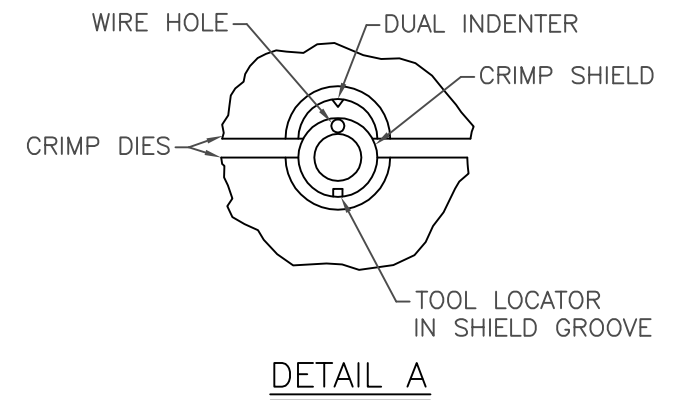
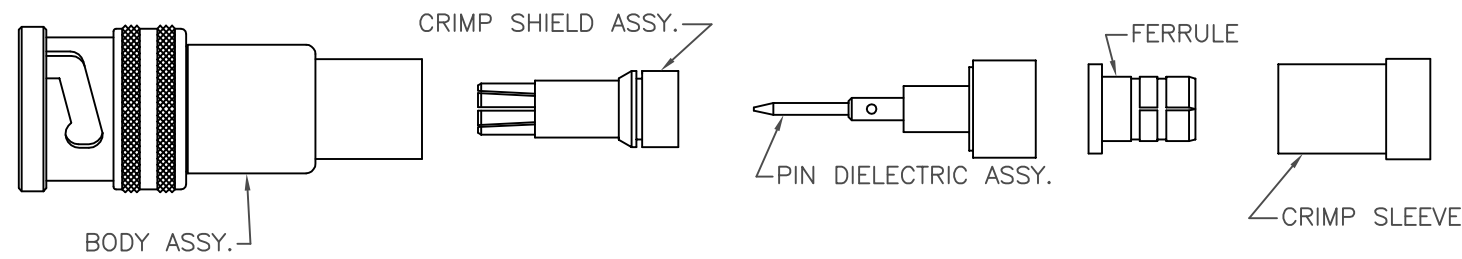


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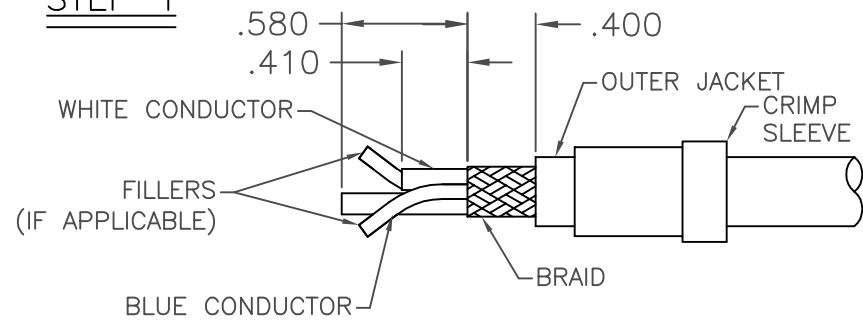
DWG NO. TAI-201 SH 1

REVISIONS

REV	DESCRIPTION	DATE	APPROVED
E	ECO 52118	3/5/10	T. KOHLER
F	ECO 52597	9/21/10	T. KOHLER

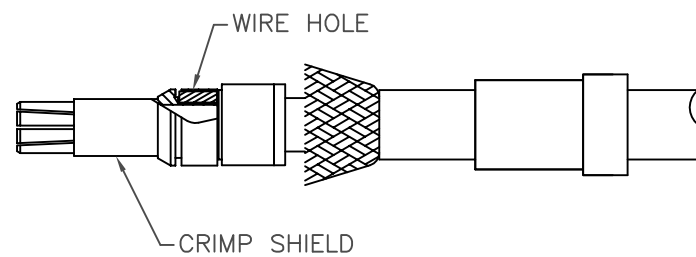


STEP 1



- A. PLACE CRIMP SLEEVE ONTO CABLE WITH STEP LOCATED AS SHOWN
- B. REMOVE OUTER JACKET AS SHOWN
- C. STRIP BRAID AND CUT WHITE CONDUCTOR AS SHOWN

STEP 3

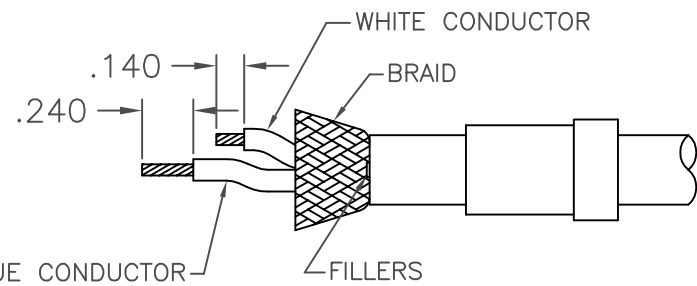


- A. PLACE CRIMP SHIELD ASSY OVER CENTER CONTACT, INSERT WHITE CONDUCTOR INTO WIRE HOLE AT REAR OF CRIMP SHIELD ASSY AND BOTTOM AGAINST DUAL ENTRY DIELECTRIC.
- B. CRIMP IN PLACE USING MILITARY CRIMP TOOL M225020/5-01 WITH TROMPETER CD5-14 DIE SET, POSITION B (SEE DETAIL A)

ASSEMBLY INSTRUCTIONS  
 "70MC" SERIES TO TWINAX CABLE  
 11/64" TO 1/4" DIA

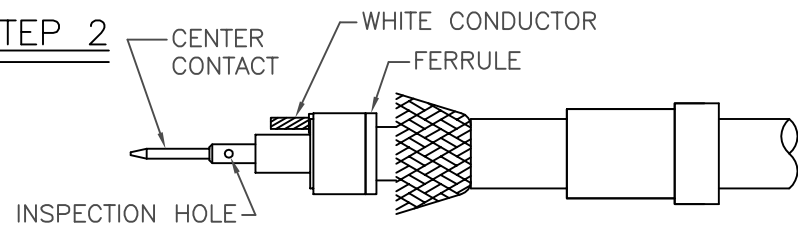


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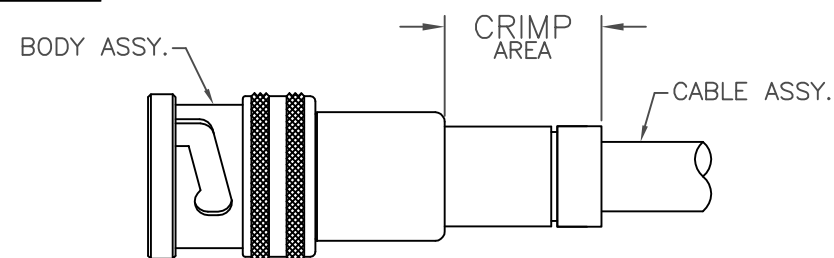
- D. FLAIR BRAID AND CUT FILLERS AS FAR BACK AS POSSIBLE (IF APPLICABLE)
- E. STRIP CONDUCTORS AS SHOWN, (OPTIONAL: LIGHTLY TIN CONDUCTORS)

STEP 2



- A. INSTALL FERRULE THRU CONDUCTORS AND PUSH BACK AS FAR AS POSSIBLE
- B. INSTALL DIELECTRIC ASSY WITH BLUE CONDUCTOR THRU CENTER HOLE AND WHITE CONDUCTOR THRU SIDE SLOT. (BLUE CENTER CONDUCTOR MUST BE VISIBLE THRU INSPECTION HOLE)
- C. CRIMP CENTER CONDUCTOR IN PLACE USING MILITARY CRIMP TOOL M22520/2-01 WITH TROMPETER POSITIONER 010-0096, SELECTOR SETTING 8 FOR PINS.

STEP 4



- A. SLIDE CRIMP SLEEVE OVER FERRULE UNTIL IT BOTTOMS AGAINST THE FERRULE.
- B. PUSH CABLE ASSY INTO BODY ASSY UNTIL IT BOTTOMS
- C. USING MILITARY CRIMP TOOL M22520/5-01 WITH TROMPETER CD5-14 DIE SET, PLACE BODY/CABLE ASSY INTO DIE POSITION A SO THE CRIMP FERRULE BOTTOMS AGAINST LOCATOR PLATE ON THE DIE. PUSH BODY ASSY FIRMLY SO THE CRIMP FERRULE BOTTOMS AGAINST LOCATOR PLATE AND CRIMP IN PLACE.

MFG. CODE NO. 14949

TAI-201

REV F

MADE IN USA

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:  
 FRACTIONS .XX ± .01 ±  
 DECIMALS .xxx ± .005  
 ANGLES .xxxx +



"70MC" SERIES TO TWINAX CABLE, 11/64" TO 1/4"

SIGNATURES		DATE	SIZE	CAGE CODE	DWG NO.	REV
DRAWN BY C. WALLACE		9/22/10	B	14949	TAI-201	F
CHECKED BY T. KOHLER		9/22/10	SCALE N/A		SHEET 1 OF 2	
APPROVED BY T. KOHLER		9/22/10				