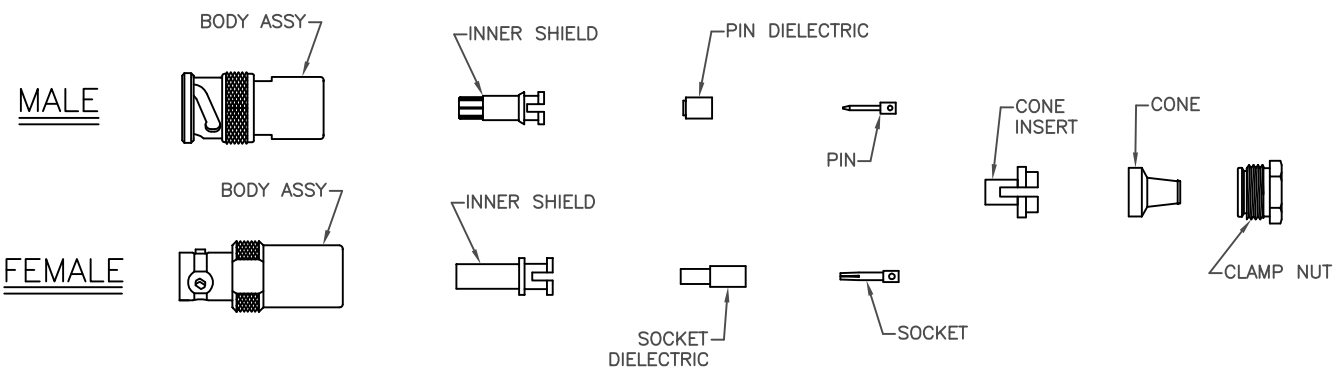


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DWG NO. TAI-189 SH 1

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



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



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REV C

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**STEP 1**

- PLACE CLAMP NUT ONTO CABLE
- 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)
- LIGHTLY TIN CENTER CONDUCTOR

**STEP 3**

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

**STEP 2**

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

**STEP 4**

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

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:

FRACTIONS	DECIMALS	ANGLES
±	.XX ± .010	± 2°
	.XXX ± .005	
	.XXXX +	



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DRAWN BY C. WALLACE		4/5/10	
CHECKED BY		SIZE	CAGE CODE
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