

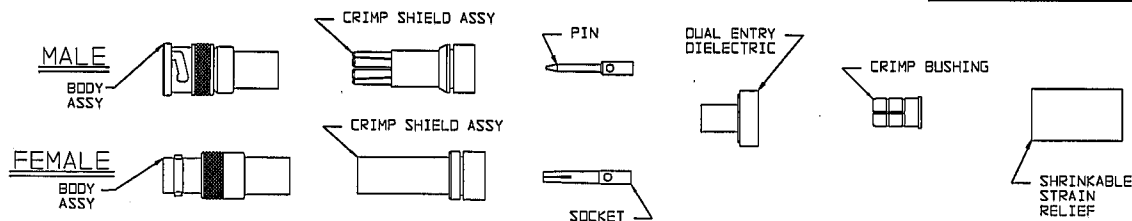
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REVISIONS

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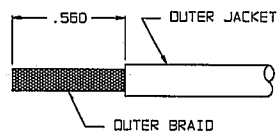
REV	DESCRIPTION	DATE	APPROVED
G	REVISED PER ECO #15706	11-3-04	WJ



RED INDICATES ORIGINAL

STEP 1

FIG 1



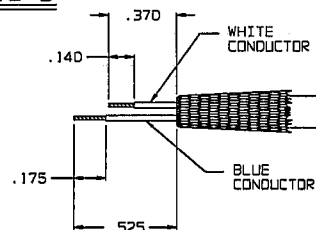
- REMOVE OUTER JACKET AS SHOWN IN FIG 1, FOR DOUBLE SHIELDED OR QUADRAx CABLE SEE FIG 2
- FOLD BRAID(S) BACK OVER JACKET
- CUT CONDUCTORS AS SHOWN IN FIG 3. (OPTIONAL) LIGHTLY TIN CONDUCTORS

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

FIG 3



ASSEMBLY INSTRUCTIONS

"70C" SERIES
TO TWINAX CABLE
1 1/64" TO 1/4" DIA

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STEP 2

FIG A



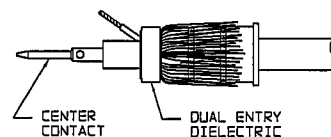
- BRING BRAID(S) FORWARD OVER CONDUCTORS AND TWIST BRAID(S) AROUND CONDUCTORS (FIG A)
- PLACE STRAIN RELIEF ONT D CABLE
- PUSH CABLE THRU CRIMP BUSHING UNTIL JACKET BOTTOMS INSIDE OF CRIMP BUSHING
- FOLD BRAID(S) BACK OVER CRIMP BUSHING (FIG B)

CRIMP BUSHING



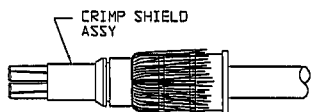
FIG B

STEP 3

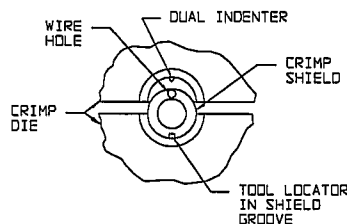


- BEND WHITE CONDUCTOR OUTWARD AND POSITION BLUE CONDUCTOR TO CENTER OF CABLE
- INSTALL DUAL ENTRY DIELECTRIC WITH BLUE CONDUCTOR THRU CENTER HOLE AND WHITE CONDUCTOR THRU SIDE SLOT
- POSITION CENTER CONTACT OVER BLUE CONDUCTOR AND CRIMP IN PLACE USING MILITARY CRIMP TOOL M22520/1-01 SELECTION 4 WITH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

STEP 4



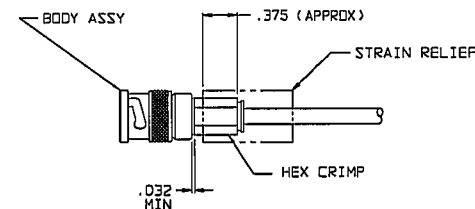
- PLACE CRIMP SHIELD ASSY OVER CENTER CONTACT, INSERT WHITE CONDUCTOR INTO SMALL HOLE AT REAR OF CRIMP SHIELD ASSY AND BOTTOM AGAINST DUAL ENTRY DIELECTRIC
- CRIMP IN PLACE USING MILITARY CRIMP TOOL M22520/5-01 WITH TROMPETER C05-B (DANIELS Y778) DIE SET, POSITION B (SEE DETAIL A)



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 C05-B (DANIELS Y778) DIE SET, POSITION A
- BRING STRAIN RELIEF UP ONT D BODY ASSY TO (APPROX) DIM SHOWN AND SHRINK IN PLACE



INTERPRET DRAWING PER MIL-STD-100 DIMENSIONS ARE IN INCHES AND INCLUDE FINISH THICKNESS UNLESS OTHERWISE SPECIFIED		TOL: UNLESS SPECIFIED .XX .XXX .XXXX ANGLES	
DRAWN PD	DATE 11-2-04	MATERIAL:	TITLE: ASSY INSTRUCTIONS "70C" SERIES TWINAX CABLE 1 1/64" TO 1/4" DIA
CHECKED T.K.H.	DATE 11-2-04	FINISH:	SIZE CAGE CODE DRAWING NO. REV. A 14949 TAI-138 G
QUALITY MS	DATE 11/3/04		SCALE DATE: 8-20-94 SHEET 1 OF 1
MANUF BP	DATE 11/3		
APPROVED WJ	DATE 11/2/04		
NEXT ASSY	CAD FILE NO. TAI-138G	DO NOT SCALE DWG	

