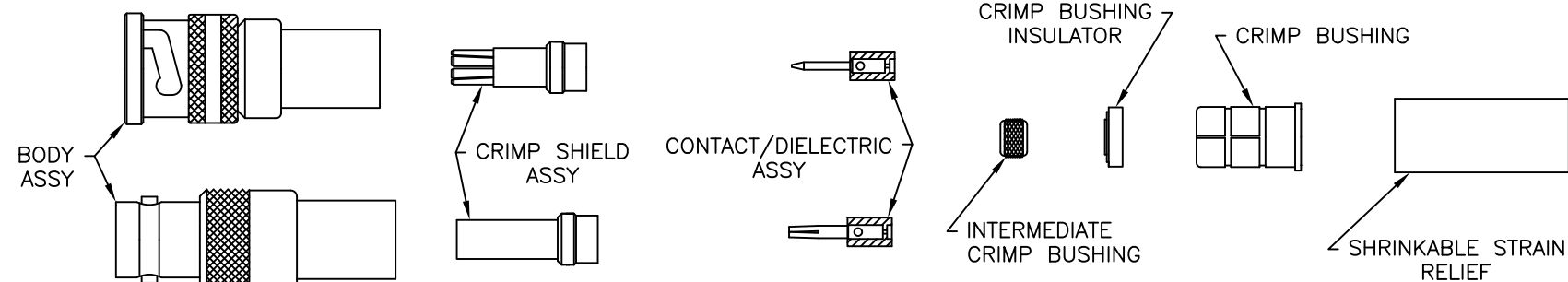


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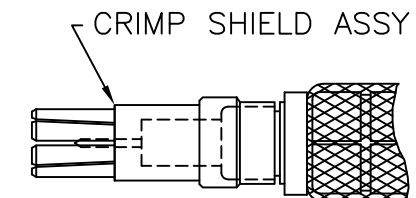
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
E	ECO 53110	3/15/11	T. SCHIEBE
F	ECO 54016	1/27/12	T.KOHLER

MALE



FEMALE

STEP 4



- PLACE CRIMP SHIELD ASSY OVER CONTACT/DIELECTRIC ASSY UNTIL SEATED.
- HOLD FIRMLY SEATED AND CRIMP IN PLACE USING MILITARY CRIMP TOOL M22520/5-01 WITH TROMPETER CD5-10 (DANIELS Y776) DIE SET POSITION B.

STEP 1  
FIG 1

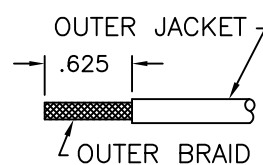


FIG 2

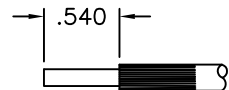


FIG 3

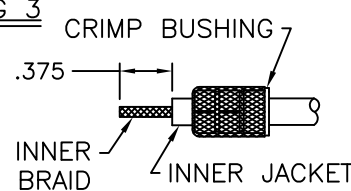
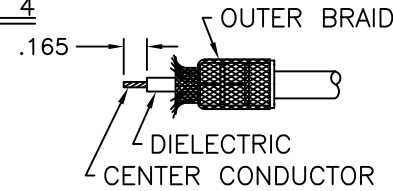
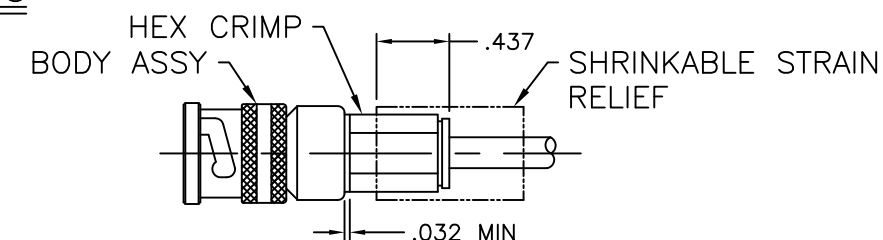


FIG 4



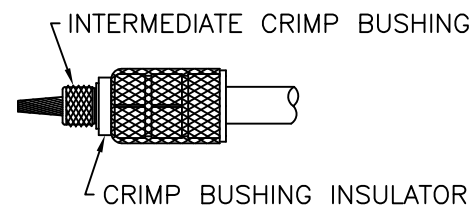
- REMOVE OUTER JACKET TO DIM SHOWN IN FIG 1.
- PLACE SEALING SLEEVE AND SHRINKABLE STRAIN RELIEF ONTO CABLE.
- COMB OUT BRAID AND FOLD OVER OUTER JACKET AND TRIM TO DIM SHOWN IN FIG 2.
- BRING OUTER BRAID BACK OVER INNER JACKET AND TWIST END. INSTALL CRIMP BUSHING OVER OUTER JACKET UNTIL BOTTOMED INSIDE OF CRIMP BUSHING. FOLD OUTER BRAID BACK OVER CRIMP BUSHING (FIG 3).
- REMOVE INNER JACKET TO DIM SHOWN IN FIG 3.
- COMB OUT INNER BRAID AND FOLD BACK, REMOVE DIELECTRIC TO DIM SHOWN IN FIG 4, (OPTIONAL: LIGHTLY TIN CENTER CONDUCTOR).

STEP 5



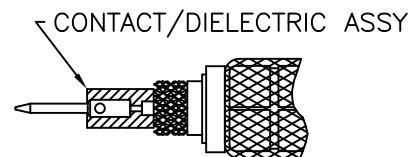
- PUSH ENTIRE ASSEMBLY INTO BODY ASSY UNTIL BOTTOMED, HOLD ASSEMBLY FIRMLY BOTTOMED UNTIL FULLY CRIMPED USING MILITARY CRIMP TOOL M22520/5-01 WITH TROMPETER CD5-10 (DANIELS Y776) DIE SET POSITION A.
- BRING UP SHRINKABLE STRAIN RELIEF TO (APPROX) DIM SHOWN AND SHRINK IN PLACE.

STEP 2



- BRING INNER BRAID FORWARD OVER CENTER CONDUCTOR AND TWIST END.
- INSTALL CRIMP BUSHING INSULATOR OVER INNER JACKET UNTIL SEATED AGAINST CRIMP RING AND/OR OUTER BRAID.
- PLACE INTERMEDIATE CRIMP BUSHING OVER INNER BRAID UNTIL SEATED AGAINST CRIMP BUSHING INSULATOR.

STEP 3



- FOLD INNER BRAID OVER INTERMEDIATE CRIMP BUSHING, TRIM BRAID TO REAR PORTION OF INTERMEDIATE CRIMP BUSHING.
- PLACE CONTACT/DIELECTRIC ASSY OVER CENTER CONDUCTOR UNTIL SEATED AGAINST INNER BRAID, HOLD FIRMLY IN PLACE AND CRIMP THRU DIELECTRIC USING MILITARY CRIMP TOOL M22520/1-01 SELECTION 4 WITH TROMPETER POSITIONER 010-0044 FOR PINS AND 010-0045 FOR SOCKET CONTACTS.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:

FRACTIONS	DECIMALS	ANGLES
±	.XX ±	±
	.XXX ±	
	.XXXX ±	



SIGNATURES	DATE
DRAWN BY M.SOURIPHONG	3/8/12
CHECKED BY T. SCHIEBE	3/20/11
APPROVED BY T. KOHLER	3/20/11
APPROVED BY	

"70" SERIES TO TRIAX CABLE UP TO 11/64 DIA			
SIZE B	CAGE CODE 14949	DWG NO. TAI-218	REV F
SCALE 1:1	DATE 6/10/97	SHEET 1 OF 2	