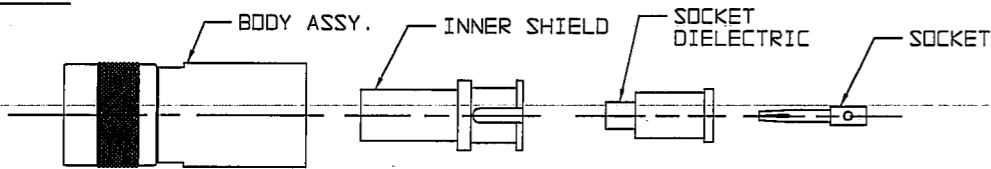


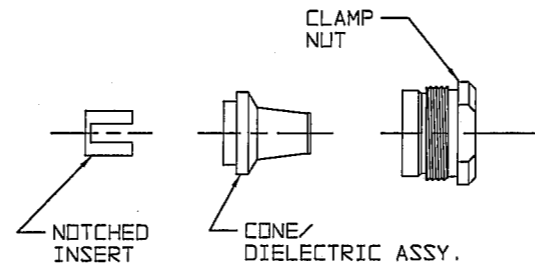
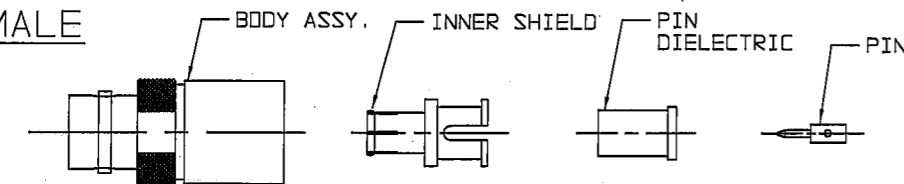
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REVISIONS		TAI-116	SH 1
REV	DESCRIPTION	DATE	APPROVED
E	REVISED PER ECD 15750	1-21-05	WS

MALE



FEMALE



ASSEMBLY INSTRUCTIONS

"WRENCH CRIMP" 80 SERIES  
CONCENTRIC TWINAX CONNECTORS  
TO 1/4" & 1/2" DIA. TWINAX CABLE

**TROMPETER**  
ELECTRONICS, INC.  
5550 E. McDowell Road  
Mesa, Arizona USA 85215  
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Mfg. Code No. 14949  
www.trompeter.com

TAI-116

REV E

ASSEMBLY INSTRUCTIONS

"80 SERIES"

- PRODUCTS
- PATCH PANELS, PATCH CORDS, JACKS, LOOPING PLUGS
  - POWER DIVIDERS, RF CONNECTORS
  - TWINAX, TRIAX, QUADRAX COMPONENTS
  - SYSTEMS

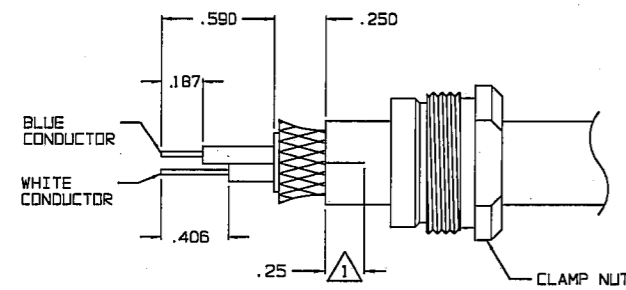
APPLICATIONS

- COMPUTERS - TV BROADCAST - CATV - CCTV - ETV
- COMMUNICATIONS - TELEPHONE - TELEMETRY
- AIRCRAFT - NUCLEAR AND INDUSTRIAL

INSTRUMENTATION

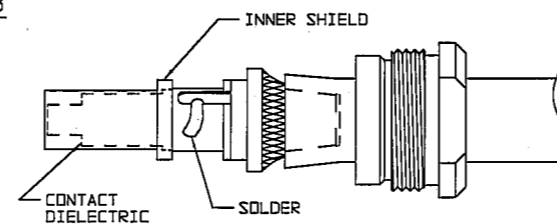
- PROCESS CONTROLS - SECURITY EQUIPMENT
- AUTOMATIC TESTING - INFORMATION RETRIEVAL
- MICROWAVE DATA TRANSMISSION

STEP 1



- PLACE CLAMP NUT ONTO CABLE.
- STRIP CABLE AS SHOWN AND FLARE BRAID.  
( $\triangle$  LATERAL SLITS 180° APART RECOMMENDED FOR INFLEXIBLE CABLES)
- LIGHTLY TIN CONDUCTORS.

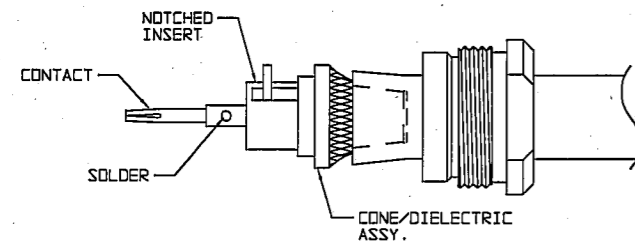
STEP 3



- PLACE CONTACT DIELECTRIC OVER CONTACT UNTIL BOTTOMED.
- INSTALL INNER SHIELD OVER CONTACT DIELECTRIC AND SEAT AGAINST CONE DIELECTRIC ASSY WITH CONDUCTOR THRU SIDE SLOT.
- WRAP CONDUCTOR BETWEEN SHIELD RIDGES AND SOLDER, DO NOT ALLOW CONDUCTOR OR SOLDER TO EXTEND ABOVE RIDGES.

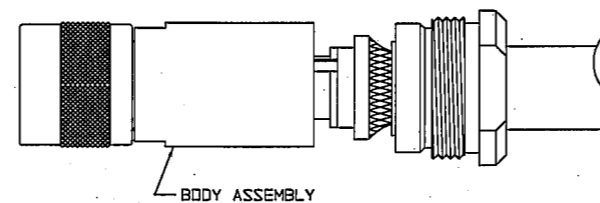
RED INDICATES ORIGINAL

STEP 2



- PUSH EDGE OF CONE UNDER BRAID UNTIL BRAID IS FLUSH WITH EDGE OF CONE.
- BEND LONGER BARED CONDUCTOR OUTWARD AT 90° AND POSITION OTHER CONDUCTOR TO CENTER OF CABLE.
- INSTALL NOTCHED INSERT WITH CENTERED CONDUCTOR THRU CENTER HOLE AND OTHER CONDUCTOR THRU SIDE SLOT UNTIL SEATED AGAINST CONE/DIELECTRIC ASSY.
- PLACE CENTER CONTACT OVER CENTERED CONDUCTOR. HOLD AGAINST NOTCHED INSERT AND SOLDER THRU SIDE HOLE.

STEP 4



- BRING CLAMP NUT UP ONTO TAPERED PORTION OF CABLE.
- ASSEMBLE BODY ASSY OVER ENTIRE ASSEMBLY AND ENGAGE WITH CLAMP NUT.
- WRENCH TIGHTEN TO 30-40 IN LB TORQUE.

INTERPRET DRAWING PER MIL-STD-100 DIMENSIONS ARE IN INCHES AND DECIMAL FRACTIONS UNLESS OTHERWISE SPECIFIED

DRAWN: AAH  
CHECKED: SD  
DATE: 1-14-05  
QUALITY: MS  
HANDLED: BR  
APPROVED: WS  
CAD FILE NO.: TAI-116E

TOL: UNLESS SPECIFIED  
.XX  
.XXX  
.XXXX  
ANGLES

MATERIAL:  
FINISH:

**TROMPETER**  
ELECTRONICS, INC.

TITLE:  
ASSY INSTR 80 SERIES  
TO 1/4" & 1/2" DIA. TWINAX CABLE

SIZE: B  
CAGE CODE: 14949  
DRAWING NO.: TAI-116  
REV.: E

DO NOT SCALE DWG SCALE: N/A DATE: SHEET: 1 OF 1