IP20 Plug Assembly Instructions

01 SHIELDING

1 to 1 ½"
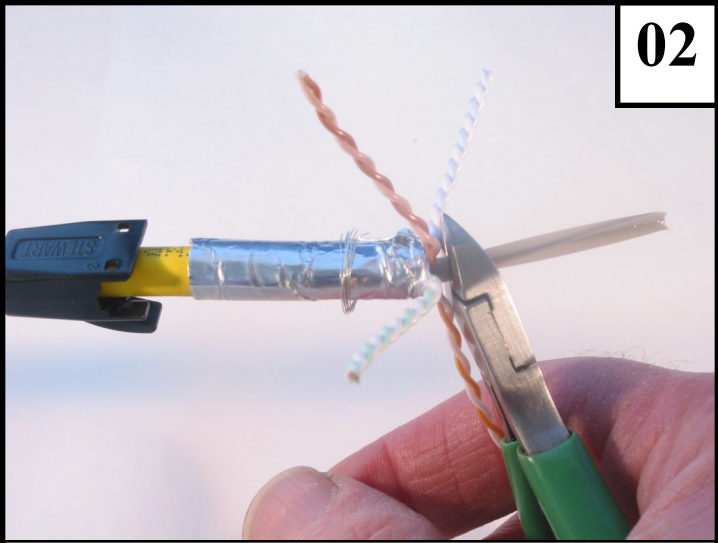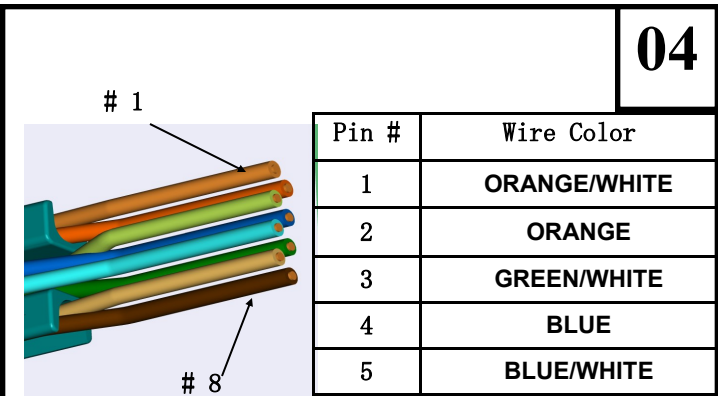
- Cut cable to length. Insert cable into the boot if used.
- Strip the jacket back 1 to 1 1/2 inches.
- If using shielded cable, fold braid, drain wire, or foil back over the jacket.

02

- Spread the wire pairs apart.
- Carefully cut away any spline or filler strips from the end of the cable. Cut as close to the edge of the jacket as you can without nicking the wire insulation.
- If not using a wire aligner skip to step 5

03 ORANGE PAIR

NOTCH IN WIRE ALIGNER
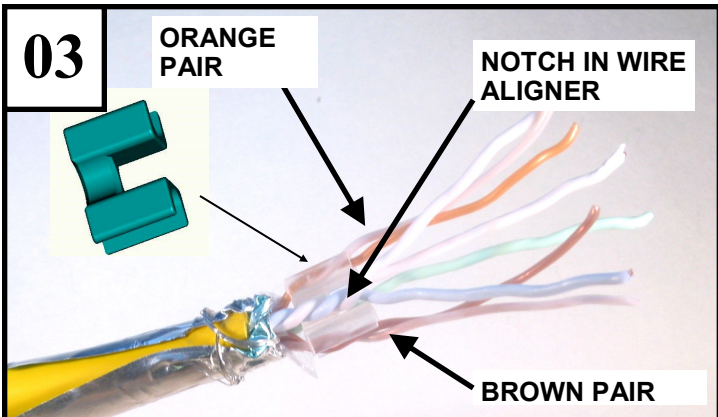
BROWN PAIR

- Orient the **Orange** pair up and the **Brown** pair down.
- Insert the wire aligner so the notch is facing right. The **Blue** and **Green** pairs should straddle the wire aligner in the shallow channels. (Either the Blue or Green pair may be in front depending on which the end of the cable is used.)
- Keep the aligner tight against the jacket.
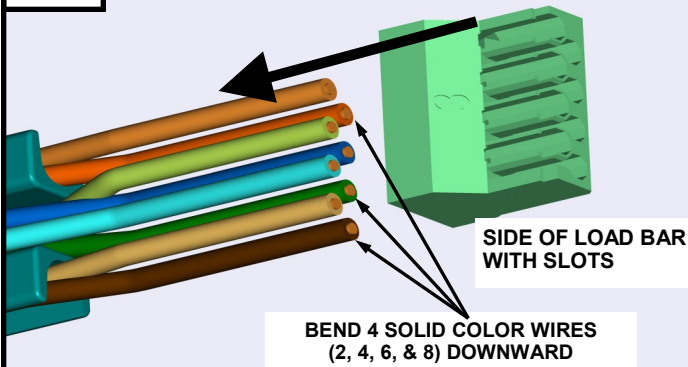- Untwist the wire pairs. Stop untwisting at the edge of the wire aligner.

04

1

8

Pin #	Wire Color
1	ORANGE/WHITE
2	ORANGE
3	GREEN/WHITE
4	BLUE
5	BLUE/WHITE
6	GREEN
7	BROWN/WHITE
8	BROWN

- Smooth out the wires as straight as possible.
- Align wires to standard (T568B Shown above).

Stewart Connector

IP20 Plug Assembly Instructions

05

PUSH LOAD BAR OVER WIRES

SIDE OF LOAD BAR WITH SLOTS

BEND 4 SOLID COLOR WIRES (2, 4, 6, & 8) DOWNWARD
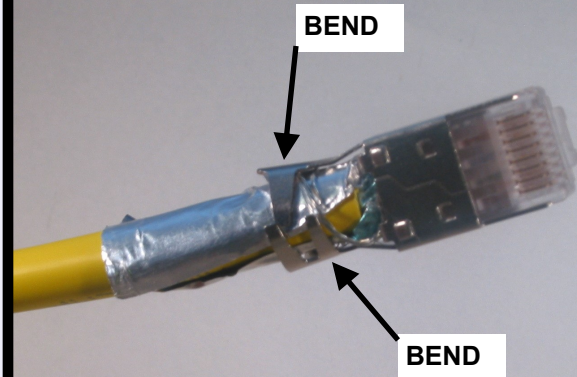
- Bend the solid color wires down slightly.
- Insert the ends of the wires into the load bar keeping the slots toward you (see picture).
- Pull the wires through the load bar and seat the load tight against the wire aligner or outer jacket.
- Trim off the wires flush to the end of the load bar

06

BEND

BEND

- Insert the load bar and wires into the back of the plug housing keeping the plug contacts toward you.
- Push the loadbar in until it is fully seated against the front of the plug housing.
- Ensure that the wires have not backed out of the load bar.
- Bend shield fingers in toward the cable.

07
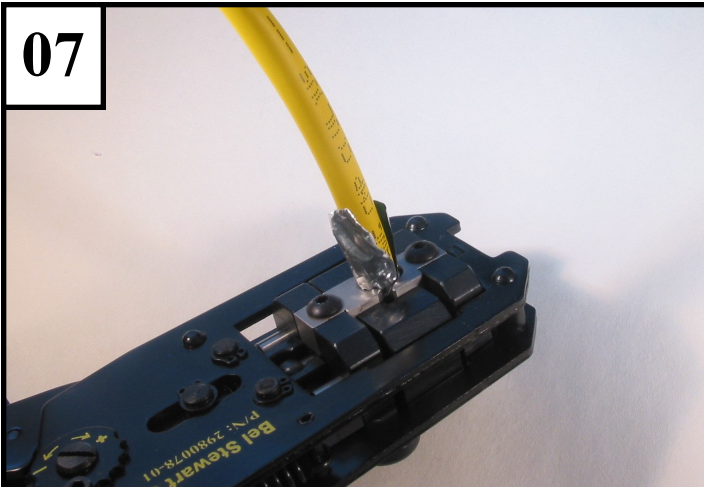
- If using shielded cable, the shield fingers should contact the foil, drain wire and/or braid.
- Fully insert the plug into the termination tool and close the handle.

08
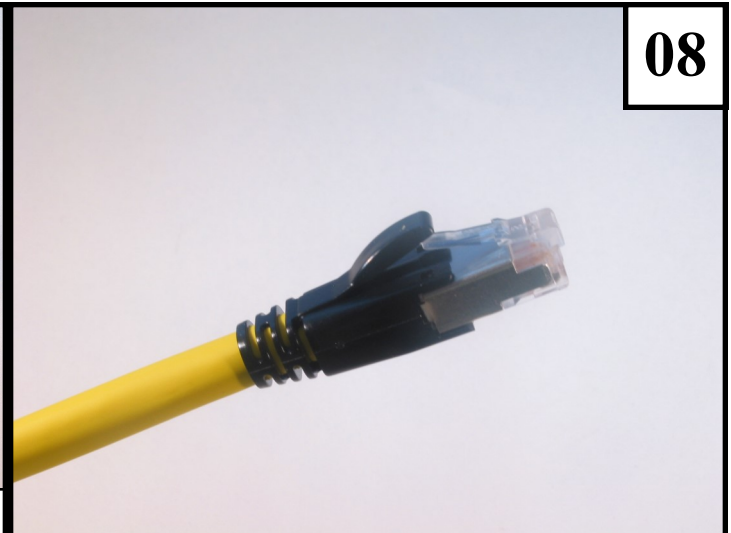
- Remove the terminated plug from the tool using the release button.
- Trim off any excess shield if used and snap the boot in place.
- Inspect and test your cable.

Stewart Connector