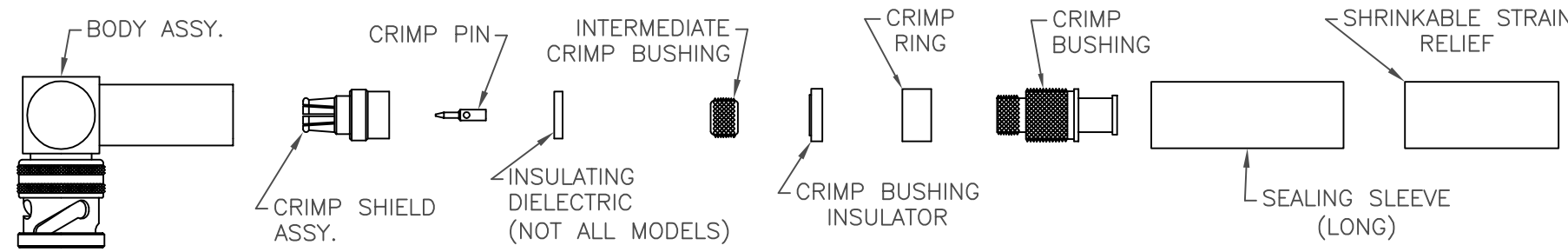


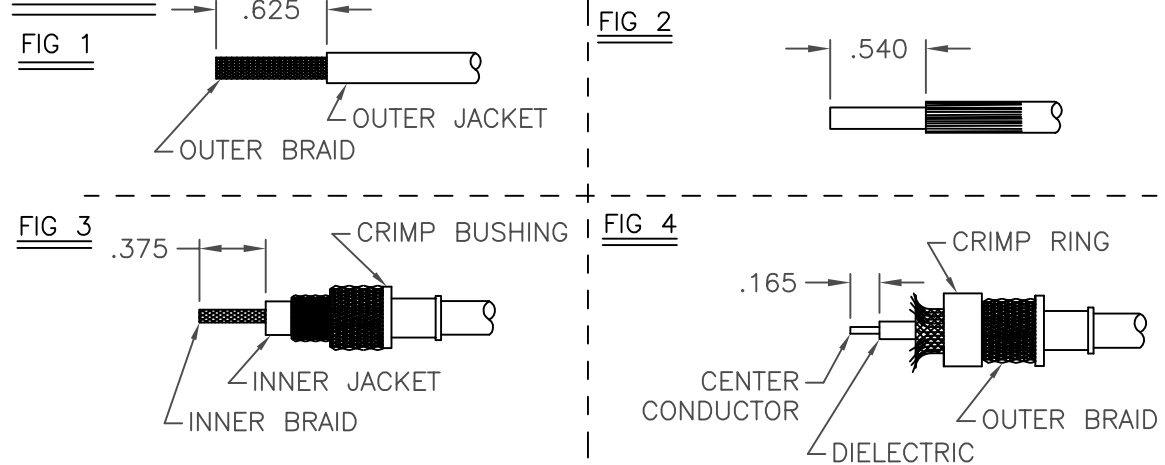
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DWG NO. TAI-154 SH 1

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
E	ECO 15823	5/23/05	B. SPINK
F	ECO 52692	11/8/10	T. KOHLER

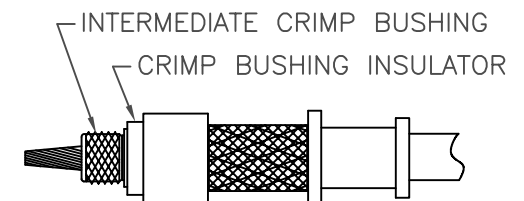


STEP 1



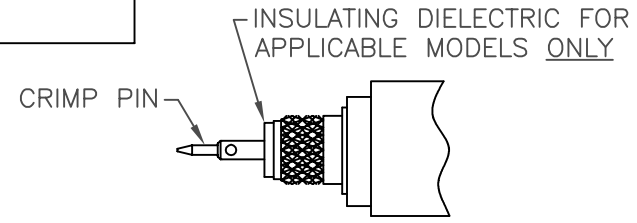
- REMOVE OUTER JACKET TO DIMENSION SHOWN IN FIG 1.
- PLACE SEALING SLEEVE AND SHRINKABLE STRAIN RELIEF ONTO CABLE.
- COMB OUT BRAID, FOLD OVER OUTER JACKET AND TRIM CABLE TO DIMENSION SHOWN IN FIG 2.
- BRING OUTER BRAID BACK OVER INNER JACKET AND TWIST END. INSTALL CRIMP BUSHING OVER OUTER JACKET UNTIL BOTTOMED INSIDE OF CRIMP BUSHING, FOLD OUTER BRAID BACK OVER CRIMP BUSHING (FIG 3).
- REMOVE INNER JACKET TO DIMENSION SHOWN IN FIG 3.
- PLACE CRIMP RING OVER OUTER BRAID AND CRIMP BUSHING UNTIL BOTTOMED FIG 4.
- COMB OUT INNER BRAID AND FOLD BACK, REMOVE DIELECTRIC TO DIMENSIONS SHOWN IN FIG 4. (OPTIONAL) LIGHTLY TIN CENTER CONDUCTOR.

STEP 2



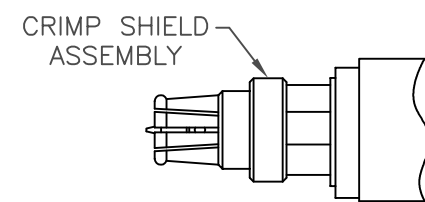
- BRING INNER BRAID FORWARD OVER CENTER CONDUCTOR AND TWIST END.
- INSTALL CRIMP BUSHING INSULATOR OVER INNER JACKET UNTIL SEATED AGAINST CRIMP RING AND/OR OUTER BRAID.
- PLACE INTERMEDIATE CRIMP BUSHING OVER INNER BRAID UNTIL SEATED AGAINST CRIMP BUSHING INSULATOR.

STEP 3



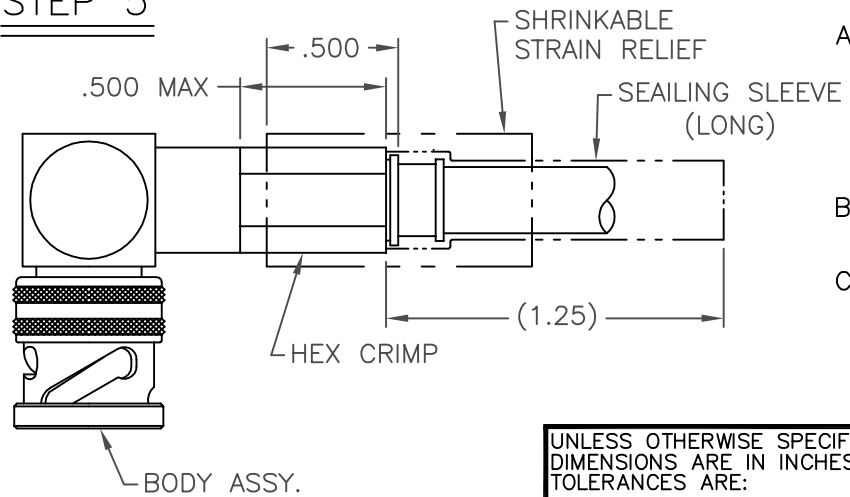
- FOLD INNER BRAID OVER INTERMEDIATE CRIMP BUSHING AND TRIM BRAID TO REAR OF INTERMEDIATE CRIMP BUSHING. INSTALL INSULATING DIELECTRIC IF SUPPLIED.
- PLACE CONTACT/DIELECTRIC ASSY OVER CENTER CONDUCTOR UNTIL SEATED AGAINST INNER BRAID, HOLD FIRMLY IN PLACE AND CRIMP USING MILITARY TOOL M22520/1-01 SELECTION 4 WITH TROMPETER POSITIONER 010-0044.

STEP 4



- PLACE CRIMP SHIELD OVER CONTACT/DIELECTRIC ASSY UNTIL SEATED.
- HOLD FIRMLY IN PLACE AND CRIMP IN PLACE USING MILITARY TOOL M22520/5-01 WITH TROMPETER CD5-10 (DANIELS Y776) DIE SET POSITION B.

STEP 5



- PUSH ENTIRE ASSEMBLY INTO BODY ASSEMBLY UNTIL BOTTOMED, HOLD ASSEMBLY FIRMLY BOTTOMED UNTIL FULLY CRIMPED USING MILITARY TOOL M22520/5-01 WITH TROMPETER CD5-10 (DANIELS Y776) DIE SET POSITION A.
- BRING SEALING SLEEVE UP ONTO REAR PORTION OF CRIMP BUSHING AND SHRINK IN PLACE.
- BRING SHRINKABLE STRAIN RELIEF UP ONTO REAR PORTION OF BODY ASSY TO (APPROX) DIMENSION SHOWN AND SHRINK IN PLACE.

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



SIGNATURES	DATE
DRAWN BY C. WALLACE	11/9/10
CHECKED BY T. KOHLER	11/10/10
APPROVED BY	
APPROVED BY	

RIGHT ANGLE 70C/150AC SERIES UP TO .172 DIA TRIAX CABLE			
SIZE B	CAGE CODE 14949	DWG NO. TAI-154	REV F
SCALE N/A		SHEET 1 OF 2	