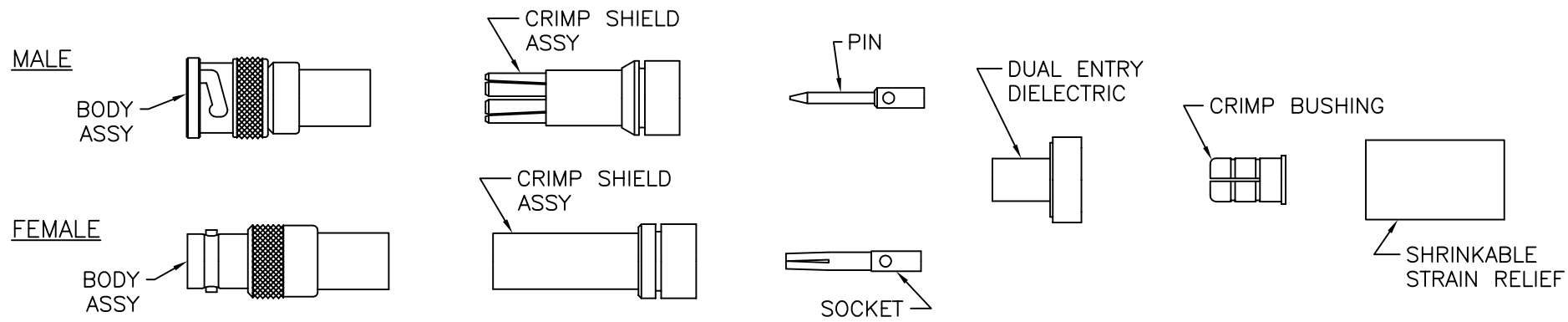
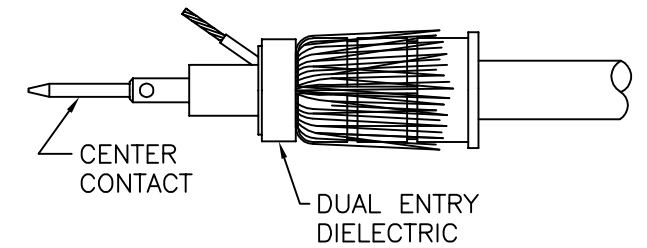


REV	ECO	DATE
H	52118	3/4/2010
J	55816	9/9/2015

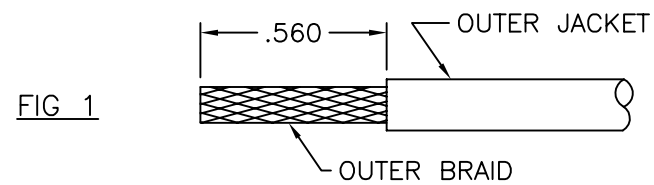


**STEP 3**



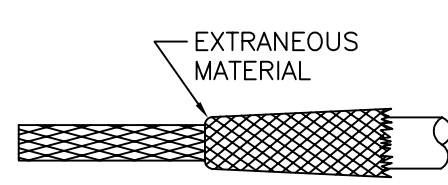
- BEND WHITE CONDUCTOR OUTWARD AND POSITION BLUE CONDUCTOR TO CENTER OF CABLE.
- INSTALL DUAL ENTRY DIELECTRIC WITH BLUE CONDUCTOR THRU CENTER HOLE AND WHITE CONDUCTOR THRU SLOT.
- POSITION CENTER CONTACT OVER BLUE CONDUCTOR AND CRIMP IN PLACE USING MILITARY CRIMP TOOL M22520/1-01 SELECTION 4 WITH TROMPETER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

**STEP 1**



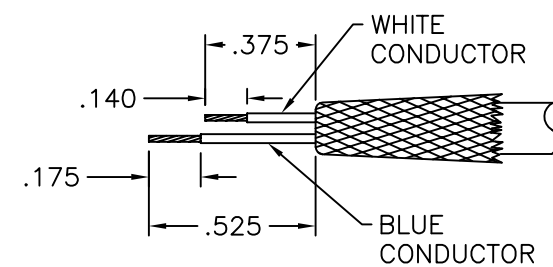
- REMOVE OUTER JACKET AS RECOMMENDED IN FIG 1, FOR DOUBLE SHIELDED OR QUADRAx CABLE SEE FIG 2.
- FOLD BRAID(S) BACK OVER JACKET.
- CUT CONDUCTORS AS RECOMMENDED (FIG 3), OPTIONAL; LIGHTLY TIN CONDUCTORS.

**FIG 2**

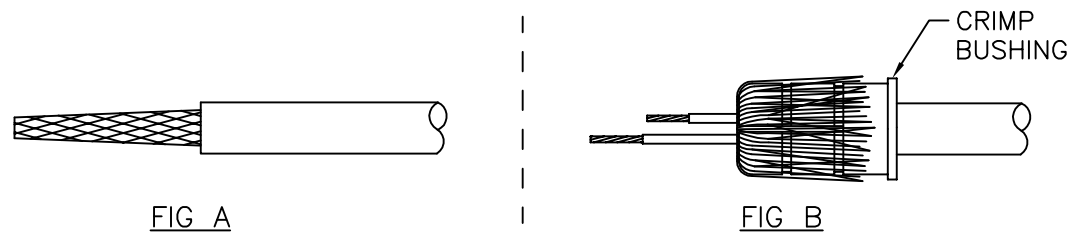


FOR DOUBLE SHIELDED OR QUADRAx CABLES, FOLD BACK OUTER BRAID AND REMOVE EXTRANEIOUS MATERIAL (MYLAR, MU-METAL, ETC) AS FAR BACK AS POSSIBLE

**FIG 3**

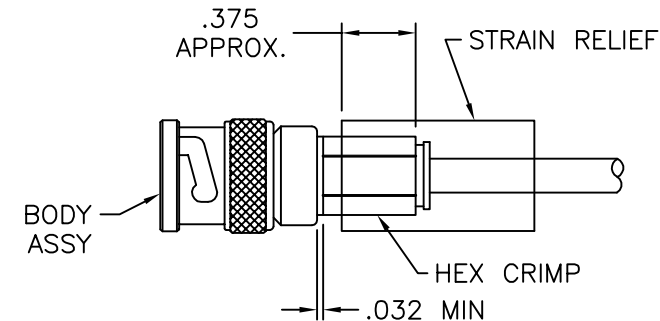


**STEP 2**



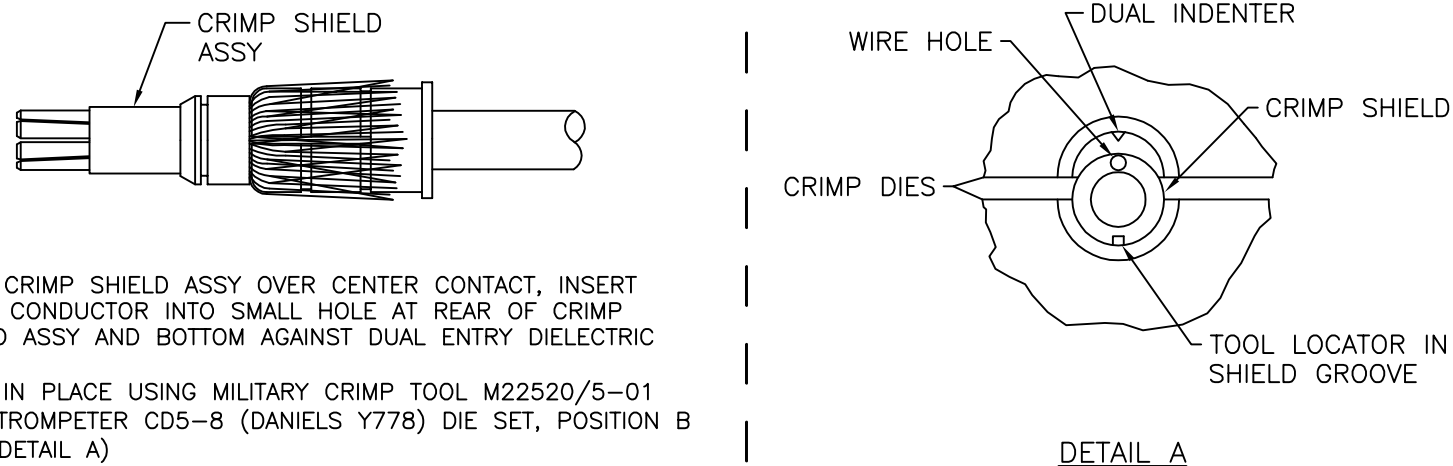
- BRING BRAID(S) FORWARD OVER CONDUCTORS AND TWIST BRAID(S) AROUND CONDUCTORS (FIG A).
- PLACE STRAIN RELIEF ONTO CABLE.
- PUSH CABLE THRU CRIMP BUSHING UNTIL JACKET BOTTOMS INSIDE OF CRIMP BUSHING.
- FOLD BRAID(S) BACK OVER CRIMP BUSHING (FIG B).

**STEP 5**



- PUSH 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.
- BRING STRAIN RELIEF UP ONTO BODY ASSY TO DIMENSION SHOWN AND SHRINK IN PLACE.

**STEP 4**



- 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
- 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 TWINAX CABLE  
11/64" TO 1/4" DIA



a bel group  
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](http://cinch.com)

MGF. CODE NO. 14949

TAI-138

REV J

<p>The PROPRIETARY Document is property of Cinch Connectivity Solutions. It is confidential in nature, non-transferable, and issued with the clear understanding that it is not to be traced or copied without permission and is returnable upon demand. INTERPRET DRAWING ACCORDANCE WITH ASME Y14.5-2009.</p>	Model No.	TAI-138	<b>TROMPETER</b>	
	RoHS2	2011/65/EU	Cage Code	14949
	UNLESS OTHERWISE SPECIFIED UNITS: INCH	.XX ± .010 .XXX ± .002 ANGLES ± 2°	3RD ANGLE PROJECTION	Title: ASSY INST 70C SERIES TWINAX CABLE 11/64 TO 1/4 DIA Drawing No. TAI-138 Rev. J
	DATE	9/14/2015	Drawn By:	C. WALLACE