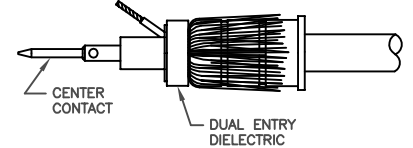


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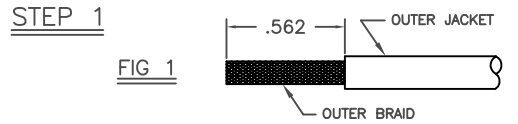
DWG NO. TAI-170 SH 1

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
E	ECO 52208	5/17/10	T. KOLHER

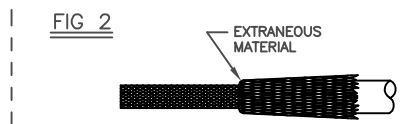
STEP 3



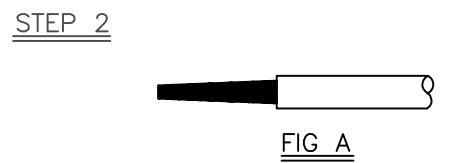
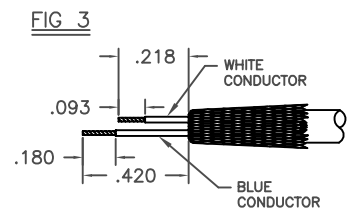
- A. BEND WHITE CONDUCTOR OUTWARD AND POSITION BLUE CONDUCTOR TO CENTER OF CABLE.
- B. INSTALL PIN/DUAL ENTRY DIELECTRIC ASSY. OVER BLUE CONDUCTOR WITH WHITE CONDUCTOR THRU SIDE SLOT UNTIL BOTTOMED AGAINST BRAID, BLUE CONDUCTOR SHOULD BE VISIBLE IN CONTACT INSPECTION HOLE.
- C. CRIMP IN PLACE USING MILITARY CRIMP TOOL M22520/2-01 USING TROMPETER POSITIONER 010-0041.



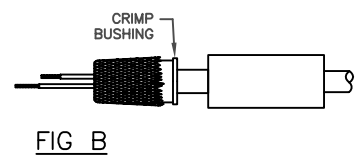
- A. REMOVE OUTER JACKET AS SHOWN IN FIG 1, FOR DOUBLE SHIELDED OR QUADRAK CABLE SEE FIG 2.
- B. FOLD BRAID(S) BACK OVER JACKET.
- C. CUT CONDUCTORS AS SHOWN IN FIG. 3 (OPTIONAL) LIGHTLY TIN CONDUCTORS.



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

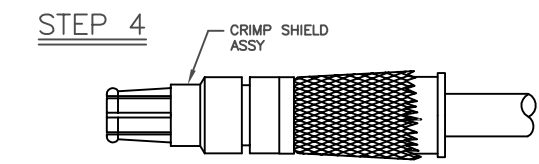
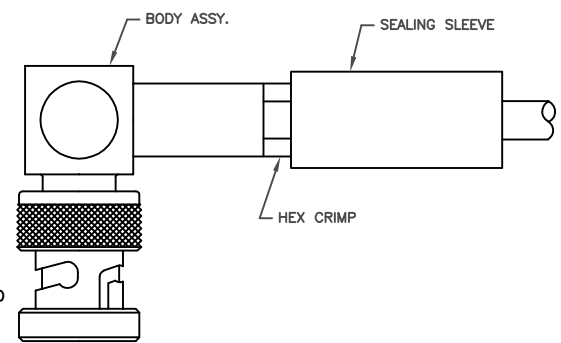


- A. BRING BRAID(S) FORWARD OVER CONDUCTORS AND TWIST BRAID(S) AROUND CONDUCTORS (FIG A).
- B. PLACE SEALING SLEEVE ONTO CABLE.
- C. PUSH CABLE THRU CRIMP BUSHING UNTIL JACKET BOTTOMS INSIDE OF CRIMP BUSHING (FIG. B).
- D. FOLD BRAID(S) BACK OVER CRIMP BUSHING (FIG B).

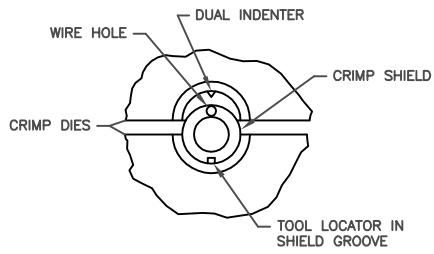


STEP 5

- A. PUSH ASSY INTO BODY ASSY UNTIL BOTTOMED, HOLD ASSY FIRMLY BOTTOMED UNTIL FULLY HEX CRIMPED USING MILITARY CRIMP TOOL M22520/5-01 WITH TEI DIE SET CD5-120 OR DANIELS DIE SET Y789(F) CLOSURE "A"
- B. BRING SEALING SLEEVE UP ONTO CRIMPED PORTION OF BODY (MUST NOT EXTEND BEYOND CRIMPED AREA) AND SHRINK IN PLACE



- 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 ASSEMBLY.
- B. CRIMP IN PLACE USING MILITARY CRIMP TOOL M22520/5-01 WITH TEI DIE SET CD5-120 OR DANIELS DIE SET Y789(F) CLOSURE "B" SEE DETAIL A



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:

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



SIGNATURES		DATE		PLR155AC & PLR455AC SERIES TO .180 DIA. TWINAX	
DRAWN BY C. WALLACE		5/17/10		SIZE B	CAGE CODE 14949
CHECKED BY				DWG NO. TAI-170	REV E
APPROVED BY				SCALE N/A	SHEET 1 OF 2