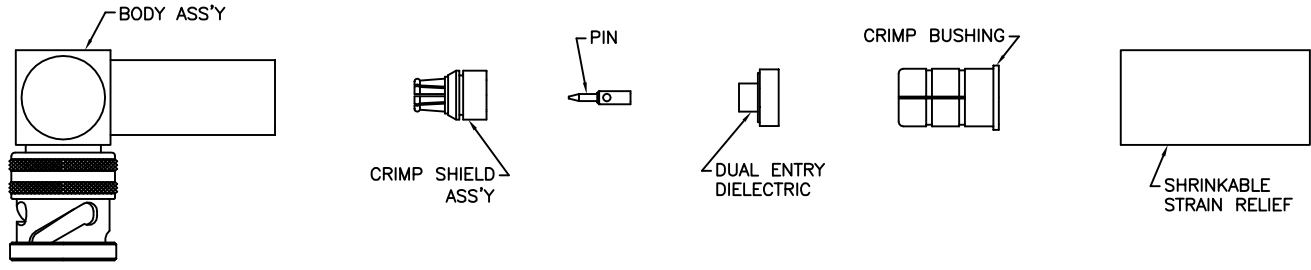
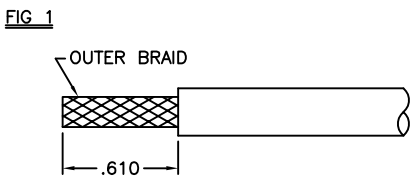


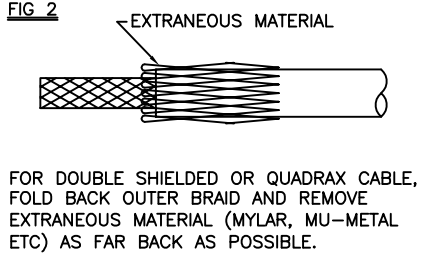
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
E	ECO 52894	1/18/11	T. SCHIEBE



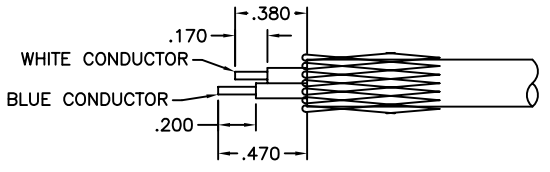
**STEP 1**



**FIG 2**

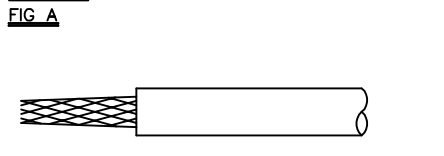


**FIG 3**

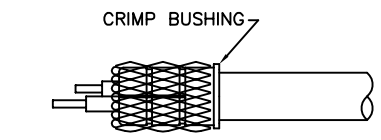


- A. REMOVE OUTER JACKET TO DIM SHOWN IN FIG 1, FOR DOUBLE SHIELDED OR QUADRAX CABLES SEE FIG 2.
- B. FOLD BRAID(S) BACK OVER JACKET.
- C. CUT CONDUCTORS AS SHOWN IN FIG 3, (OPTIONAL) LIGHTLY TIN.

**STEP 2**

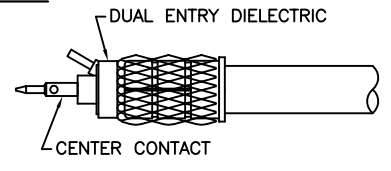


**FIG B**



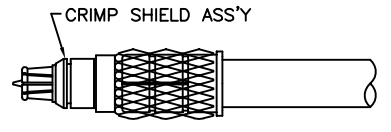
- A. BRING BRAID(S) FORWARD OVER CONDUCTORS AND TWIST BRAID(S) AROUND CONDUCTORS (FIG A).
- B. PLACE STRAIN RELIEF ONTO CABLE.
- C. PUSH CABLE THRU CRIMP BUSHING UNTIL JACKET BOTTOMS INSIDE CRIMP BUSHING.
- D. FOLD BACK BRAID(S) OVER CRIMP BUSHING (FIG B).

**STEP 3**

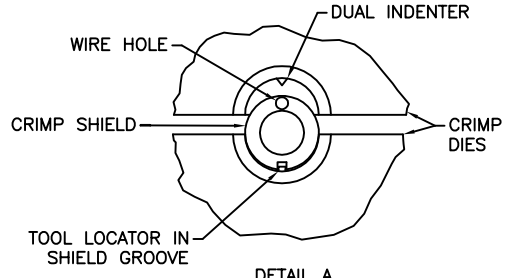


- A. BEND WHITE CONDUCTOR OUTWARD AND POSITION BLUE CONDUCTOR TO CENTER OF CABLE.
- B. INSTALL DUAL ENTRY DIELECTRIC WITH BLUE CONDUCTOR THRU CENTER HOLE AND WHITE CONDUCTOR THRU SIDE SLOT.
- C. POSITION CENTER CONTACT OVER BLUE CONDUCTOR AND CRIMP IN PLACE USING MILITARY CRIMP TOOL M22520/1-01 SELECTION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

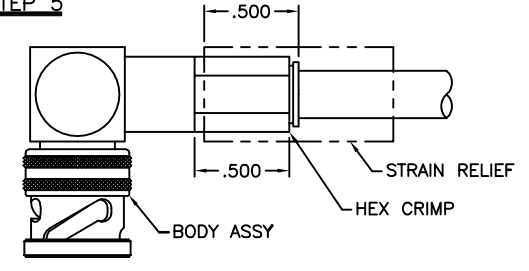
**STEP 4**



- A. PLACE CRIMP SHIELD ASS'Y OVER CENTER CONTACT, INSERT WHITE CONDUCTOR INTO SMALL HOLE AT REAR OF CRIMP SHIELD ASS'Y 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).



**STEP 5**



- A. PUSH ASS'Y INTO BODY ASS'Y UNTIL BOTTOMED, HOLD ASS'Y FIRMLY BOTTOMED UNTIL FULLY HEX CRIMPED AS SHOWN USING MILITARY CRIMP TOOL M22520/5-01 WITH TROMPETER CD5-8 (DANIELS Y778) DIE SET, POSITION A.
- B. BRING STRAIN RELIEF UP ONTO BODY ASS'Y TO (APPROX) DIM SHOWN AND SHRINK IN PLACE.

**ASSEMBLY INSTRUCTIONS**

RIGHT ANGLE "70C" & "150AC"  
LARGE BODY SERIES TO  
.171-.250 DIA TWINAX CABLE



a bel group  
Cinch Connectivity Solutions  
299 Johnson Avenue SW, Suite 100  
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T: +1 507.833.8822 F: +1 507.833.6287  
[cinch.com](http://cinch.com)

MGF. CODE NO. 14949

TAI-161

REV E

MADE IN USA

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:

FRACTIONS	DECIMALS	ANGLES
±	.XX ±	±
	.XXX ±	
	.0001 ±	

SIGNATURES		DATE	RA 70C & 150AC LG BODY	
DRAWN BY C. WALLACE		1/24/11	TO .171-.250 DIA TWINAX CABLE	
CHECKED BY			SIZE	CAGE CODE
APPROVED BY			C	14949
APPROVED BY			DWG NO.	TAI-161
			SCALE	N/A
			DATE:	8/11/87
			SHEET	1 OF 1