

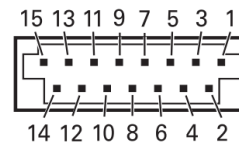
| TI-5668 Cable Pinouts - Heidenhain Endat Encoder Header (15pin pcb connector - JAE) | | | | |
|--|----------------|------------------|-----------------|-----------------|
| Line | Heidenhain Pin | Heidenhain Color | 14 Pin TB Pin # | Conductor Color |
| +5V | 13 | BRN/GRN, BLU | 1 | BLU |
| 0V | 14 | WHT/GRN, WHT | 2 | WHT |
| A+ | 1 | GRN/BLK | 3 | GRN |
| A- | 2 | YEL/BLK | 4 | ORG |
| B+ | 3 | BLU/BLK | 5 | BLK |
| B- | 4 | RED/BLK | 6 | RED |
| + DATA | 7 | GRY | 9,11,13 | GRY |
| - DATA | 8 | PNK | 10,12,14 | BRN |
| Line | Heidenhain Pin | Heidenhain Color | 12 Pin TB Pin # | Conductor Color |
| + CLOCK | 9 | VIO | 3 | VIO |
| - CLOCK | 10 | YEL | 4 | YEL |

- NOTE:**
- J2 TB must be long to go around adapter
 - J1 TB end requires 1.25" BRN, GRY jumpers
 - BLK, GRN, BRN, RED on pigtail end not used

Start with 6' of 10 conductor cable

Pigtail end of Cable

- Strip off 3" of cover and remove foil
- Cut wires at 1/4" intervals in reverse order (i.e. on 10 conductor red would be 1/4" longer than blue and vice versa on connector pigtail).
- Use ten 3/4" pieces of 1/16" heatshrink to insulate solder connections between 10 conductor and connector pigtail.
- Route all conductors back along cable and cover with 3" of 3/8" heatshrink as well as heating the pigtail heatshrink.
- Double the conductor leads back toward the end of the cable, secure with two cable ties and cover with 4" of 1/2" heatshrink.



TB end of cable

- Strip off 10.5" of cover and remove clear plastic
- Apply .75" of .25" heat shrink at end of cover
- Tin any FREE wires, cable tie them back to main cable
- Route 2 wires for 12 pin TB and BRN, GRY back towards main cable
- Install cable tie around 4 wires at heat shrink, trim tie to 5/16", install tie at pin J1-8
- Cut wires of 14 pin TB to proper length, strip, install in 14 pin TB
 BRN & GRY are jumpered to 3 pins each
 cut 2 BRN & 2 GRY jumpers each 1.5"
 twist each pair together at one end and tin
 twist one end of each pair together with respective BRN and GRY wire, tin
- Insert both connectors into the board at J1 and J2 with adapter board 5001 in place
- Route remaining 2 wires through another cable tie, trim tie to 5/16", install at J2-1
- Cut wires of 12 pin TB to proper length, strip and install in 12 pin TB
- Tighten all unused terminals
- Install identifying label at

| | | |
|-------------------------------|-------------|----------------|
| Heidenhain Pigtail | M/E P/N: | 21982115 |
| | Manuf. P/N: | 640067-N3 |
| | Vendor P/N: | HEIDENHAIN |
| Terminal Block - 14pin | M/E P/N: | 21235114 |
| | Manuf. P/N: | PCD ELFT 14260 |
| Terminal Block - 12pin | M/E P/N: | 21235112 |
| | Manuf. P/N: | PCD ELFT 12260 |

