

Terminating 18AWG Cables with MOLEX Connectors

1. Use Xcelite CJS100 cable stripper to take off about 2.5-3 inches of insulation off the ends of the cable, exposing the six conductors. For best results, be sure it is set on "9", and rotate the cable stripper around the insulation while applying force to the blade side and pulling the slot outwards.
2. Slide two strips of heat shrink over cable (of roughly the same size as the removed insulation)
3. Cut off extraneous material inside exposed lengths of cable (the white and blue material) using scissors or other tool at hand
4. Use Xcelite SAS 3210 cable stripper (with top bar set fully to "+" setting and bottom set to 0.125, the first dash on the decimal side) to take off the insulation for each of the six conductors at both ends of the cable. This is done by placing the end of the conductor such that it is touching the semicircle inside the stripper and then squeezing the lever completely. If having trouble getting the clamp to catch the conductor, try clamping slowly and/or pulling the wire as the handle is being squeezed once the conductor is in place.
5. Use Tyco Electronics crimper or Amp crimper to attach the gold-plated conducting pins to the exposed conductor ends. This is done by placing the pins into the 18 AWG slot of the crimper, squeezing the handle just enough such that the crimper holds the pin in place, then inserting the exposed conductor from the cable into the gold-plated pin and finishing clamping with the crimper.
6. Repeat step 5 for each conductor (12 times in total per cable)
7. Attach Tyco 6 pin rectangular converter to each end of the cable. This is done by placing one of the (now gold-plated) conductors in each of the six larger slots until it locks into place. This should be done such that the conductors in the top row of the converter (the side with the clasp) are, from left to right, black, brown, and yellow, and that the bottom row of conductors is, again from left to right, red, blue, and orange.
8. Heat the shrink wrap in place over the area where the conductors are protruding from the cable after the initial slice from the first step.