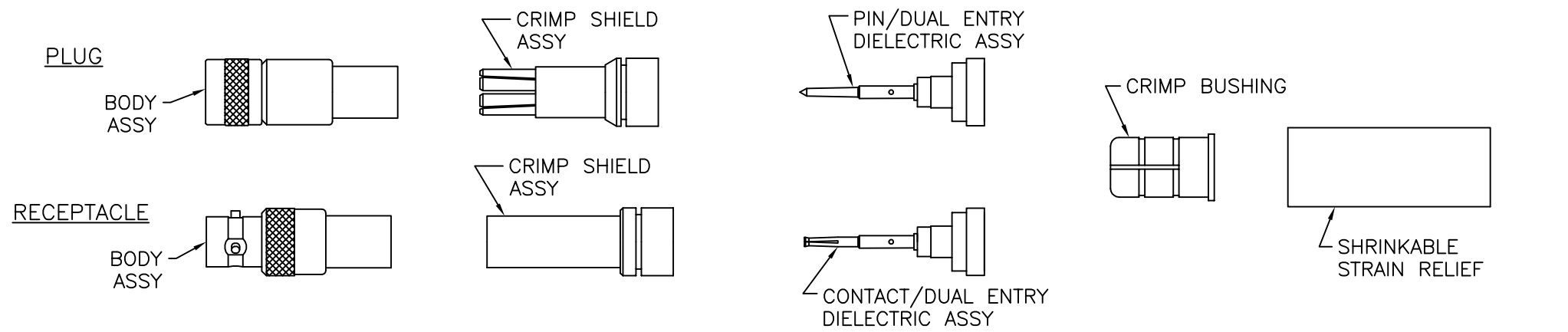
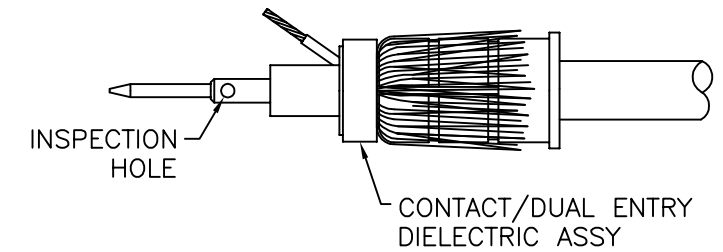


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G	52788	12/1/2010
H	55817	9/9/2015



STEP 3



- BEND WHITE CONDUCTOR OUTWARD AND POSITION BLUE CONDUCTOR TO CENTER OF CABLE.
- INSTALL PIN/CONTACT/DUAL ENTRY DIELECTRIC ASSY OVER CONDUCTORS WITH BLUE CONDUCTOR THROUGH CENTER HOLE AND WHITE CONDUCTOR THROUGH SIDE SLOT AND SEAT AGAINST BRAID.
- CRIMP IN PLACE USING TEI LOCATOR 010-0041 WITH M22520/2-01 SETTING 4.

STEP 1

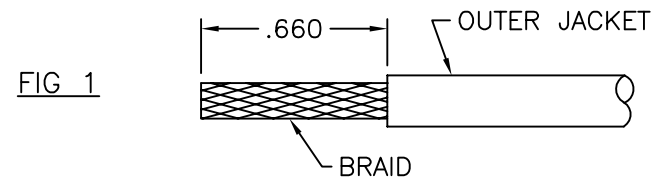


FIG 2

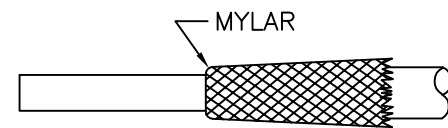
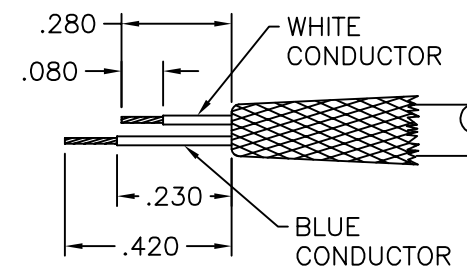


FIG 3



- REMOVE JACKET AS RECOMMENDED IN FIG 1, FOR -217 SEE FIG 2.
- COMB BRAID(S) BACK OVER JACKET (FIG 2).
- CUT CONDUCTORS AS SHOWN WITH RECOMMENDED DIMENSIONS (FIG 3), OPTIONAL; LIGHTLY TIN CONDUCTORS.

FOR -217, FOLD BACK OUTER BRAID AND REMOVE MYLAR, MU-METAL, ETC AS FAR BACK AS POSSIBLE

STEP 2

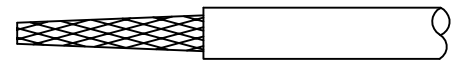


FIG A

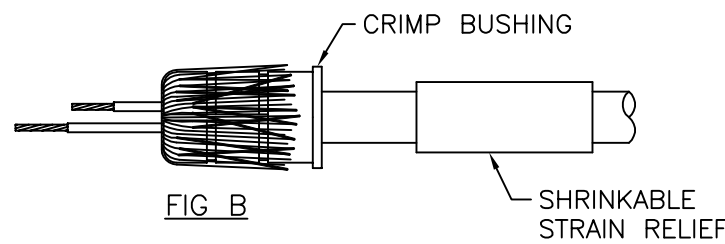
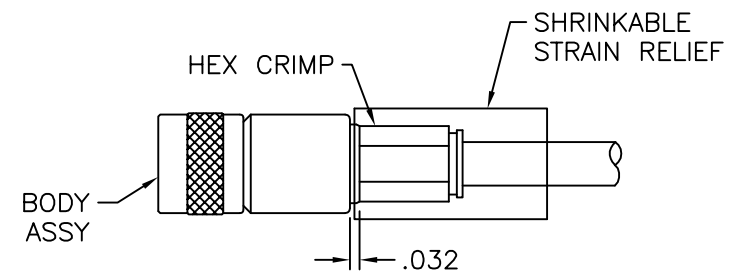


FIG B

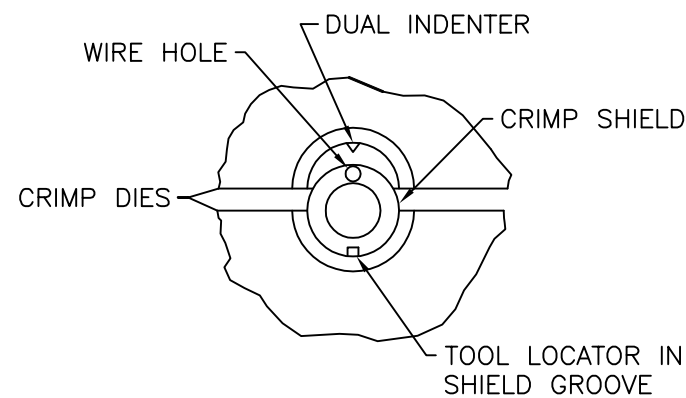
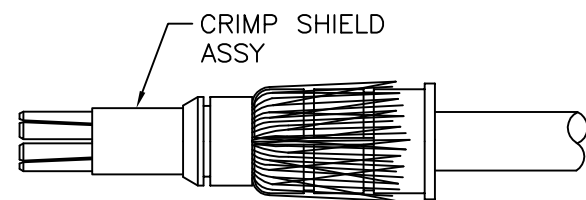
- BRING BRAID(S) FORWARD OVER CONDUCTORS AND TWIST BRAID(S) AROUND CONDUCTORS (FIG A).
- PLACE SHRINKABLE STRAIN RELIEF ONTO CABLE.
- PUSH CABLE THRU CRIMP BUSHING UNTIL JACKET BOTTOMS INSIDE OF CRIMP BUSHING.
- FOLD BRAID(S) BACK OVER CRIMP BUSHING (FIG B).

STEP 5



- PUSH ENTIRE ASSEMBLY INTO BODY ASSEMBLY UNTIL BOTTOMED, HOLD ASSEMBLY FIRMLY BOTTOMED UNTIL FULLY HEX CRIMPED AS SHOWN USING MILITARY CRIMP TOOL M22520/5-01 WITH TEI DIE SET CD5-9, CLOSURE A, MAINTAIN .032 DIMENSION.
- BRING SHRINKABLE STRAIN RELIEF TO (APPROX) LOCATION SHOWN AND SHRINK IN PLACE.

STEP 4



DETAIL A

- PLACE SHIELD/DIELECTRIC ASSY OVER CENTER CONTACT, PUT WHITE CONDUCTOR INTO SMALL HOLE AT REAR OF SHIELD/DIELECTRIC ASSY AND BOTTOM AGAINST DUAL ENTRY DIELECTRIC ASSY.
- CRIMP IN PLACE USING MILITARY CRIMP TOOL M22520/5-01 WITH TEI DIE SET CD5-9, CLOSURE B (SEE DETAIL A).

ASSEMBLY INSTRUCTIONS
"150AC" SERIES TO .160 DIA FLEXIBLE TWINAX CABLE



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TAI-143

REV H

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	DATE: 9/14/2015	SIZE: B	DO NOT SCALE DRAWING	1 OF 1