

Assembly Guidance---3E S



Ningbo Excellence Communicated Connector Co., Ltd.

C6R5Z50V2SIL-3E Assebmlly Guidance

CONFIDENTIAL



Assembly Guidance---3E S

1、 3E Plug+C6A SSTP Cable

1.1 Insert 1 1.2 Insert shell up 1.3 Insert shell down

1.3 plug

2、 Items indication:

2.1 “Plug”—C6R5Z50V2SIL-3E;

2.2 “Insert 1”—8 wires in line to ensure the stability of wires;

2.3“Cross insert” —Insert shell up, Insert shell down ;

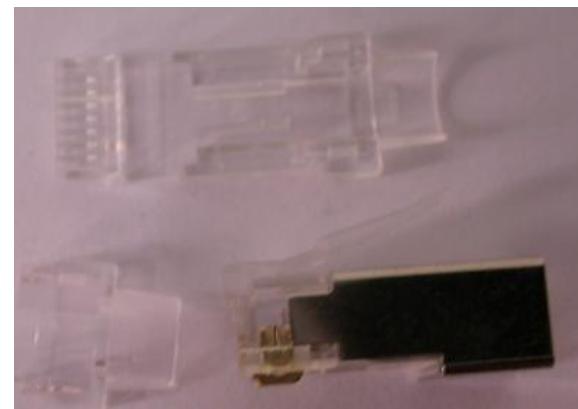
2.4 “Cable”—Cat.6A SSTP;

2.5 “Wire pairs”—4 pairs of cable;

2.6“ Foil” —Each pair has been wrapped by the foil;

2.7 “Braiding” —4 paris wrapped overall by braiding.

1. plug with 4 parts



2. CAT6A SSTP



CONFIDENTIAL

EXW

Assembly Guidance---3E S

1、 Making patch cord

1.Wire cutting:

1.1 The wire length need to add 100mm as tolerance, for reworking 2 times if any defective.

1.2 When we arrange the wire, the inner OD is between 120-190MM (Pic. ①)

(The inner OD is depends on the spec. of the cable.)

1.3 The cable tie need to rotate 3 times, refer to Pic. 2 (Pic. ②)

1.Wire cutting
120-190MM



CONFIDENTIAL



Assembly Guidance---3E S

2、 Jacket Stripping

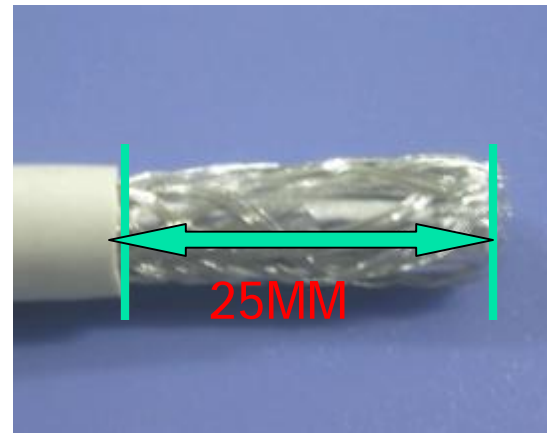
2.1 Using stripping machine to remove the jacket, and remove jacket length is 25MM (Pic.①)

2.2 To ensure all the wires no hurt in the insulation, and the length is 25MM, the cutting must be neatly。 (Pic. ②)

2.Strip the jacket



①



②

CONFIDENTIAL

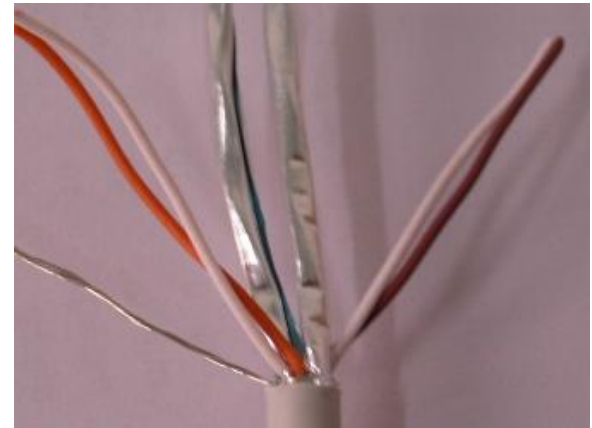
EXW

Assembly Guidance---3E S

3、 Remove Foil

3.1 Use knife to cut the foil, first wh-or, or, wh-br, br, then arrange the braiding as one wire and put besides the wh-or pair. (Pic. 1 , 2)

3. Remove Foil



CONFIDENTIAL

EXW

Assembly Guidance---3E S

4、 Assembly insert shell down

4.1 Arrange the wire as 568B or 568A.: (Pic. ①)

568B: wh-or, or, wh-gr, blue, wh-bl, gr, wh-br, br

568A: wh-gr, gr, wh-or, blue, wh-bl, or, wh-br, br.

4.2 Use scissors to cut the foil of wh-gr, gr, wh-bl, bl up to the insert, ensure not to hurt the insulation (Pic. ② ③)

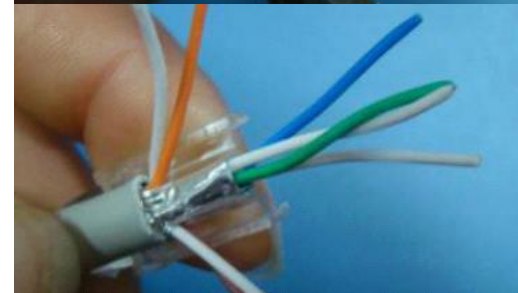
4. Put insert shell down



①



②



③

CONFIDENTIAL

EXW

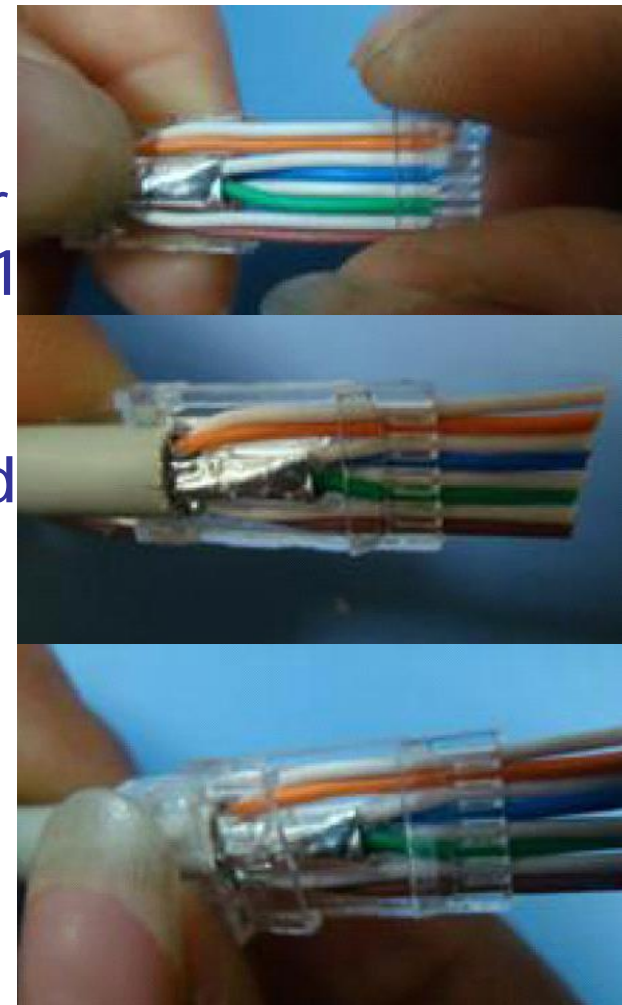
Assembly Guidance---3E S

5、 Put insert 1、 insert shell up

5.1 Left hand fix the insert shell down, right hand arrange the wire as 568B or 568A, then put the 8 wires into insert 1 (Pic. ① ②)

5.2 Put the insert to the right position, and then check the wire map is correct or not. (Pic. ②)

5.3 Put the insert shell up into the insert shell down, and fix it. (Pic. ③)



CONFIDENTIAL

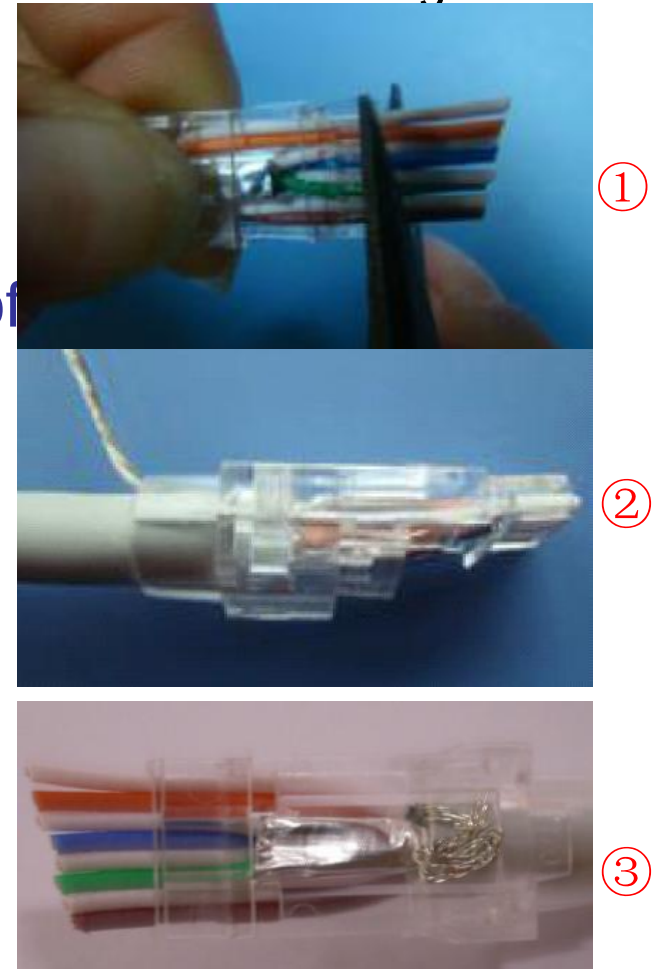
EXW

Assembly Guidance---3E S

6、Cutting wires

6.1 Use scissors to cut the wire on the top of insert1, and re-check the wire map is correct. (Pic. ① ② ③)

6. Wire cutting



CONFIDENTIAL

EXW

Assembly Guidance---3E S

7、 Assembly Plug

7.1 Put the insert into the plug, and ensure the insert in right position. (Pic.①)

7. Plug assembly



CONFIDENTIAL

EXW

Assembly Guidance---3E S

8、 Plug crimping

8.1 Before crimping, check the wire is in right position. (Pic. ①)

8.2 Put the plug into the crimping machine, and check the height based on FCC standard. $H=6.02 \pm 0.13\text{MM}$

Remarks: EXW standard=6.00 –6.10

8.3 After crimping, check the plug and shielded without any hurts.

8. Plug crimping



①

CONFIDENTIAL

EXW