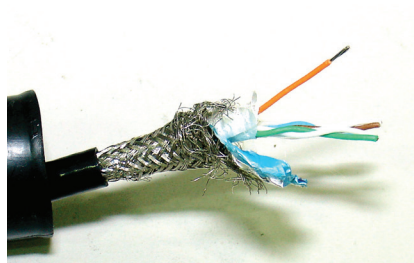
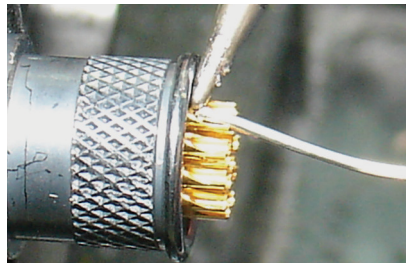


RECOMMENDED SOLDER EQUIPMENT

- JBC soldering iron AD2700 set at approx. 662°F (350°C)
- JBC tip 2245-930
- Should adhere to IPC J-STD-001 Rev D Class 3, using IPC 610 for reference.

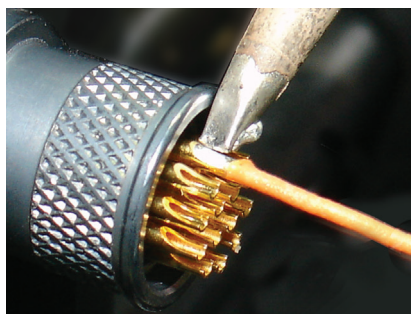


STEP 1: Slide the rear accessories over the wire bundle in the proper sequence for reassembly.

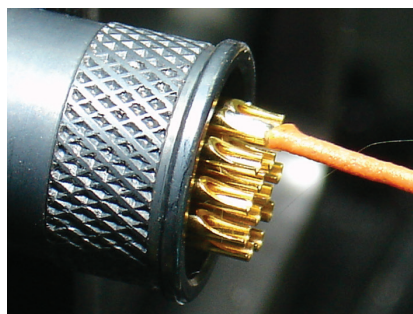


STEP 2: Strip wires .200" (5.08).

STEP 3: Pre-tin wire to be terminated.



STEP 4: Pre-tin the solder bucket. This should be done using the minimum temperature required while achieving the wetted solder joint. Remember to ensure a good solder bridge. Place the iron tip inside the bucket.



STEP 5: Terminate wire to the solder bucket, again using minimum heat while ensuring the required wetting. Place the iron tip inside the bucket and slide in the wire to be terminated. Always clean solder joints, ensuring that the contacts are not damaged.

STEP 6: Repeat steps for additional contacts. Terminate shield using banding termination or other method. Recover heat shrink boot starting on the connector and moving downward towards the cable. Adhesive should flow out of the boot.

ETHERNET WIRING



Rear view of connector

Termination process for 07-14 layout to CAT 6 Ethernet Cable

- Standard CAT 6 Ethernet RJ45 Patch lead terminated to the rear of the connector, as per instructions

Temperatures are °F (°C). All Dimensions in inches (millimeters in parenthesis).