

TI-5079 Cable Pinouts - Heidenhain EnDat Direct-to-Encoder (12 pin PCB connector)				
Line	Heidenhain Pin	Heidenhain Color	14 Pin TB Pin #	Conductor Color
+5V	1b	BRN/GRN	1	BLU
0V	4b	WHT/GRN	2	WHT
A+	2a	GRN/BLK	3	GRN
A-	5b	YEL/BLK	4	ORG
B+	4a	BLU/BLK	5	BLK
B-	3b	RED/BLK	6	RED
+ DATA	6b	GRY	9,11,13	GRY
- DATA	1a	PNK	10,12,14	BRN
Line		Heidenhain Color	12 Pin TB Pin #	Conductor Color
+ CLOCK	2b	VIO	3	VIO
- CLOCK	5a	YEL	4	YEL

Heidenhain 12 pin Pigtail	M/E P/N:	21982212
	Manuf. P/N:	332202-01
	Vendor P/N:	HEIDENHAIN
10 cond., 24AWG	M/E P/N:	60090010
	Manuf. P/N:	Carol C0745A
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

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

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 plac
- 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 on TB of J1

