

**Ordering Information:**

PT-908	.....	Crimp tool with built-in round cable cutter/stripper, 8-position die set and padded nylon carrying case
PT-908-D	.....	Crimp tool with built-in round cable cutter/stripper, 8-position die set packaged in a clear plastic display case

**Accessories:**

PT-DIE-8	.....	8-position die set
PT-DIE-6	.....	6-position die set
PT-BLD	.....	Standard replacement blade (long) with screws and allen wrench
PT-BLD-F	.....	Optional blade (short) required to strip flat cable; includes screws and allen wrench
P-8-8	.....	8-position modular plug with 8 contacts
P-8-8K	.....	8-position keyed modular plug with 8 contacts
P-6-6	.....	6-position modular plug with 6 contacts
P-6-4	.....	6-position modular plug with 4 contacts
UP-2468	.....	"Universal" modular plug with 8 contacts for use with 6 or 8-position jacks
PC4-1000-1	.....	2-pair, stranded, non-plenum, category 4 cable, 1000 foot dispenser pack
PC6-1000-1	.....	3-pair, stranded, non-plenum, category 4 cable, 1000 foot dispenser pack
PC8-1000-1	.....	4-pair, stranded, non-plenum, category 4 cable, 1000 foot dispenser pack
MC5-8-T(XX)-20	.....	Category 5 double-ended 4-pair modular stranded cord, ivory jacket, T568A/T568B

Use (XX) to specify length  
 03=0.91 m (3 ft), 07=2.13 m (7 ft), 10=3.05 m (10 ft)

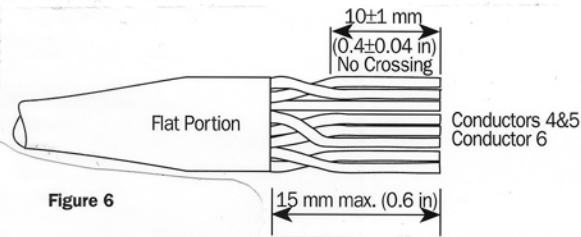
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# PT-908 & PT-908-D Crimp Tool Instructions



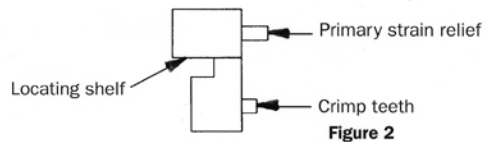
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- The trimmed length of conductors should not exceed 15 mm (0.6 in), measured from the jacket to the tips of the conductors. There should be no physical crossings between conductors for a length of  $10 \pm 1$  mm ( $0.4 \pm 0.04$  in) from the wire tips (Figure 6).



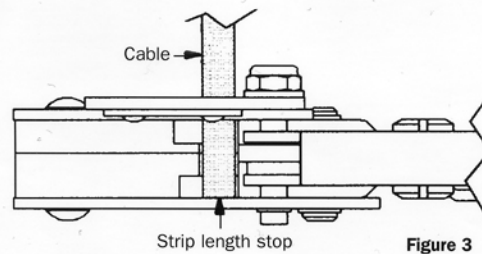
**Patch cable & conductors prior to plug termination**

- Insert the plug over the prepared conductors and the flat jacketed portion of the cable. The tips of the conductors must be "bottomed-out" in the front of the plug and the flattened portion of the jacket must extend beyond the primary strain relief (Figure 7).
- Open tool and fully seat the plug into the die cavity. Close tool until the ratchet releases and remove the terminated plug assembly. The conductor and jacket dimensions shown in Figure 6 should be checked after termination.



**Cable Cutting and Stripping**

To cut cable, open the tool and insert cable into cutting area (shown in Figure 1), check that the cable is set square with the cutting edge and squeeze handles completely. To strip round cable, open the tool, insert cable to strip length stop (as shown in Figure 3), and slowly squeeze the handles until the blade makes contact with the cable. Further engage the ratchet as needed to fully score the outer jacket taking care not to penetrate the inner conductor insulation. Rotate the tool around the cable at least one revolution and remove the outer jacket. Since round cable varies in diameter and jacket thickness, the amount of additional ratchet engagement may vary based on the cable being stripped.



### Installing Optional Blade for Flat Cable

To strip flat cable, the optional blade, P/N: PT-BLD-F, is required. To install the optional blade, it is important that the blades are set to a .035 gap (as shown in Figure 4). Use a thickness gage to set gap square to maintain the proper stripping dimension. Make sure to tighten screws to keep blades from moving.

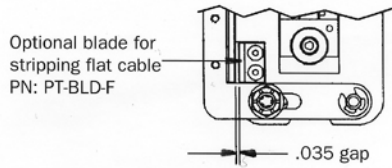


Figure 4

### Recommended Termination Procedure:

The following guidelines are intended to provide terminations that will have minimal detrimental effects on the transmission capabilities of high performance UTP cabling. Although these guidelines require additional preparation and care, familiarity through repeated terminations will yield improved consistency and transmission performance while minimizing the time required per termination.

*Note: To assure category 5 link performance, The Siemon Company strongly recommends the use of factory terminated and 100% transmission tested modular cords (see ordering information).*

1. Strip the outer cable jacket so that the twisted conductors extend a distance of about 20 mm (0.8 in) beyond it.
2. Position the cable pairs so that they are sequenced 1&2, 3&6, 4&5, 7&8 respectively (Figure 5). To prevent physical interference between pairs under the jacket when the plug is crimped, the side-by-side orientation of the cable pairs must extend into the jacket a distance of at least 8 mm (0.3 in), creating a flat portion. The flat, jacketed portion of the patch cable will appear to be oblong in cross-section. Care is required to assure that the paired conductors are not untwisted inside of the jacket.

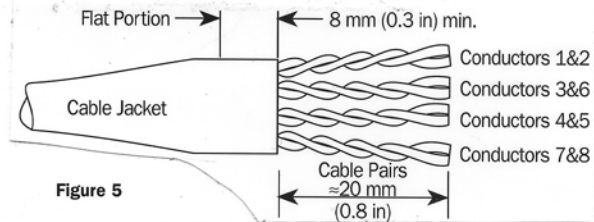


Figure 5 Jacket and aligned cable pairs prior to untwisting

3. Untwist the exposed pairs and orient them in correct order for termination so that they are parallel and conductor 6 is made to cross over conductors 4 and 5 (Figure 6). When orienting the conductors, be sure that pair twists inside of the jacket are not disturbed.

### Description

The PT-908 features a full cycle, ratchet controlled release mechanism to consistently assure proper modular plug terminations. The tool includes an allen wrench and an 8-position die set already installed (6-position die set available separately). The crimp frame is equipped with built-in, cable cutting and stripping features for round cable. An optional blade for stripping flat cable is also available (see ordering information).

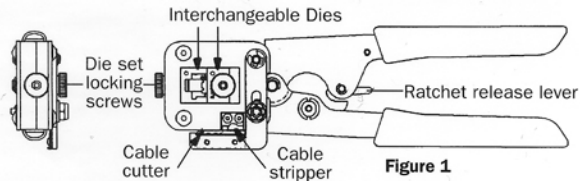


Figure 1

### Selecting and Installing the Proper Die Set

Before making any crimps, it is important to ensure that the correct die set is installed. The die size can be verified by counting the number of crimp teeth. To change the die set, open the tool by squeezing the handles completely or use the ratchet release lever shown in Figure 1. Remove the die set locking thumbscrews (shown in Figure 1), then push the die set upward and out of the tool. To install the new die set, hold the die set in closed position and place it into the tool opening until the die set rests on the locating shelf (shown in Figure 2), and replace the locking thumbscrews. It is recommended to firmly tighten the lower half using the allen wrench included.

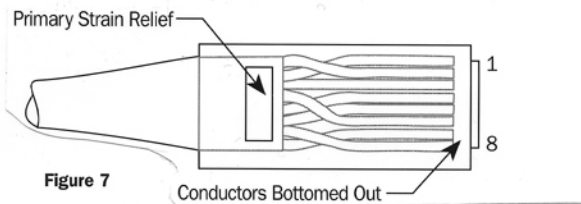


Figure 7

Completed plug termination

**Caution:** Make sure the proper die is being used and that the plug is fully inserted into the cavity. Failure to do so may damage both the connector and the die set.

The following chart can be used as a reference for wiring T568A or T568B patch cords.

Tip/ Ring	T568A Plug Pin*	T568B Plug Pin*	Stranded Cable Colors	Solid Cable Colors
T1	5	5	green	white/blue
R1	4	4	red	blue
T2	3	1	black	white/orange
R2	6	2	yellow	orange
T3	1	3	blue	white/green
R3	2	6	orange	green
T4	7	7	brown	white/brown
R4	8	8	white	brown

Plug Pin numbers = Conductor Number (Reference Fig. 5&6).