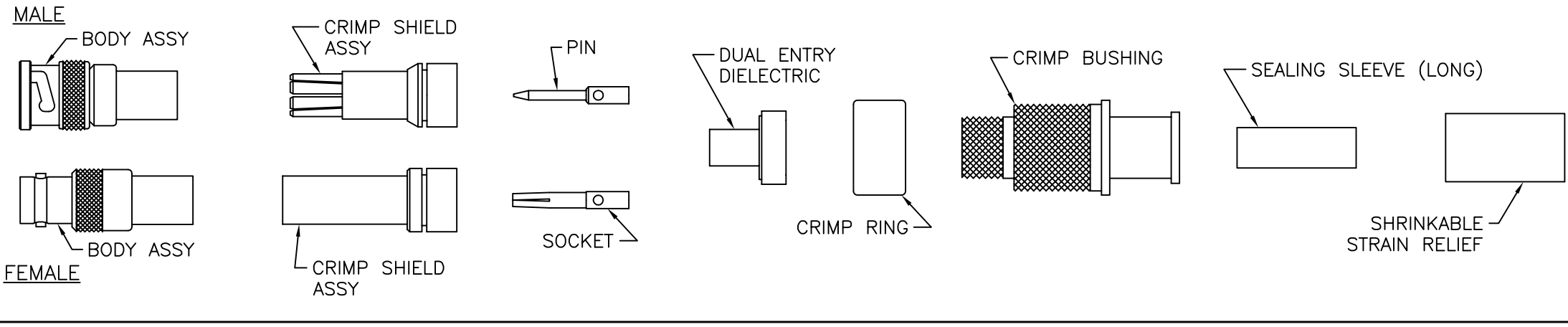
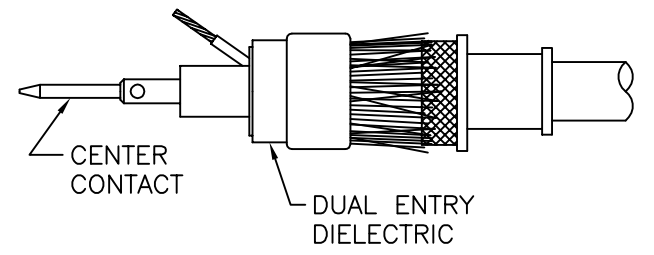


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M	55818	9/9/2015

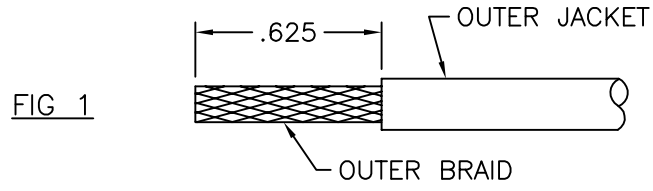


**STEP 3**



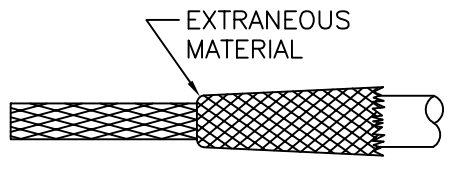
- A. BEND WHITE CONDUCTOR OUTWARD AND POSITION BLUE CONDUCTOR TO CENTER OF CABLE.
- B. INSTALL DUAL ENTRY DIELECTRIC WITH BLUE CONDUCTOR THRU CENTER HOLE AND WHITE CONDUCTOR THRU SLOT.
- C. POSITION CENTER CONTACT OVER BLUE CONDUCTOR AND CRIMP IN PLACE USING MILITARY CRIMP TOOL M22520/1-01 SELECTION 4 WITH TROMPETER POSITIONER 010-0044 FOR PINS AND 010-0045 FOR SOCKETS.

**STEP 1**



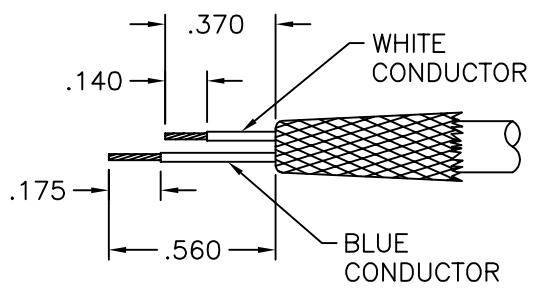
- A. REMOVE OUTER JACKET AS RECOMMENDED IN FIG 1, FOR DOUBLE SHIELDED OR QUADRAx CABLE SEE FIG 2.
- B. FOLD BRAID(S) BACK OVER JACKET.
- C. STRIP CENTER CONDUCTORS TO RECOMMENDED DIMENSIONS AS SHOWN IN FIG 3, OPTIONAL; LIGHTLY TIN CONDUCTORS.

**FIG 2**

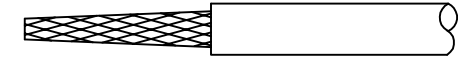


FOR DOUBLE SHIELDED OR QUADRAx CABLES, FOLD BACK OUTER BRAID AND REMOVE EXTRANEIOUS MATERIAL(MYLAR, MU-METAL, ETC) AS FAR BACK AS POSSIBLE

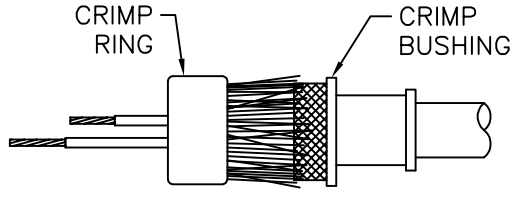
**FIG 3**



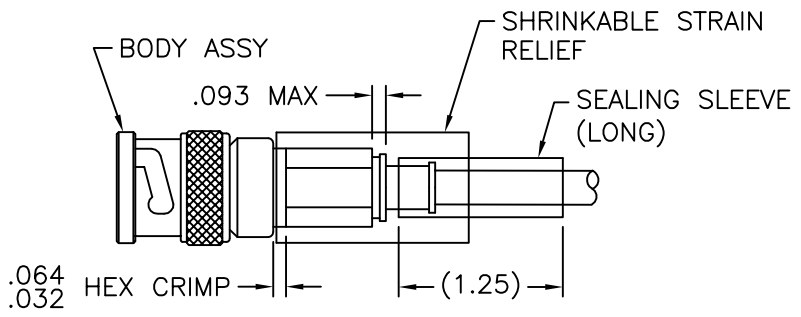
**STEP 2**



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

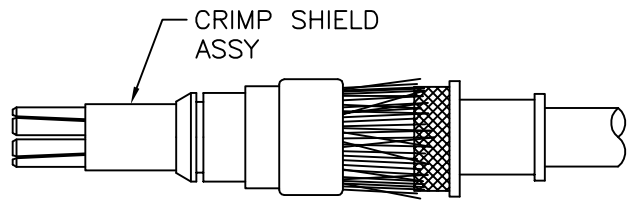


**STEP 5**

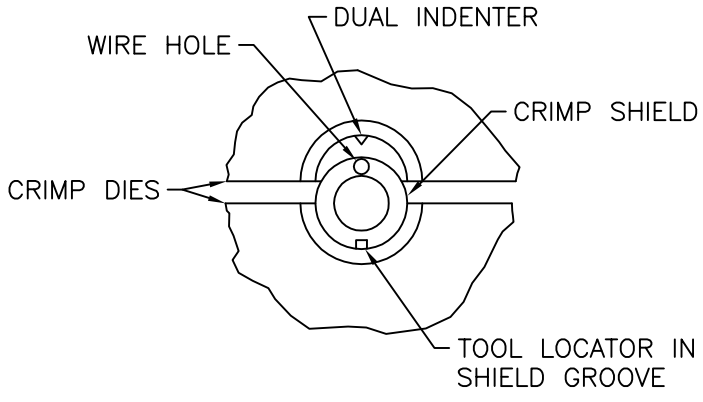


- A. PUSH ASSY INTO BODY ASSY UNTIL BOTTOMED, HOLD ASSY FIRMLY BOTTOMED UNTIL FULLY CRIMPED AS SHOWN USING MILITARY CRIMP TOOL M22520/5-01 WITH TROMPETER CD5-8 (DANIELS Y778) DIE SET, POSITION A.
- B. BRING SEALING SLEEVE UP ONTO REAR PORTION OF CRIMP BUSHING AND SHRINK IN PLACE.
- C. BRING STRAIN RELIEF UP ONTO BODY ASSY TO POSITION SHOWN AND SHRINK IN PLACE.

**STEP 4**



- A. PLACE CRIMP SHIELD ASSY OVER CENTER CONTACT, INSERT WHITE CONDUCTOR INTO SMALL HOLE AT REAR OF CRIMP SHIELD ASSY AND BOTTOM AGAINST DUAL ENTRY DIELECTRIC
- B. CRIMP IN PLACE USING MILITARY CRIMP TOOL M22520/5-01 WITH TROMPETER CD5-8 (DANIELS Y778) DIE SET, POSITION B (SEE DETAIL A).



**ASSEMBLY INSTRUCTIONS**  
"70C" SERIES TO .171 DIA TWINAX CABLE



MGF. CODE NO. 14949

TAI-166

REV M

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	RoHS2	2011/65/EU	Cage Code	14949	
	UNLESS OTHERWISE SPECIFIED UNITS: INCH	.XX ± 01	3RD ANGLE PROJECTION	Title: "70C" SERIES TO .172 DIA TWINAX CABLE	
	ANGLES ± 2°	.XXX ± .005	Drawn By:	C. WALLACE	Drawing No.
Date:	9/14/2015	SIZE	B	DO NOT SCALE DRAWING	Workmanship Std: 1 OF 1