



TECHNICAL NOTE

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The following reference guide was designed by Technical Support as a mechanism for the easy identification of tools used for assembly with Trompeter connectors. Typically, all Trompeter engineering control drawings has the appropriate TAI (Trompeter Assembly Instruction) listed on sheet 1. In addition, the appropriate assembly instruction may be stamped on the bag in which the part is packaged. Once the TAI for the part has been identified, you then find the listing for the TAI, and all pertinent tool information will be listed.

Tables 1 and 2 also contain tooling information regarding Trompeter's standard and broadcast crimp connectors. Table 1 contains the MIL-SPEC tooling recommendations for 50-ohm BNC's, as well as the tooling requirements for commercial 75-ohm connectors. Table 2 has the requirements for UPL2000 series connectors.

If you need any further amplification, or your customer asks a question that is not addressed, contact Bill Berger in Technical Support at (818) 865-6534, or e-mail at bill.berger@trompeter.com. We look forward to your questions.

TROMPETER ASSEMBLY INSTRUCTIONS AND TOOLS

	TOOL	DIE OR LOCATOR	CLOSURE OR SETTING
TAI-117			
CONTACT:	SOLDER		
CRIMP SLEEVE:	CT4L	CD3-(*)	

TAI-A118

MIL-SPEC

50 ohm CONTACT:	M22520/1-01	M22520/1-12
CRIMP SLEEVE:	M22520/5-01	M22520/5-(*)

COMMERCIAL

50 ohm PIN/SOCKET	CT4L	CD3-(*)	C
75 ohm PIN 8 POINT:	010-0055		
75 ohm SOCKET 8 POINT:	010-0088		
75 ohm PIN/SOCKET:	CT4L	CD3-(*)	D
CRIMP SLEEVE:	CT4L	CD3-(*)	

TAI-C118

MIL-SPEC

50 ohm CONTACT:	M22520/1-01	M22520/1-12
CRIMP SLEEVE:	M22520/5-01	M22520/5-(*)

COMMERCIAL

50 ohm PIN/SOCKET	CT4L	CD3-(*)	C
75 ohm PIN 8 POINT:	010-0055		
75 ohm SOCKET 8 POINT	010-0088		
75 ohm PIN/SOCKET:	CT4L	CD3-(*)	D
CRIMP SLEEVE:	CT4L	CD3-(*)	

TAI-D118

75 ohm PIN 8 POINT:	010-0055		
75 ohm SOCKET 8 POINT:	010-0088		
CRIMP SLEEVE:	CT4L	CD3-(*)	

TAI-122

CONTACT:	M22520/2-01	010-0041	4
SHIELD ASSY:	CT4L	CD3-4	A
CRIMP SLEEVE:	CT4L	CD3-4	

TAI-123

MIL-SPEC

50 ohm CONTACT:	M22520/1-01	M22520/1-12
CRIMP SLEEVE:	M22520/5-01	M22520/5-(*)

COMMERCIAL

50 ohm PIN/SOCKET	CT4L	CD3-(*)	C
75 ohm SOCKET 8 POINT:	010-0088		
75 ohm PIN/SOCKET:	CT4L	CD3-(*)	D
CRIMP SLEEVE:	CT4L	CD3-(*)	

TOOL	DIE OR	CLOSURE OR
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LOCATOR SETTING				
TAI-132				
CONTACT:	M22520/2-01	K709	4	
SHIELD ASSY:	M22520/5-01	CD5-4	B	
BODY ASSY:	M22520/5-01	CD5-4	A	
TAI-133				
CONTACT:	SOLDER			
CRIMP SLEEVE:	CT4L	CD3-(*)		
TAI-134				
CONTACT:	SOLDER			
CRIMP SLEEVE:	CT4L	CD3-(*)		
TAI-137				
CONTACT:	SOLDER			
CRIMP SLEEVE:	CT4L	CD3-(*)		
TAI-138				
PIN CONTACT:	M22520/1-01	010-0044	4	
SOCKET CONTACT:	M22520/1-01	010-0045	4	
SHIELD ASSY:	M22520/5-01	CD5-8	B	
BODY ASSY:	M22520/5-01	CD5-8	A	
TAI-141				
CONTACT:	SOLDER			
CRIMP SLEEVE:	CT4L	CD3-1		
TAI-143				
CONTACT:	M22520/2-01	010-0041	4	
SHIELD ASSY:	M22520/5-01	CD5-9	B	
BODY ASSY:	M22520/5-01	CD5-9	A	
TAI-144				
CONTACT:	M22520/2-01	010-0043	4	
SHIELD ASSY:	M22520/5-01	CD5-8	B	
BODY ASSY:	M22520/5-01	CD5-8	A	
TAI-146				
MIL-SPEC				
50 ohm CONTACT:	M22520/1-01	M22520/1-12		
CRIMP SLEEVE:	M22520/5-01	M22520/5-(*)		
COMMERCIAL				
50 ohm CONTACT:	CT4L	CD3-(*)	C	
CRIMP SLEEVE:	CT4L	CD3-(*)		
TAI-149				
CONTACT:	M22520/2-01	K709	4	
BODY ASSY:	M22520/5-01	CD3-10	A	
	TOOL	DIE OR	CLOSURE OR	

* See Table 1

	LOCATOR SETTING		
TAI-150			
CONTACT:	M22520/2-01	K709	4
SHIELD ASSY:	M22520/5-01	CD5-7	B
BODY ASSY:	M22520/5-01	CD5-7	A
TAI-153			
CONTACT:	M22520/2-01	010-0041	4
SHIELD ASSY:	M22520/5-01	CD5-11	B
BODY ASSY:	M22520/5-01	CD5-11	A
TAI-154			
CONTACT:	M22520/1-01	010-0044	4
SHIELD ASSY:	M22520/5-01	CD5-10	B
BODY ASSY:	M22520/5-01	CD5-10	A
TAI-157			
CONTACT:	M22520/2-01	010-0041	4
SHIELD ASSY:	M22520/5-01	CD5-11	B
BODY ASSY:	M22520/5-01	CD5-11	A
TAI-161			
PIN:	M22520/1-01	010-0044	4
SOCKET:	M22520/1-01	010-0045	4
SHIELD ASSY:	M22520/5-01	CD5-8	B
BODY ASSY:	M22520/5-01	CD5-8	A
TAI-162			
CONTACT:	M22520/2-01	010-0041	4
SHIELD ASSY:	M22520/5-01	CD5-9	B
BODY ASSY:	M22520/5-01	CD5-9	A
TAI-166			
PIN:	M22520/1-01	010-0044	4
SOCKET:	M22520/1-01	010-0045	4
SHIELD ASSY:	M22520/5-01	CD5-8	B
BODY ASSY:	M22520/5-01	CD5-8	A
TAI-167			
CONTACT:	M22520/2-01	010-0043	4
SHIELD ASSY:	M22520/5-01	CD5-8	B
BODY ASSY:	M22520/5-01	CD5-8	A
TAI-168			
PIN:	M22520/1-01	010-0044	4
SOCKET:	M22520/1-01	010-0045	4
SHIELD ASSY:	M22520/5-01	CD5-10	B
BODY ASSY:	M22520/5-01	CD5-10	A
	TOOL	DIE OR LOCATOR	CLOSURE OR SETTING

* See Table 1

TAI-169

CONTACT:	M22520/1-01	010-0044	4
SHIELD ASSY:	M22520/5-01	CD5-8	B
BODY ASSY:	M22520/5-01	CD5-8	A

TAI-170

CONTACT:	M22520/2-01	010-0041	4
SHIELD ASSY:	M22520/5-01	CD5-120	B
BODY ASSY:	M22520/5-01	CD5-120	A

TAI-173

CONTACT:	M22520/2-01	010-0043	4
SHIELD ASSY:	M22520/5-01	CD5-13	B
BODY ASSY:	M22520/5-01	CD5-13	A

TAI-177

CONTACT:	SOLDER		
CRIMP SLEEVE:	CT4L	CD3-(*)	

TAI-178

CONTACT:	M22520/1-01	010-0044	4
SHIELD ASSY:	M22520/5-01	CD5-10	B
BODY ASSY:	M22520/5-01	CD5-10	A

TAI-179

CONTACT:	CT4L	CD3-(*)	C
CRIMP SLEEVE:	CT4L	CD3-(*)	

TAI-186

CONTACT:	M22520/2-01	010-0041	4
SHIELD ASSY:	M22520/5-01	CD5-10	B
BODY ASSY:	M22520/5-01	CD5-10	A

TAI-187

CONTACT 8 POINT:	010-0071		
CRIMP SLEEVE:	CT4L	CD3-3	A

TAI-188

CONTACT:	M22520/2-01	K709	4
SHIELD ASSY:	M22520/5-01	CD5-4	B
BODY ASSY:	M22520/5-01	CD5-4	A

TAI-190

CONTACT:	M22520/2-01	010-0041	4
SHIELD ASSY:	M22520/5-01	CD5-11	B
BODY ASSY:	M22520/5-01	CD5-11	A

TOOL	DIE OR LOCATOR	CLOSURE OR SETTING
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TAI-191

* See Table 1

CONTACT:	SOLDER		
CRIMP SLEEVE:	CT4L	CD3-2 FOR -1,-2,-5	B
		CD3-1 FOR -4,-6,-7	A
		CD3-2 FOR -3	A

TAI-192-1

CONTACT 8 POINT:	010-0070		
CRIMP SLEEVE:	CT4L	010-0118-17	A
		(NOTE 1)	

TAI-192-2/3

CONTACT 8 POINT:	010-0070		
CRIMP SLEEVE:	CT4L	010-0118-17	B
		(NOTE 1)	

TAI-193-1

CONTACT 8 POINT:	010-0097		
CRIMP SLEEVE:	CT4L	010-0118-17	A
		(NOTE 1)	

TAI-193-2/3

CONTACT 8 POINT:	010-0097		
CRIMP SLEEVE:	CT4L	010-0118-17	B
		(NOTE 1)	

TAI-196

MIL-SPEC

50 ohm CONTACT:	M22520/1-01	M22520/1-12	6
CRIMP SLEEVE:	M22520/5-01	M22520/5-(*)	

COMMERCIAL

50 ohm SOCKET	CT4L	CD3-(*)	C
75 ohm SOCKET 8 POINT:	010-0055		
CRIMP SLEEVE:	CT4L	CD3-(*)	

TAI-198

PIN:	M22520/1-01	010-0044	4
SOCKET:	M22520/1-01	010-0045	4
SHIELD ASSY:	M22520/5-01	CD5-10	B
BODY ASSY:	M22520/5-01	CD5-10	A

TAI-199

MIL-SPEC

CONTACT:	M22520/1-01	M22520/1-12	
CRIMP SLEEVE:	M22520/5-01	M22520/5-(*)	

COMMERCIAL

CONTACT:	CT4L	CD3-(*)	C
CRIMP SLEEVE:	CT4L	CD3-(*)	

TAI-200

CONTACT 8 POINT:	010-0097		
CONTACT:	CT4L	CD3-(*)	D
CRIMP SLEEVE:	CT4L	CD3-(*)	
	TOOL	DIE OR	CLOSURE OR
		LOCATOR	SETTING

TAI-201

CONTACT:	M22520/2-01	010-0096	6
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* See Table 1

SHIELD ASSY:	M22520/5-01	CD5-14	B
CRIMP SLEEVE:	M22520/5-01	CD5-14	A

TAI-202-1/4

CONTACT 8 POINT:	010-0055		
CRIMP SLEEVE:	CT4L	CD3-11	A

TAI-202-2

CONTACT 8 POINT:	010-0055		
CRIMP SLEEVE:	CT4L	CD3-11	B

TAI-203-1/2

CONTACT 12 POINT:	010-0100		
CONTACT:	CT4L	CD3-(*)	D
CRIMP SLEEVE:	CT4L	CD3-(*)	

TAI-204

CONTACT:	M22520/2-01	010-0041	4
SHIELD ASSY:	M22520/5-01	CD5-9	B
CRIMP SLEEVE:	M22520/5-01	CD5-9	A

TAI-205-1

CONTACT 8 POINT:	010-0097		
CRIMP SLEEVE:	CT4L	010-0118-17 (NOTE 1)	A

TAI-205-2/3

CONTACT 8 POINT:	010-0097		
CRIMP SLEEVE:	CT4L	010-0118-17 (NOTE 1)	B

TAI-206

CONTACT:	M22520/2-01	010-0109	6
SHIELD ASSY:	M22520/5-01	CD5-14	B
CRIMP SLEEVE:	M22520/5-01	CD5-14	A

TAI-207-1/4

CONTACT 8 POINT:	010-0097		
CRIMP SLEEVE:	CT4L	010-0118-17 (NOTE 1)	A

TAI-207-2/3

CONTACT 8 POINT:	010-0097		
CRIMP SLEEVE:	CT4L	010-0118-17 (NOTE 1)	B

TAI-207-5

CONTACT 8 POINT:	010-0097		
CRIMP SLEEVE:	CT4L	010-0118-18 (NOTE 1)	A

TOOL	DIE OR LOCATOR	CLOSURE OR SETTING
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TAI-208-1/4

CONTACT 8 POINT:	010-0097		
CRIMP SLEEVE:	CT4L	010-0118-17	A

* See Table 1

(NOTE 1)			
TAI-208-2/3			
CONTACT 8 POINT:	010-0097		
CRIMP SLEEVE:	CT4L	010-0118-17	B
(NOTE 1)			
TAI-208-5			
CONTACT 8 POINT:	010-0097		
CRIMP SLEEVE:	CT4L	010-0118-18	A
(NOTE 1)			
TAI-209			
CONTACT:	M22520/2-01	010-0096	6
SHIELD ASSY:	M22520/5-01	CD5-15	B
CRIMP SLEEVE:	M22520/5-01	CD5-15	A
TAI-214 (ONE PIECE F-CONN.)			
BODY ASSY:	CT4L	CD6-1	F1/F3 USE .360 F2 USE .324
TAI-216			
CONTACT 8 POINT:	010-0097		
CONTACT 12 POINT:	010-0098		
CONTACT:	CT4L	CD3-(*)	D
CRIMP SLEEVE:	CT4L	CD3-(*)	
TAI-217			
CONTACT 8 POINT:	010-0097		
CONTACT 12 POINT:	010-0098		
CONTACT:	CT4L	CD3-(*)	D
CRIMP SLEEVE:	CT4L	CD3-(*)	B
TAI-218			
PIN:	M22520/1-01	010-0044	4
SOCKET:	M22520/1-01	010-0045	4
SHIELD ASSY:	M22520/5-01	CD5-10	B
BODY ASSY:	M22520/5-01	CD5-10	A
TAI-219			
PIN:	M22520/1-01	010-0044	4
SOCKET:	M22520/1-01	010-0045	4
SHIELD ASSY:	M22520/5-01	CD5-8	B
BODY ASSY:	M22520/5-01	CD5-8	A
TAI-220			
PIN 8 POINT:	010-0055		
SOCKET 8 POINT:	010-0088		
PIN/SOCKET:	CT4L	CD3-(*)	D
CRIMP SLEEVE:	CT4L	CD3-(*)	
	TOOL	DIE OR LOCATOR	CLOSURE OR SETTING
TAI-221			
75 ohm PIN 8 POINT:	010-0055		
CRIMP SLEEVE:	CT4L	CD3-(*)	

* See Table 1

TAI-223

75 ohm PIN 8 POINT:	010-0055		
CRIMP SLEEVE:	CT4L	CD3-(*)	

TAI-225 (UPL2000-D5)

75 ohm PIN:	M22520/1-01	010-0045	6
75 ohm PIN:	CT4L	CD3-1,-2,-3	C
CRIMP SLEEVE:	M22520/5-01	CD5-16	

TAI-226 (UPL2000 SEE TABLE 2)

75 ohm PIN 8 POINT CRIMP:	010-0055		
75 ohm PIN:	CT4L	CD3-1,-2,-3	D
CRIMP SLEEVE:	CT4L	CD3-1,-2,-3	B

TAI-227

PIN:	CT4L	CD3-1	C
CRIMP SLEEVE	CT4L	CD3-1	A

MIL-SPEC	
CRIMP SLEEVE	CENTER CONTACT
FOR USE WITH M22520/5-01 TOOL	FOR USE WITH M22520/1-01 TOOL AND M22520/1-12 TURRET HEAD

COMMERCIAL
CRIMP SLEEVE
FOR USE WITH CT4L TOOL

* See Table 1

CABLE GROUP	DIE NUMBER	CLOSURE	CENTER CONTACT SETTING
-001	M22520/5-05	B	3
-002	M22520/5-43	B	3
-003	M22520/5-05	B	4
-004	M22520/5-05	B	3
-005	M22520/5-43	B	3
-006	M22520/5-43	B	4
-007	M22520/5-05	B	3
-008	M22520/5-05	B	3
-009	M22520/5-05	B	4
-010	M22520/5-05	B	6
-011	M22520/5-05	A	5
-012	M22520/5-05	A	5
-013	M22520/5-07	A	6
-013A	M22520/5-07	A	6
-013B	M22520/5-07	A	6
-014	M22520/5-07	A	5
-015	M22520/5-41	A	6
-015A	M22520/5-41	A	6
-016	M22520/5-55	A	5
-017	M22520/5-33	A	6
-018	M22520/5-07	A	6
-019	M22520/5-07	A	4
-020	M22520/5-41	A	5
-021	M22520/5-05	A	5
-022	M22520/5-07	A	4
-023	M22520/5-07	A	4
-024	M22520/5-41	A	5
-025	M22520/5-07	A	4
-026	M22520/5-05	B	3
-027	M22520/5-05	B	3

Table 1

DIE NUMBER	CLOSURE
CD3-1 (NOTE 1)	B
CD3-5	B
CD3-1 (NOTE 1)	B
CD3-1 (NOTE 1)	B
CD3-5	B
CD3-5	B
CD3-1 (NOTE 1)	B
CD3-1 (NOTE 1)	B
CD3-1 (NOTE 1)	B
CD3-1 (NOTE 1)	B
CD3-1	A
CD3-1	A
CD3-2 (NOTE 1)	B
CD3-2 (NOTE 1)	B
CD3-2	B
CD3-2 (NOTE 1)	B
CD3-3	B
CD3-3	B
CD3-2	A
CD3-3	A
CD3-2 (NOTE 1)	B
CD3-2 (NOTE 1)	B
CD3-3	B
CD3-1	A
CD3-2	B
CD3-2 (NOTE 1)	B
CD3-3	B
CD3-2 (NOTE 1)	B
CD3-1 (NOTE 1)	B
CD3-1 (NOTE 1)	B

NOTE 1

THE CD3-19 IS THE RECOMMENDED DIE SET WHEN USING 010-0055 OR ANY OTHER CENTER CONTACT CRIMP TOOL.

UPL2000 TOOL CHART			
UPL2000-	CRIMP DIE FOR USE WITH CT4L	CRIMP SLEEVE CLOSURE	CENTER PIN CLOSURE*
-D1	CD3-1	B	

* See Table 1

-D2	CD3-2	B	D
-D3	CD3-2	B	
-D4	CD3-3	B	
-D5	TAI-225		
-D6	CD3-3	B	D
-D7	CD3-1	B	
-D8	CD3-2	B	
-D9	CD3-2	B	
-D10	CD3-2	A	
-D11	CD3-2	B	
-D12	CD3-1	A	
-D13	CD3-3	A	

TABLE 2

* Additionally, the 010-0055 or any other center pin crimp tool can be used