

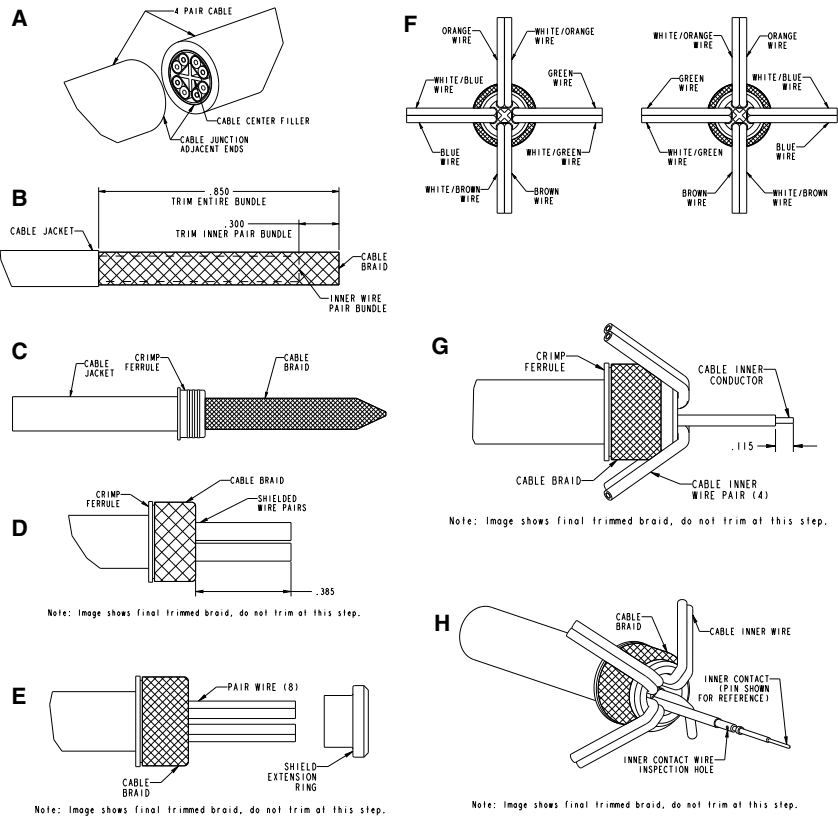
21-033425-901 (PIN)
21-033425-911 (SOCKET)

**Contact, Pin and Socket,
 Type Octonet Installation Instructions**

See table for 4 pair cable recommended, crimp tool settings, crimping tools, positioners and insertion/removal tool information.

- A 1. Cut cable for assembly of Octonet contacts. Note: contact assemblies of opposite gender should be assembled at cable junction adjacent ends, to have inner wire pairs in correct orientation during contact assembly. Crossing of inner wire pairs from their natural position is not recommended at this step in the termination process.
- B 1. Strip cable jacket 0.850 to expose cable outer braid as illustrated. Ends must be cut cleanly and at right angles to the axial plane of the cable. Cable must not be deformed while making cuts.
 2. Flair cable braid to expose inner wires.
 3. Cut away entire end of inner cable bundle .300 as shown.
- C 1. Firmly fold cable braid over inner cable bundle and twist together cable braid strand ends to form point as shown.
 2. Slide crimp ferrule, large diameter end first, over cable braid until cable jacket butts inside shoulder of crimp ferrule.
- D 1. Firmly fold cable braid back over crimp ferrule. Wrap excess cable braid firmly around cable jacket (not illustrated) to hold crimp ferrule in position during assembly of subsequent contact components. Comb out excess braid that extends past the ferrule. Illustration shows final trimmed cable braid.
 2. Trim all shielded wire pairs to be .385 as shown.
 3. Unravel & cut away inner foil wrap as close to crimp ferrule edge as possible.
 4. Trim cable center filler as close to cable braid as possible.
- E 1. Carefully untwist cable inner wire pairs until they lay straight and untwisted as illustrated.
 2. Slide shield extension ring, thin end first, over all internal wires until shoulder is flush against braid.
- F 1. Splayed inner wire pairs should match one of the illustrated wire color patterns shown. If not, grasp any non-conforming wire pair/s and untwist 180° (as close to breakout location as possible) to match the illustrated wire color pattern.
- G 1. Splay inner wire pairs firmly back over cable as shown, leaving one wire extended.
- H 1. Strip extended inner wire insulation .115 to expose inner conductor as shown.
 2. Assemble inner contact over cable center conductor until fully seated against inner wire insulation. Observe center conductor through contact's wire inspection hole, to make certain conductor is properly positioned.
 3. Crimp inner contact to center conductor using tools listed in table (make certain contact is seated firmly against wire insulation before crimping).
 4. Splay crimped contact and wire back over shield extension and extend second inner wire of wire pair.
 5. Repeat stripping of wire insulation per step G2.
 6. Repeat crimping of inner contact per steps H1 and H2
 7. Repeat crimping of contact and wire back over entire cable and extend another inner wire.
 8. Repeat stripping of wire insulation and crimping of inner contacts per step G2 through H6 until all inner contacts are crimped (8 total).

21-033425-901 (PIN)
21-033425-911 (SOCKET)

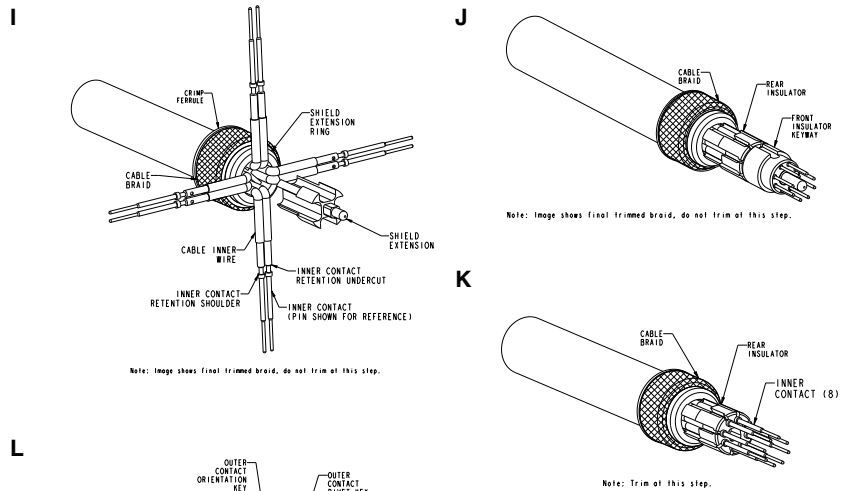


L-2119-JK
April 2026

FSCM77820

21-033425-901 (PIN)
21-033425-911 (SOCKET)

- I 1. Lay each wire pair into shield extension trench, ensure wire pair is oriented correctly. The shield extension shall be orientated as shown in figure I the inner wire pair color pattern of view F must be maintained (suggested assembly procedure: pinch wire pairs against the base/bottom of the shield extension. Small amount of tape may be used to hold the pair within the trench).
- J 1. Slide shield extension toward crimp ferrule until raised area bottoms on shield extension ring front surface.
- K 1. One-by-one, assemble wired inner contacts into rear insulator slots until fully seated as shown. Inner contact's retention undercut (shown in view I) must be positioned to capture rear insulator's retention shoulder (shown in view I), before fully seating inner contact. When contacts are properly seated, inner contact's retention shoulder will be positioned in front of rear insulator's front surface as shown. It is recommended that the two inner contacts of a wire pairs be assembled into insert slots consecutively, followed by assembly of the two inner contacts from the opposing wire pair.
- L 1. Assemble front insulator assembly over inner contacts until rear surface of front insulator butts retention shoulder of inner contacts as shown. The front insulator keyway must be centrally aligned with the contact pair desired at contact positions 1 & 2 (shown in mating face view).
 2. Cut away excess cable braid (trim to crimp ferrule shoulder as shown).
- M 1. Align front insulator keyway (shown in view K) with outer contact's rivet key. Slide inner contact assembly inside outer contact assembly until fully seated. Observe contact's mating end to make certain inner contacts are aligned as shown in mating face view.
 2. Crimp outer contact body and crimp ferrule in area shown using tools listed in table.



Amphenol Part Number	Description	Octonet Cable Recommended	Inner Crimp Tools		Outer Crimp Tools	
			Tool (Setting)	Positioner	Tool	Die Set (Location)
21-033425-901	OCTONET, PIN SPECIAL, RAILCART	RADOX RAILCAT CAT7 4X (100 OHM)	M22520/2-01 (3)	DANIELS K1958	M22520/5-01	DANIELS Y144
21-033425-911	OCTONET, SOCKET SPECIAL, RAILCART					

Amphenol Suggested Wiring

Differential Pair	Inner Contact ID
1	1
	2
2	3
	4
3	5
	6
4	7
	8

