessive braid to behind main shoulder. (Figure 8)

