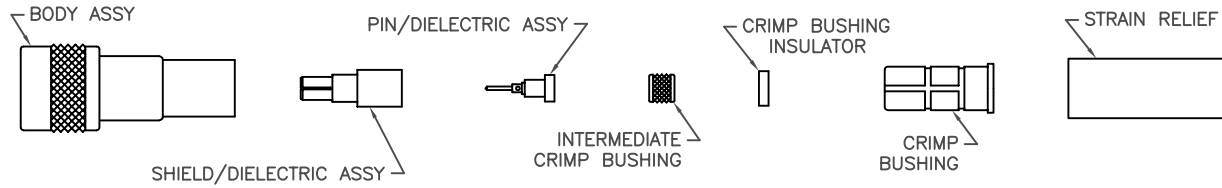


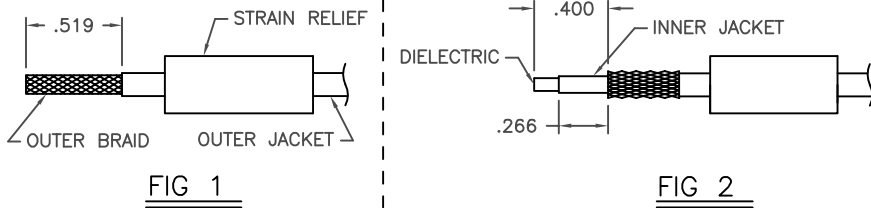
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DWG NO. TAI-153 SH 1

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
G	ECO 15952	10/13/05	B. SPINK
H	ECO 52208	5/13/10	T. KOHLER

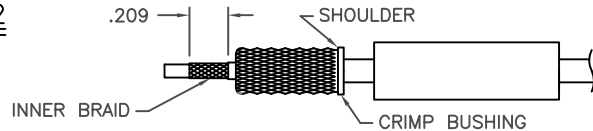


STEP 1



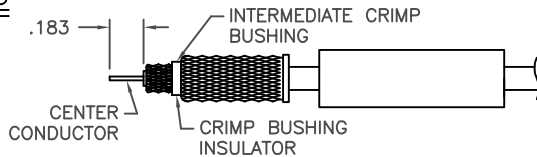
- PLACE STRAIN RELIEF ONTO CABLE JACKET AS SHOWN (FIG 1).
- CAREFULLY REMOVE OUTER JACKET TO .519 DIM. **DO NOT NICK BRAID** (FIG 1).
- FOLD OUTER BRAID BACK OVER OUTER JACKET (FIG 2).
- CUT BACK ENTIRE INNER JACKET TO .400 DIM (FIG 2).
- REMOVE INNER JACKET AND SHIELD TO .266 DIM (FIG 2).

STEP 2



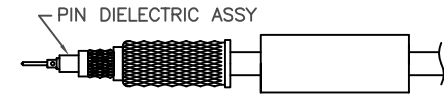
- COMB OUTER BRAID FORWARD OVER INNER JACKET AND TAPER ENDS TOGETHER.
- THREAD TAPER ENDS THROUGH CRIMP BUSHING UNTIL OUTER JACKET BOTTOMS INSIDE CRIMP BUSHING.
- COMB BACK OVER CRIMP BUSHING, TRIM AT SHOULDER IF REQUIRED.
- CAREFULLY REMOVE INNER JACKET TO .209 DIM, **DO NOT NICK BRAID**.

STEP 3



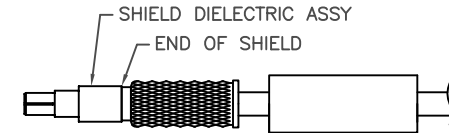
- INSTALL CRIMP BUSHING INSULATOR OVER JACKET UNTIL BOTTOMED AGAINST OUTER BRAID.
- PLACE INTERMEDIATE CRIMP BUSHING OVER INNER BRAID UNTIL BOTTOMED AGAINST CRIMP BUSHING INSULATOR.
- COMB OUT EXPOSED INNER BRAID AND COMB BACK OVER INTERMEDIATE CRIMP BUSHING.
- REMOVE CABLE PRIMARY DIELECTRIC TO BARE CENTER CONDUCTOR .183 DIM SHOWN. (OPTIONAL: LIGHTLY TIN CENTER CONDUCTOR)

STEP 4



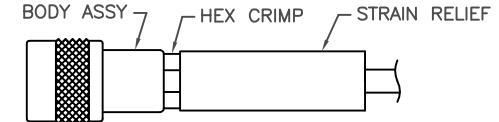
- INSTALL PIN/DIELECTRIC ASSY ONTO CENTER CONDUCTOR UNTIL BOTTOMED AGAINST PRIMARY DIELECTRIC.
- CRIMP IN PLACE (SEE TABLE FOR CRIMP TOOL AND ACCESSORIES).

STEP 5



- PLACE SHIELD/DIELECTRIC ASSY OVER PIN/DIELECTRIC AND COMBED BACK INNER BRAID UNTIL BOTTOMED. (ANY BRAID PAST END OF SHIELD WHEN BOTTOMED MUST BE REMOVED.)
- HOLDING ASSEMBLY FIRMLY BOTTOMED IN CRIMP DIE, CRIMP IN PLACE. (SEE TABLE).

STEP 6



- INSTALL CRIMPED ASSEMBLY FULLY INTO BODY ASSY AND HOLD FIRMLY BOTTOMED UNTIL FULLY HEX CRIMPED.
- BRING STRAIN RELIEF UP TO STOP ON ASSEMBLY (MUST NOT EXTEND BEYOND CRIMPED AREA) AND SHRINK IN PLACE.

SOURCE	OUTER SHIELD (BODY) CRIMP DIE	INTERMEDIATE (SHIELD) CRIMP DIE	CTR CONTACT POSITIONER	BASIC CRIMPING TOOL
TROMPETER	CD5-11/CLOSURE A	CD5-11/CLOSURE B	010-0041	M22520/2-01
TROMPETER				M22520/5-01
DANIELS			K 815S	M22520/2-01
DANIELS	Y777/CLOSURE A	Y777/CLOSURE B		M22520/5-01

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
FRACTIONS DECIMALS ANGLES
± .XX ± ±
.XXX ± ±
.XXXX + ±



SIGNATURES	DATE
DRAWN BY C. WALLACE	5/15/10
CHECKED BY	
APPROVED BY	
APPROVED BY	

PL155AC SERIES SMALL BODY TO TRIAX CABLE		REV H
SIZE B	CAGE CODE 14949	DWG NO. TAI-153
SCALE N/A	SHEET 1 OF 2	