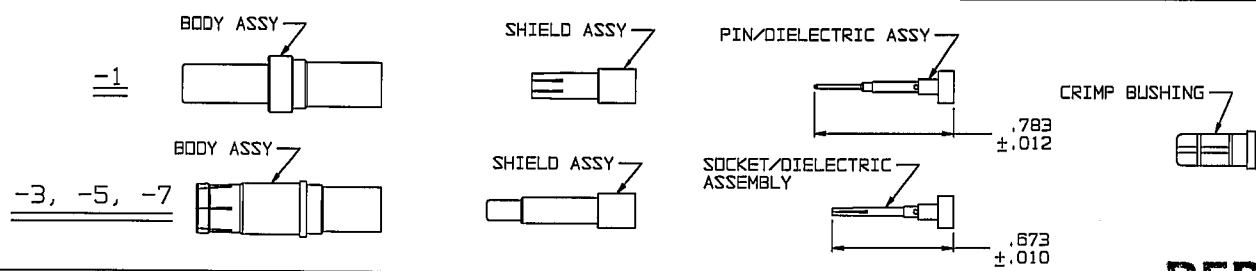


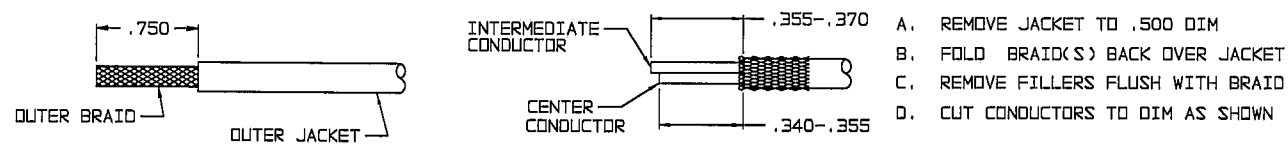
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REVISONS		305-0864	SH 3
REV	EO	DESCRIPTION	DATE

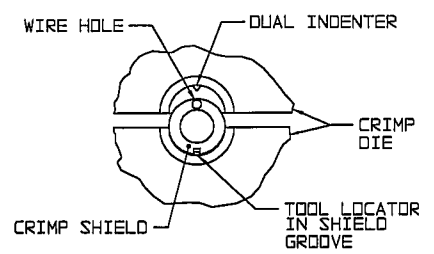


RED INDICATES ORIGINAL

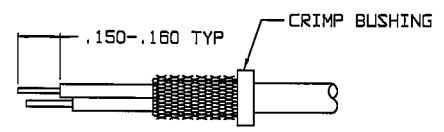
STEP 1



- REMOVE JACKET TO .500 DIM
- FOLD BRAID(S) BACK OVER JACKET
- REMOVE FILLERS FLUSH WITH BRAID
- CUT CONDUCTORS TO DIM AS SHOWN

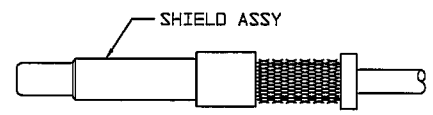


STEP 2



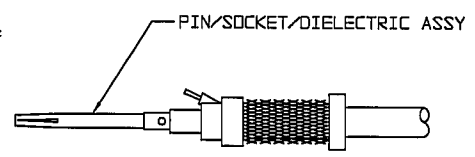
- TAPER BRAID FORWARD OVER CONDUCTORS
- PUSH CABLE THROUGH CRIMP BUSHING UNTIL JACKET BOTTOMS INSIDE CRIMP BUSHING.
- FOLD BRAID BACK OVER CRIMP BUSHING, TRIM AT SHOULDER IF REQUIRED, STRIP CONDUCTORS AND (OPTIONAL) LIGHTLY TIN

STEP 4



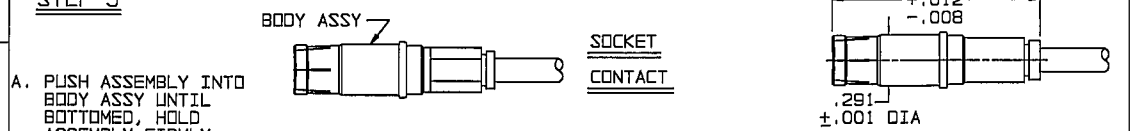
- PLACE SHIELD ASSY OVER PIN/SOCKET/DIELECTRIC ASSY
- PUT WHITE CONDUCTOR INTO SMALL HOLE AT REAR OF SHIELD ASSY AND BOTTOM SHIELD ASSY AGAINST PIN/SOCKET/DIELECTRIC ASSY SHOULDER
- CRIMP IN PLACE (SEE DETAIL A AND TABLE FOR CRIMP TOOLS AND ACCESSORIES)

STEP 3



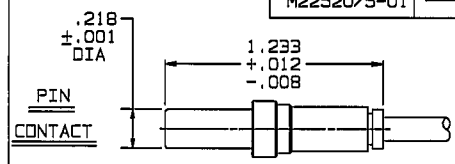
- BEND WHITE CONDUCTOR OUTWARD AND POSITION BLUE CONDUCTOR TO CENTER OF CABLE
- INSTALL PIN/SOCKET/DIELECTRIC ASSY ONTO CABLE WITH BLUE CONDUCTOR INTO CENTER CONTACT & WHITE CONDUCTOR POSITIONED THROUGH SIDE SLOT
- PUSH BACK DIELECTRIC PRIOR TO CRIMPING. RE-SEAT AND VERIFY OVERALL LENGTH, (SEE DIMS ABOVE) (SEE ALSO TABLE FOR CRIMP TOOL AND ACCESSORIES)

STEP 5



- PUSH ASSEMBLY INTO BODY ASSY UNTIL BOTTOMED, HOLD ASSEMBLY FIRMLY BOTTOMED USING CONTACT PRESSURE AID (FA 22680-9 FOR PIN OR FA22680-10 FOR SOCKET) UNTIL FULLY HEX CRIMPED

BASIC CRIMPING TOOL	CTR CONTACT POSITIONER	INTERMEDIATE (SHIELD) CRIMP DIE	OUTER SHIELD (BODY) CRIMP DIE	SOURCE
M22520/5-01		① CD5-4/CLOSURE B	① CD5-4/CLOSURE A	① TEI
M22520/2-01	② K709			② DANIELS
M22520/5-01		② Y631/CLOSURE B	② Y631/CLOSURE A	② DANIELS



MADE IN USA

QTY	DESCRIPTION	PART NUMBER	ITEM
TOL UNLESS SPECIFIED	TROMPETER ELECTRONICS, INC.		SPECIAL SPEC/SPCS CONTACT, NASA SPEC SSG22680
OWN R L 2/28/00	MATERIAL	CODE IDENT	DRAWING NO.
CHK (RM) 3/16/00		14949	305-0864
ENGR	SCALE	DATE 9-29-93	SHEET 3
NEXT ASSY	APPR (RM) 3/16/00		