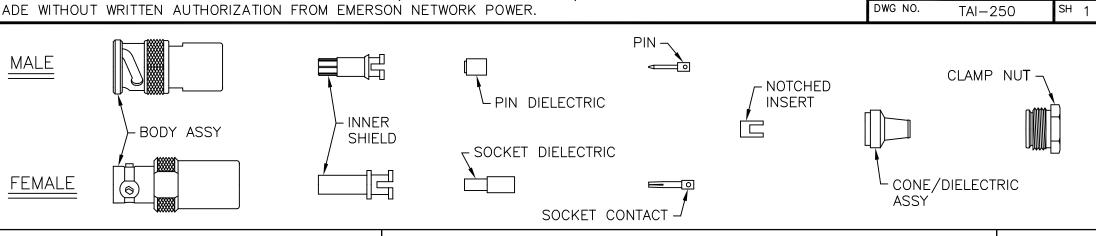
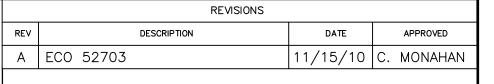
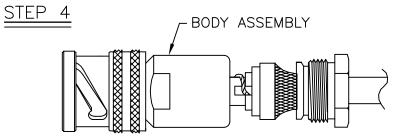
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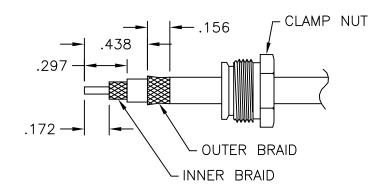




- STEP 1A CLAMP NUT <− .625 --
 - OUTER BRAID A. PLACE CLAMP NUT ONTO CABLE.
 - B. STRIP CABLE AS SHOWN AND FLARE OUTER BRAID TO ALLOW FREE ENTRY OF CONE

STEP 1B

ALTERNATE STRIPPING INSTRUCTIONS



- A. PLACE CLAMP NUT ONTO CABLE.
- B. STRIP CABLE AS SHOWN AND FLARE OUTER BRAID TO ALLOW FREE ENTRY OF CONE
- C. ADDITIONAL TRIMMING IN STEP 2 IS NOT NESSARY (2A, 2C & 2E)

- STEP 2 PIGTAIL -CONE/DIELECTRIC **ASSY** SOLDER L NOTCH INSERT
- A. PUSH CONE/DIELECTRIC ASSEMBLY UNDER OUTER BRAID AND TRIM ANY ERRANT STRANDS. THEN TRIM INTER LAYER FLUSH WITH THE CONE/DIELECTRIC ASSEMBLY.
- NOTCHED INSERT WITH PIGTAILS THROUGH SIDE SLOTS.
- F. POSITION PIN AND SOLDER IN PLACE.
- B. SEPARATE INNER BRAID AND PIGTAIL BOTH SIDES. C. TRIM DIELECTRIC CORE TO THE NOTCHED INSERT LENGTH, THEN INSTALL D. LIGHTLY TIN CENTER CONDUCTOR. E. TRIM INNER CONDUCTOR TO FILL THE PIN HOLE.
- **SOLDER** STEP 3 SHIELD PIN DIELECTRIC
- A. INSTALL PIN DIELECTRIC OVER PIN AND INSTALL SHIELD WITH PIGTAILS THROUGH NOTCHES.
- B. WRAP PIGTAILS BETWEEN SHIELD RIDGES AND SOLDER (DO NOT ALLOW PIGTAILS OR SOLDER TO EXTEND ABOVE THE RIDGES, MAY DIVIDE EACH PIGTAIL TO SPREAD THEM OUT BETWEEN THE RIDGES).

- A. BRING CLAMP NUT UP ONTO TAPERED PORTION OF CONE.
- B. ASSEMBLE BODY OVER ENTIRE ASSEMBLY AND ENGAGE WITH CLAMP NUT.
- C. WRENCH TIGHTEN TO 25-30 IN LBS TORQUE.

ASSEMBLY INSTUCTIONS

"70" SERIES WRENCH CRIMP TO M17/116-RG307



Cinch Connectivity Solutions 299 Johnson Avenue SW, Suite 100 Waseca, MN 56093 USA T: +1 507.833.8822 F: +1 507.833.6287

cinch.com

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REV A

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