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REVISIONS			SH		
REV	ECO	DESCRIPTION	DWN	APPROVED	DATE
H	15501	CREATED CAMERA READY ART UPDATED REV AND ADDRESS TO AZ	DANC	<i>WMark</i>	6/23/04

### BACK (WHITE) PLATE

**STEP 1**

A. PLACE CLAMP NUT AND CRIMP SLEEVE WITH STEP LOCATED AS SHOWN ONTO CABLE.  
B. STRIP CABLE AS SHOWN AND FLARE BRAID OUTWARD TO ALLOW FREE ENTRY OF PINS/SLEEVE ASSY.  
C. LIGHTLY TIN CENTER CONDUCTOR.

**STEP 2**

A. SLIDE SLEEVE FULLY UNDER BRAID.  
B. PUSH PINS/SLEEVE ASSEMBLY UNDER BRAID UNTIL BOTTOMED.  
C. SOLDER CENTER CONDUCTOR TO PIN.  
D. BRING CRIMP SLEEVE FORWARD OVER BRAID AND CRIMP IN PLACE USING THE CRIMP TOOL (13 WITH 033 - (SEE TABLE) DIE SET).

**STEP 3**

A. INSERT PINS/SLEEVE ASSEMBLY INTO BARREL, ENGAGE CLAMP NUT WITH BARREL.  
B. HOLDING CLAMP NUT RIGID, WRENCH TOUGHEN BARREL TO 25-30 IN LB TORQUE.

⚠️ CABLES WITH FOL. ADJACENT TO THE DIE/STAMP CAN MORE EFFECTIVELY BE ASSEMBLY WITH SLEEVE INSTALLED OVER FOL.

TABLE RECOMMENDED HEX CRIMP SIZE FOR THE VARIOUS CABLE GROUPS

DASH NO	DIE SET A	DASH NO	HEX	DASH NO	DIE SET A	DASH NO	HEX
-040	1-POS B	-013	2-POS B	-014	2-POS B	-015	2.95
-045	5-POS B	-018	3-POS B	-019	3-POS B	-020	2.90
-048	1-POS B	-022	2-POS A	-023	2-POS A	-024	3.31
-050	1-POS B	-025	2-POS B	-026	2-POS B	-027	2.95
-052	1-POS A	-028	1-POS B	-029	1-POS B	-030	1.78
-055	2-POS A	-032	1-POS B	-033	1-POS B	-034	1.78

RECOMMENDED HEX CRIMP  
MADE IN USA

### FRONT (CLEAR) PLATE

**ASSEMBLY INSTRUCTIONS**

**HEX CRIMP PL3C, PL11C**  
TO  
**FLEXIBLE COAX CABLE**

**TROMPETER**  
ELECTRONICS, INC.

5550 E. McDowell Road, Mesa, AZ 85215  
Phone (800) 778-4401 Fax (480) 985-0334  
Mfg Code No. 14949 TAI-133 Rev H

**RED INDICATES ORIGINAL**

QTY	DESCRIPTION		DESCRIPTION	ITEM
TOL UNLESS SPECIFIED XXX ± .XXXX ± .XXXXX ± ANGLES ±			HEX CRIMP PL3C/PL11C TO FLEXIBLE COAX CABLE	DRAWING NO <b>TAI-133</b>
DWN				
CHK	WMark	6-15-04	MATERIAL	CODE IDENT <b>14949</b>
ENGR	WMark	6/24/04	DRAWING NO	<b>TAI-133</b>
NEXT ASSY	APPR	WMark	DATE: 11/26/84	SHEET OF
			SCALE 1 / 1	

PRINT TO SCALE  
IF INSERT, PRINT DOUBLE SIDED