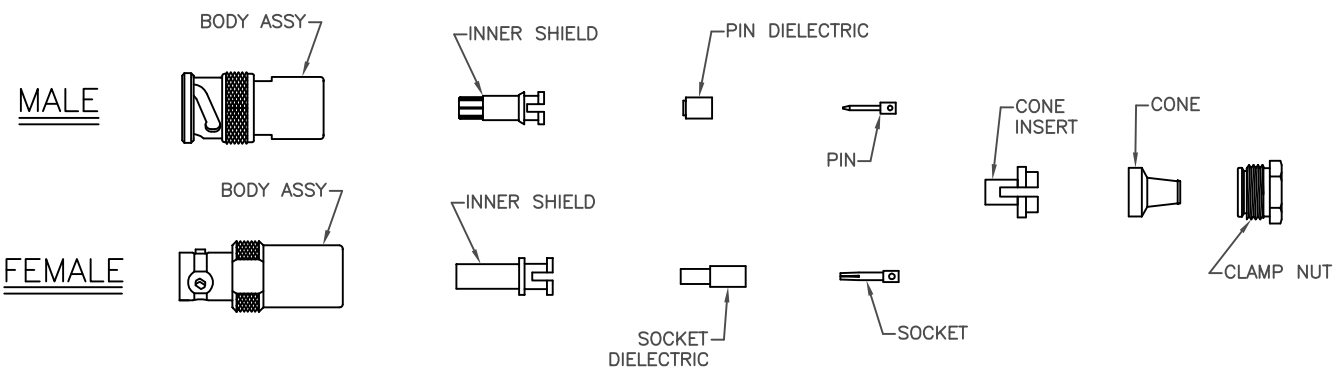


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DWG NO. TAI-189 SH 1

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
c	ECD 52208	4/5/10	T. KOHLER



**STEP 1**

A. PLACE CLAMP NUT ONTO CABLE  
 B. STRIP CABLE AS SHOWN AND FLARE OUTER BRAID TO ALLOW FREE ENTRY OF CONE (▲ LATERAL; SLITS, 180° APART MAY BE REQUIRED FOR VERY INFLEXIBLE JACKET MATERIALS)  
 C. LIGHTLY TIN CENTER CONDUCTOR

**STEP 3**

A. INSTALL PIN DIELECTRIC OVER PIN AND SHIELD WITH PIGTAILS THROUGH NOTCHES  
 B. WRAP PIGTAILS BETWEEN SHIELD RIDGES AND SOLDER (DO NOT ALLOW PIGTAILS AND SOLDER TO EXTEND ABOVE RIDGES)

**STEP 2**

A. PUSH CONE UNDER OUTER BRAID UNTIL BRAID IS FLUSH WITH EDGE OF CONE, TRIM ANY ERRANT STRANDS.  
 B. SEPARATE INNER BRAID AND PIGTAIL BOTH SIDES  
 C. INSTALL CONE INSERT INTO CONE WITH PIGTAILS THROUGH SIDE SLOTS.  
 D. POSITION PIN AND SOLDER IN PLACE

**STEP 4**

A. BRING CLAMP NUT UP ONTO TAPERED PORTION OF CONE  
 B. ASSEMBLE BODY ASSY OVER ENTIRE ASSEMBLY AND ENGAGE WITH CLAMP NUT  
 C. WRENCH TIGHTEN TO 25-30 IN LB TORQUE

**ASSEMBLY INSTRUCTIONS**  
 "WRENCH CRIMP" 70 SERIES  
 TRIAX CONNECTORS TO  
 .250" DIA CABLE

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MGF. CODE NO. 14949  
 TAI-189 REV C  
 MADE IN USA

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:  
 FRACTIONS DECIMALS ANGLES  
 ± .XX ± .010 ± 2°  
 .XXX ± .005  
 .XXXX +

SIGNATURES	DATE
DRAWN BY C. WALLACE	4/5/10
CHECKED BY	
APPROVED BY	
APPROVED BY	

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WRENCH CRIMP 70 SERIES TRIAX  
 CONNECTORS TO .250 DIA CABLE

SIZE	CAGE CODE	DWG NO.	REV
B	14949	TAI-189	c
SCALE	N/A		SHEET 1 OF 2