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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.

CAUTION: CABLES WITH FOL ADJACENT TO THE DIELECTRIC 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	DIE SET	A
-013	1-POS B	.285	-013	2-POS B	.285
-014	1-POS B	.290	-014	3-POS B	.290
-015	1-POS B	.321	-015	2-POS A	.321
-016	5-POS B	.187	-016	2-POS B	.285
-017	1-POS B	.178	-017	2-POS B	.285
-018	1-POS A	.213	-018	1-POS B	.178
-019	1-POS A	.213	-019	1-POS B	.178

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 TAI-133
DWN				
CHK	WMark	6-15-04	MATERIAL	CODE IDENT 14949
ENGR	WMark	6/24/04	DATE: 11/26/84	SHEET OF
NEXT ASSY	APPR	WMark	SCALE 1 / 1	DATE: 11/26/84

PRINT TO SCALE
IF INSERT, PRINT DOUBLE SIDED