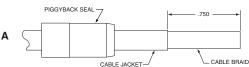
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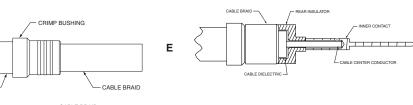
Contact, Socket, Coaxial, Type LJT-RE, TV-R (MIL-DTL-38999 Series I & III) Installation Instructions

See table on reverse side for coaxial cable recommended, crimping tool and positioner information.

- A 1. Rubber end first, slide piggyback grommet seal back over cable jacket, before stripping the cable.
 - Strip cable jacket to expose cable outer braid as illustrated. Ends must be cut cleanly and at right angles to the axial plane of the cable. Cable must not be deformed while making cuts. Hot wire stripping is recommended.
 Slide crimp bushing, large diameter end first, over cable braid
- B 1. Slide crimp bushing, large diameter end first, over cable braid until cable jacket butts inside shoulder of crimp bushing.
- C 1. Flair cable braid back over crimp bushing as illustrated to expose cable dielectric. Trim excess cable braid.
 - Cut away any inner braids and/or wraps as close to outer cable braid as possible.
 Cut cable dielectric to dimension shown.
 - Out cable dielectric to dimension shown.
 Strip cable dielectric to expose center conductor as
- D 1. Strip cable illustrated. E 1. Slide rear
 - Slide rear insulator, large diameter end first, over cable center conductor and dielectric until it butts the cable braid as shown.
 Assemble the inner contact over the center conductor until it
 - Assemble the inner contact over the center conductor until it butts the rear insulator, as shown (trim the cable center conductor if necessary).
 Remove the inner contact & tin the cable center conductor
 - Hemove the inner contact & tin the cable center conductor using a 47.5 watt soldering iron (inner contact wire well may also be tinned). Solder the center conductor into the inner contact wire well. A pin vice can be used to hold the inner contact.
- F 1. Slide the front insulator over the inner contact until the inner contact shoulder butts the inside shoulder of the front insulator. A small gap between the front insulator and rear insulator is permissible.
 G 1. Carefully slide the outer contact over the inner contact
- G 1. Carefully slide the outer contact over the inner contact assembly until the inner assembly is fully seated inside the outer contact.
 - Crimp the outer contact body & crimp bushing in the area indicated using crimp tool listed in table on back.

L-1107-BL June 2019 FSCM77820

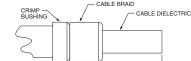




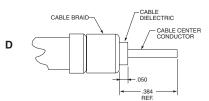
F

CABLE BRA

CRIMP AREA



384





Amphenol Aerospace

AMPHENOL CORPORATION Amphenol Aerospace 40-60 Delaware Avenue Sidney, New York 13838-1395 www.amphenol-aerospace.com

FRONT INSULATOR

PART NO.	COAXIAL CABLE ACCOMMODATED	TOOLS			CONTACT REMOVAL
		SHIELD CRIMP SLEEVE			
		BASIC CRIMPING TOOL	DIE	DIE CLOSURE	TOOL P/N
21-033591-081	GORE CXN3671	M22520/5-01	M22520/5-45	A	MIL-I-81969/14-12 or DANIELS DRK-264-8 or AMPHENOL 11-9170

CONTACT INSERTION INTO CONNECTOR

Contacts are inserted by hand. Slide the wire sealing member (piggyback grommet seal) on the cable and over the crimped shield crimp sleeve. Insert the contact/ cable assembly into proper rear grommet hole. Contact must be aligned with hole and not inserted at an angle. Push forward until contact and wire sealing member is felt to snap into position within the insert. Gently tug on the cable to assure retention.

CONTACT REMOVAL FROM THE CONNECTOR

Remove wire sealing member from grommet (piggyback grommet seal). Position Amphenol removal tool part number 11-9170 or Daniels DRK-264-8 around cable and slide tool toward connector until tool tips enter rear grommet and come to a positive stop on contact. Grip cable and simultaneously remove tool, contact and cable.

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CABLE -JACKET

TRIM EXCESS BRAID

В

С

	LOOLS				
CONTACT REMOVAL N/9 JOOT	SHIELD CRIMP SLEEVE			COBRE COBXIN	.ОИ ТЯАЧ
	CLOSURE DIE	DIE	BASIC CRIMPING	ACCOMMODATED	
DVNIEC2 DBK-564-8 or WIC-I-81969/14-15	A	M225520/5-45	M22520/5-01	CXN3671 GORE	51-033291-081
or AMPHENOL 11-9170					

CONTACT INSERTION INTO CONNECTOR

is felt to snap into position within the insert. Gently tug on the cable to assure and not inserted at an angle. Push forward until contact and wire sealing member cable assembly into proper rear grommet hole. Contact must be aligned with hole seal) on the cable and over the crimped shield crimp sleeve. Insert the contact/ Contacts are inserted by hand. Slide the wire sealing member (piggyback grommet

cgble. positive stop on contact. Grip cable and simultaneously remove tool, contact and and slide tool toward connector until tool tips enter rear grommet and come to a Amphenol removal tool part number 1 t-9170 or Daniels DRK-264-8 around cable Remove wire sealing member from grommet (piggyback grommet seal). Position CONTACT REMOVAL FROM THE CONNECTOR

retention.

AMPHENOL CORPORATION Amphenol Aerospace 40-60 Delaware Avenue Sidney, New York 13838-1395 www.amphenol-aerospace.com

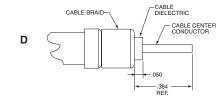
Amphenol Aerospace

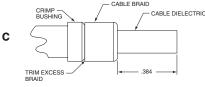
CRIMP AREA

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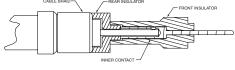


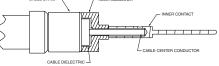






CRIMP BUSHING





Ends must be cut cleanly and at right angles to the axial plane of the cable. Cable must not be deformed while making cuts. Hot wire stripping is recommended. 1. Slide crimp bushing, large diameter end first, over cable braid В

Installation Instructions See table on reverse side for coaxial cable recommended, crimping tool

- until cable jacket butts inside shoulder of crimp bushing.
- С
 - Flair cable braid back over crimp bushing as illustrated to expose cable dielectric. Trim excess cable braid.
 - 2.
 - Cut away any inner braids and/or wraps as close to outer cable

Slide rear insulator, large diameter end first, over cable center

conductor and dielectric until it butts the cable braid as shown.

Assemble the inner contact over the center conductor until it butts the rear insulator, as shown (trim the cable center

conductor if necessary). 3. Remove the inner contact & tin the cable center conductor using a 47.5 watt soldering iron (inner contact wire well may also be tinned). Solder the center conductor into the inner

contact wire well. A pin vice can be used to hold the inner

1. Slide the front insulator over the inner contact until the inner contact shoulder butts the inside shoulder of the front

insulator. A small gap between the front insulator and real

assembly until the inner assembly is fully seated inside the

insulator is permissible. Carefully slide the outer contact over the inner contact

2. Crimp the outer contact body & crimp bushing in the area

indicated using crimp tool listed in table on back

- Cut cable dielectric to dimension shown. 3. Strip cable dielectric to expose center conductor as

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D

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F

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1.

2.

1.

and positioner information.

illustrated.

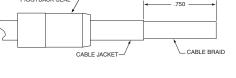
contact

outer contact

1. Rubber end first, slide piggyback grommet seal back over cable jacket, before stripping the cable. 2. Strip cable jacket to expose cable outer braid as illustrated.



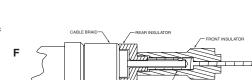
PIGGYBACK SEAL -

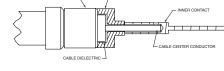


CABLE BRAID

OUTER CONTACT









CABLE -JACKET

Α

В