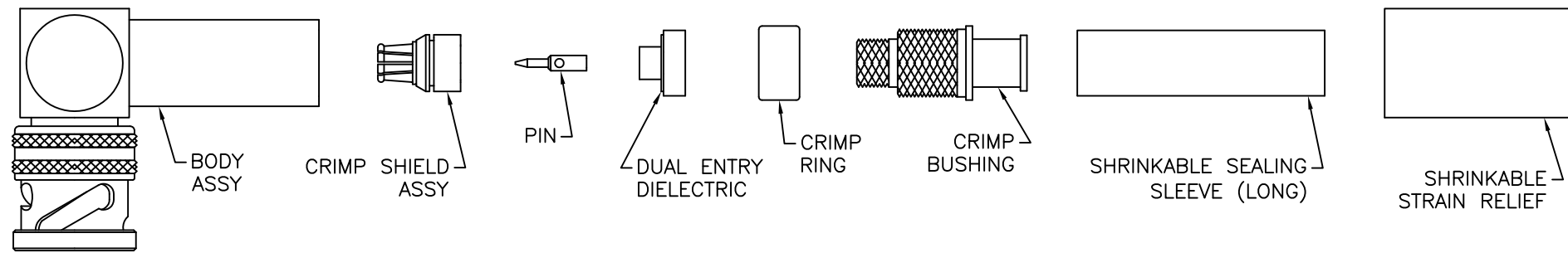


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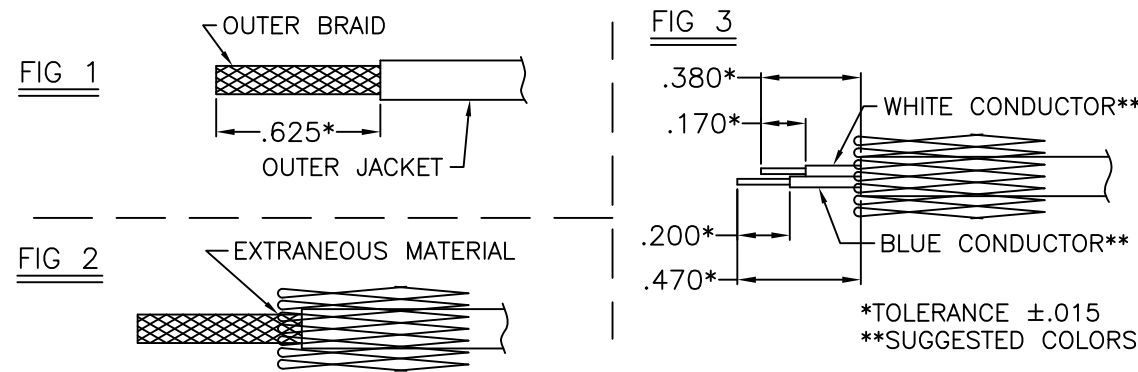
DWG NO. TAI-169 SH 1

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
L	ECO 53004	2/7/11	T. SCHIEBE
M	ECO 54017	1/27/12	T.KOHLER



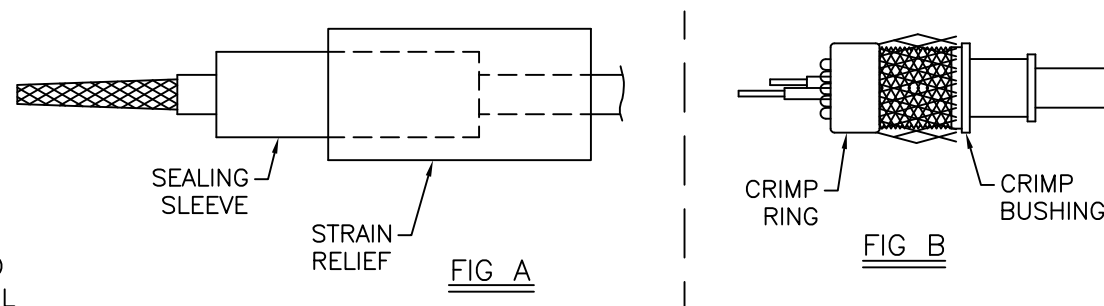
STEP 1

- REMOVE OUTER JACKET AS SHOWN IN FIG 1. FOR DOUBLE SHIELDED OR QUADRAX CABLE SEE FIG 2. FOR DOUBLE SHIELDED OR QUADRAX CABLES, FOLD BACK OUTER BRAID AND REMOVE EXTRANEOUS MATERIAL (MYLAR, MU-METAL, ETC.) AS FAR BACK AS POSSIBLE.
- FOLD BRAID(S) BACK OVER JACKET.
- CUT CONDUCTORS AS SHOWN IN FIG 3. (OPTIONAL) LIGHTLY TIN CONDUCTORS.



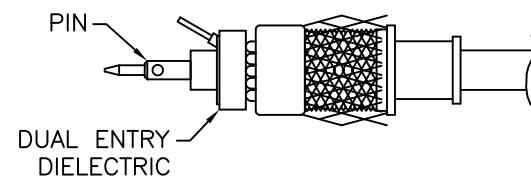
STEP 2

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



STEP 3

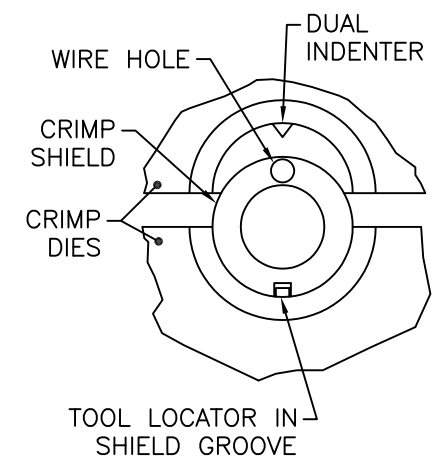
- BEND WHITE CONDUCTOR OUTWARD AND POSITION BLUE CONDUCTOR TO CENTER OF CABLE.
- INSTALL DUAL ENTRY DIELECTRIC WITH BLUE CONDUCTOR THRU CENTER HOLE AND WHITE CONDUCTOR THRU SIDE SLOT.
- POSITION CENTER CONTACT OVER BLUE CONDUCTOR AND CRIMP IN PLACE USING MILITARY CRIMP TOOL M22520/1-01 SELECTION 4 WITH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



STEP 4

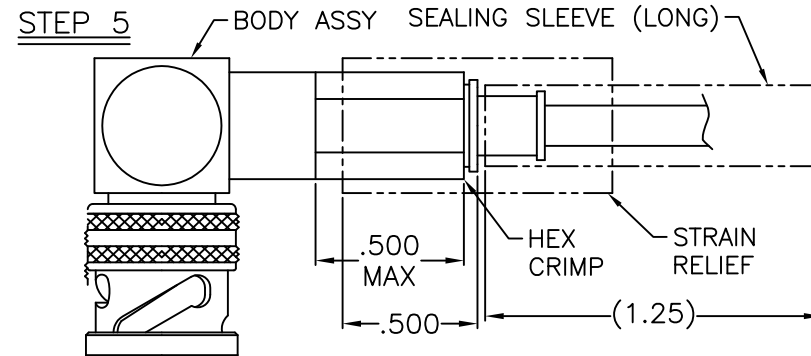
- PLACE CRIMP SHIELD ASSY OVER CENTER CONTACT, INSERT WHITE CONDUCTOR INTO SMALL HOLE AT REAR OF CRIMP SHIELD ASSY AND BOTTOM AGAINST DUAL ENTRY DIELECTRIC.
- CRIMP IN PLACE USING MILITARY CRIMP TOOL M22520/5-01 WITH TROMPETER CD5-8 DIE SET, POSITION B (SEE DETAIL A).

DETAIL A



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 DIE SET.
- BRING SEALING SLEEVE ONTO REAR PORTION OF CRIMP BUSHING AND SHRINK IN PLACE.
- BRING SHRINKABLE STRAIN RELIEF UP ONTO BODY ASSY TO POSITION SHOWN AND SHRINK IN PLACE.



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:

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



SIGNATURES	DATE
DRAWN BY M.SOURIPHONG	3/8/12
CHECKED BY C. ALDRICH	3/8/12
APPROVED BY T.KOHLER	3/8/12
APPROVED BY	

RIGHT ANGLE "70C" & "150AC" SERIES TO .171 DIA TWINAX CABLE			
SIZE	CAGE CODE	DWG NO.	REV
B	14949	TAI-169	M
SCALE	N/A	DATE	7/11/88
		SHEET 1 OF 2	