**AI85110-P**

**Revision History**

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**Tools needed:**

- M22520/2-01 AFM8 w/K1906 Crimper & Positioner
- GS206 w/859-184-2, 859-184-3 Positioners
- 600-235 Alignment Tool
- 600-242 Insert Tool

**Twisted Pair Color Orientation of Cable**

*Figure 1*

**Cable Layout for Pin Contact 858-016-02**

**Procedure**

**Step 1:**
Slide grommet follower over jacket. Cable ends must be cut cleanly and at right angle to the cable axis with circular cable cutter.
Step 2:
Remove cable jacket (0.720”) to expose the braid shield.

Step 3:
Flare cable braid to expose the twisted pair wires with aluminum foil shields. Flare wire bundle with aluminum foil shields and trim the middle filler as close to the jacket as possible.

Step 4:
Identify cable twisted pair color orientation to match Figure 1. Unwrap foil around one pair. Remove insulation of the conductors to (0.115”). Install inner contacts 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, Setting #3 for 26 AWG. Re-wrap foil tightly around the wire pair. Use Kapton tape to hold the foil in place. Trim excess tape and foil to expose wire insulator. No more than 0.100” of insulator should be exposed. Ensure foil does not cover base of contact.

Step 5:
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.
Step 6:  
Identify the wire colors. 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 2](image)

Step 7:  
Slide outer insulator over inner insulator. Place the outer insulator such as its key is in orientation with color code as shown in Figure 2. Push the outer insulator in until outer and inner tabs nest together.

![Step 7](image)

Step 8:  
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. Trim braid just short of the crimp bushing.

![Step 8](image)

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

![Inspection Step](image)
Step 9:
Install outer shell body in tool 600-235. 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 3. Use insert tool 600-242 to slide cable assembly into shell body using 600-235 as a guide per Figure 4. Ensure crimp bushing is fully seated and the blue stripe is no longer visible.

![Figure 3](image1.png)

![Figure 4](image2.png)

Step 10:
Install depth locator 859-184-3 on crimp tool GS206. Load the contact assembly into the crimp tool Daniels GS206 until it bottoms out. Crimp the barrel first per Figure 5 & 6. Remove depth locator 859-184-3 and install 859-184-2. Rotate the contact assembly 45° and repeat crimping process per Figure 7 & 8. After crimping, the diameter of crimped barrel must not be greater than .270”.

![Figure 5](image3.png) ![Figure 6](image4.png)

![Figure 7](image5.png) ![Figure 8](image6.png)