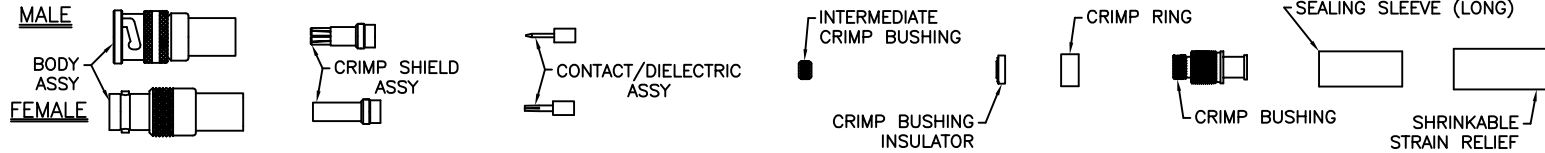


REVISIONS

REV	DESCRIPTION	DATE	APPROVED
D	ECO 15133	8/21/03	WZ
E	ECO 52667	10/27/10	T. KOHLER



STEP 1

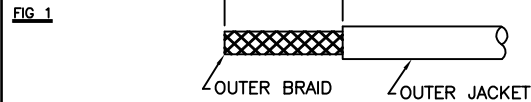


FIG 2

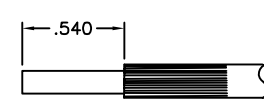


FIG 3

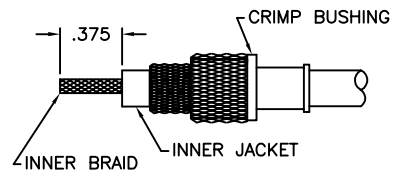
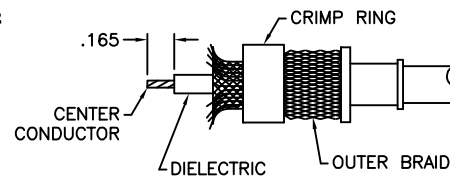
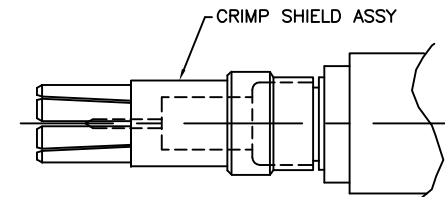


FIG 3



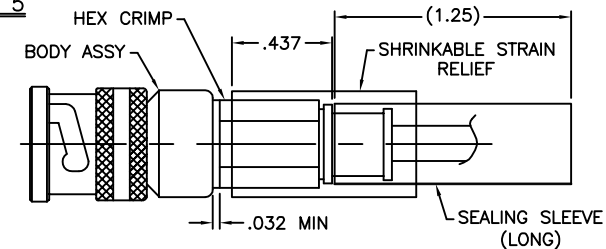
- REMOVE OUTER JACKET TO DIMENSION SHOWN IN FIG 1.
- PLACE SEALING SLEEVE AND SHRINKABLE STRAIN RELIEF ONTO CABLE.
- COMB OUT BRAID, FOLD OVER JACKET AND TRIM CABLE TO DIMENSION SHOWN IN FIG 2.
- BRING OUTER BRAID BACK OVER INNER JACKET AND TWIST END. INSTALL CRIMP BUSHING OVER OUTER JACKET UNTIL BOTTOMED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

STEP 4



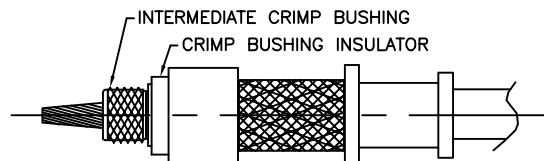
- PLACE CRIMP SHIELD OVER CONTACT/DIELECTRIC ASSY UNTIL SEATED.
- HOLD FIRMLY SEATED AND CRIMP IN PLACE USING MILITARY TOOL M22520/5-01 WITH TROMPETER CD5-10 (DANIELS Y776) DIE SET POSITION B.

STEP 5



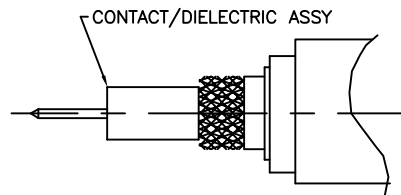
- PUSH ENTIRE ASSEMBLY INTO BODY ASSY UNTIL BOTTOMED, HOLD ASSEMBLY FIRMLY BOTTOMED UNTIL FULLY CRIMPED USING MILITARY TOOL M22520/5-01 WITH TROMPETER CD5-10 (DANIELS Y776) DIE SET POSITION A.
- BRING SEALING SLEEVE UP ONTO REAR PORTION OF CRIMP BUSHING AND SHRINK IN PLACE.
- BRING UP SHRINKABLE STRAIN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

STEP 2



- BRING INNER BRAID FORWARD OVER CENTER CONDUCTOR AND TWIST END.
- INSTALL CRIMP BUSHING INSULATOR OVER INNER BRAID 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.
- PLACE CONTACT/DIELECTRIC ASSY OVER CENTER CONDUCTOR UNTIL SEATED AGAINST INNER BRAID, HOLD FIRMLY IN PLACE AND CRIMP THRU DIELECTRIC USING MILITARY TOOL M22520/1-01 SELECTION 4 WITH TROMPETER POSITIONER 010-0044 FOR PINS AND 010-0045 FOR SOCKETS CONTACTS.

ASSEMBLY INSTRUCTIONS

FOR "70C" SERIES TO TRIAX CABLE UP TO 11/64" DIA.



MGF. CODE NO. 14949

TAI-168

REV E

MADE IN USA

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:

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

SIGNATURES	DATE
DRAWN BY C. WALLACE	10/27/10
CHECKED BY T. KOHLER	10/27/10
APPROVED BY T. KOHLER	10/27/10



ASST INST "70C" SERIES TO TRIAX CABLE UP TO 11/64" DIA

SIZE	CAGE CODE	DWG NO.	REV
C	14949	TAI-168	E

SCALE N/A SHEET 1 OF 1