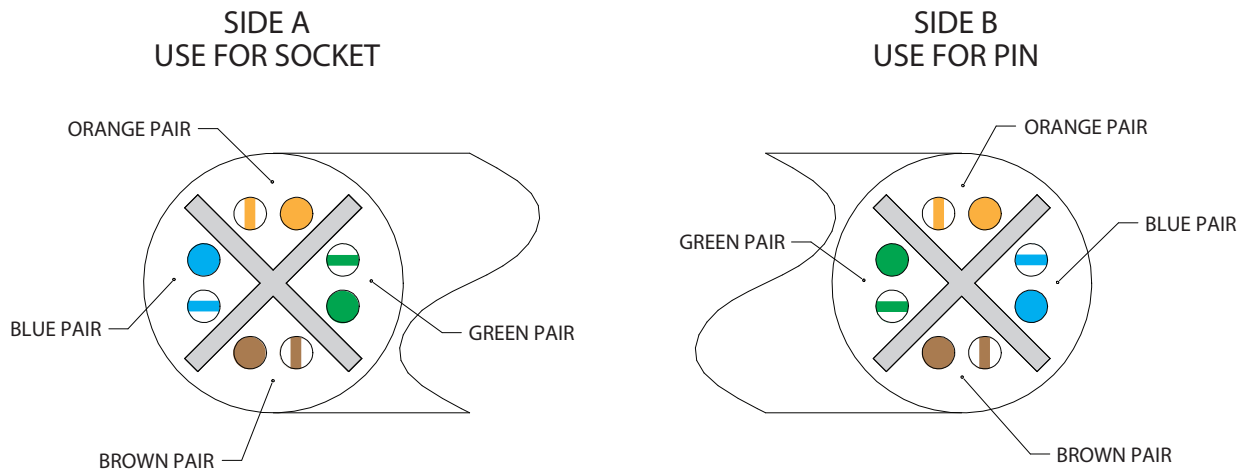


AI85082 SpeedMaster™ Contact Module Assembly Instructions



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

STEP 1

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

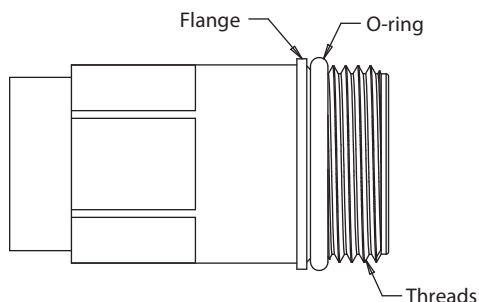


FIGURE 1

STEP 2

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

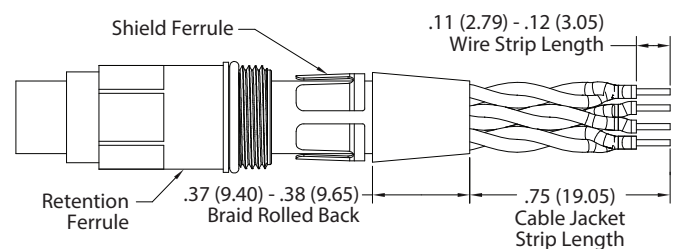


FIGURE 2

AI85082 SpeedMaster™ Contact Module Assembly Instructions

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.

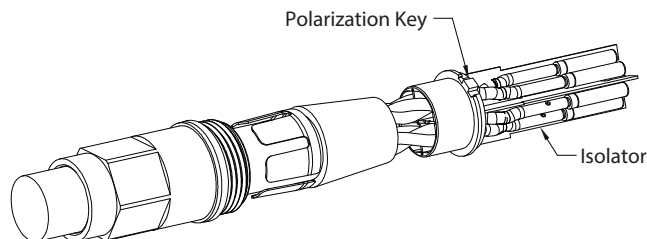


FIGURE 3
SOCKET MODULE PIN-OUT
FROM FRONT

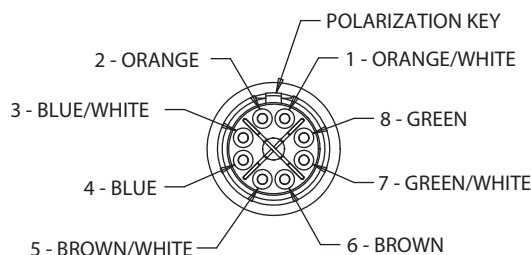
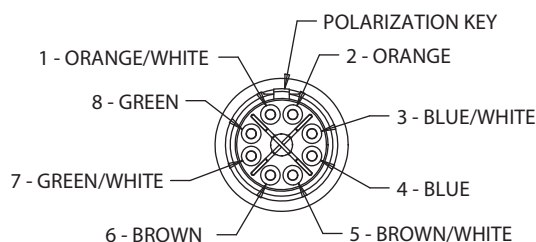


FIGURE 4
PIN MODULE PIN-OUT
FROM FRONT



STEP 4

A. Push the cable all the way into the isolator so the wire pairs can be spread out easily

B. 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.

C. 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

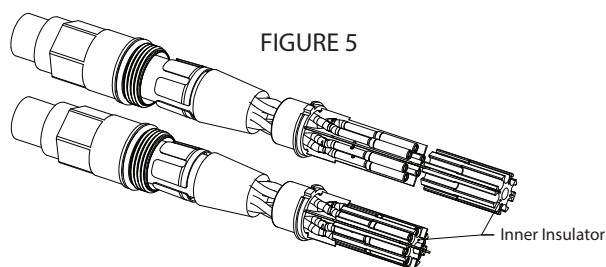


FIGURE 5

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)

