

- 1. Cat.6 patchcord includes :
- 1.1 Modular Plug.
- 1.2 Loading Bar.
- 1.3 Cat.6 Cable with "Cross".
- 2. Terminology
- 2.1 "Plug"- the Cat.6 modular Plug (long body).
- 2.2 "Loading Bar"- the Cat.6 loading bar is to fix the wire position and improve assembly stability.
- 2.3 "Cable"- the Cat.6 cable.
- 2.4 "Wire"- the twisted pairs inside the cable.
- 2.5 "Cross"- the PE Cross inside the cable.

Modular Plug & Loading Bar

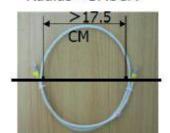


Cat.6 Cable with "Cross"



- 1. Cable Cutting
- 1.1 10cm more length is needed when cutting the cable. The 10cm is for plug assembly and rework once.
- 1.2 After arrangement, the cable radius must be larger than 17.5cm to avoid the damage of the wires inside the cable.
- 1.3 Cable tie- tied the cable for one rotation only.

Radius >17.5CM



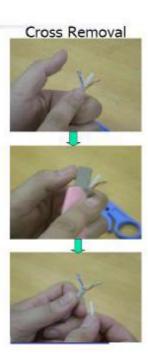
Tied the cable for one rotation only



- 2. Cable Jacket Removal
- 2.1 Use machine or hand tool to remove cable jacket. The wires inside the cable can not be damaged. The wire length outside the cable is 22mm after jacket removal.
- 2.2 All the actions have to be very careful not to damage the wires.

Jacket removal

- 3. Cross Removal
- 3.1 Open the 4 twisted pairs before Cross removal. The wires can not be bended for more than 90 degree.
- 3.2 Use sharp pocket knife to removal the Cross. Cut the one side of Cross first(50%), then cut the other side of Cross(100%). The length of Cross removal is the same as Jacket removal (22mm).



- 4. Untwist the Wire
- 4.1 For SUNF PU UTP CAT.6, Green/Blue pairs untwist twice (rotate 360 degree). Orange/Brown pairs untwist once (rotate 180 degree).
- 4.2 The wires can not be bended for more than 90 degree.
- 5. Wire pre-cutting
- 5.1 Arrange the wires and cut 2mm wires away.
- 5.2 Rotate the scissors with some angle to cut the wire with a oblique angle. It will be easier to insert the wire into loading bar.

Untwist the wire



Wire pre-cutting



Inserting Wire into Loading

- 6. Inserting Wire into Loading Bar
- 6.1 For right-handed person- Use left hand to hold the cable & fix loading bar. Use right thumb & forefinger to insert the wire.
- 6.2 Insert the 12/45/78 first, then 3/6.
- 6.3 The wires can not bended for more than 90 degree.
- 6.4 This is the most important step for patchcord assembly. The dedicated operators are preferred in order to achieve stable yields.







Adjust the Loading Bar position

- 7. Adjust Loading Bar position
- 7.1 Use pliers to fix the wires and move the Loading Bar to Cross position.
- 7.2 The wires can not be bended for more than 90 degree during this step.
- 7.3 To avoid the damage of loading bar, do not push the loading bar too much.



- 8. Wire Cutting
- 8.1 Cut the wire at the very edge of Loading Bar. Be careful not to damage the Loading Bar.
- 8.2 Use a sharp pliers to cut the wires. Make sure there is no wire residue to avoid the short between wires.

Wire Cutting







- 9. Inserting the Loading Bar into Plug
- Insert the loading bar into plug. Make sure to push the loading bar till the end of plug.
- 9.2 Push the cable jacket and try to minimize the distance between the cable jacket & loading bar. This step is important to minimize the performance loss at SR molding step.
- 9.3 Make sure the wires are at right position before crimping step.

into Plug

Inserting the Loading Bar

