

21-33197-4

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Contact, Socket, Triaxial Type LJT-R, TV-R Crimp (MIL-C-38999 Series I & III)

Standard contact arrangements available in Series I or III are 17-2, 21-75, 21-79, 25-7 and 25-46.  
Contact is supplied with a piggyback grommet seal.

#### Installation Instructions

- A. 1. Slide piggyback grommet seal over cable outer jacket. Seal rubber end first.
- B. 2. Slide outer crimp bushing over cable outer jacket.
3. Strip cable outer jacket .850 inches.
4. Strip cable outer shield (flat strands) .350 inches.
5. Comb cable outer shield (flat strands) and fan back over cable outer jacket and outer crimp bushing as shown.
6. Using extreme caution, strip metal tape shield .600 inches. Cable interlayer must not be cut while stripping metal tape shield.
7. Open metal tape shield seam slightly as shown in picture "C" and carefully insert spacer bushing insulator over cable interlayer and under opened metal tape shield as shown in picture "B", until it firmly butts at base as shown.
- C. 8. Trim cable metal tape shield even with shoulder on spacer bushing insulator as shown.
- D. 9. Bring cable outer shield (flat strands) forward and bring outer crimp bushing forward over shield strands. Cable outer shield strands must butt against the spacer bushing insulator. Fan shield (flat strands) back over outer crimp bushing and trim to length as shown.
10. Slide inner crimp bushing over cable interlayer insulation (see view D), and firmly butt inner crimp bushing against spacer bushing insulator as shown.
11. Strip cable interlayer ahead of inner crimp bushing.
12. Strip cable inner shield .110 inches ahead of the inner crimp bushing.
- E. 13. Fan inner cable shield back over inner crimp bushing and trim shield ahead of the inner crimp bushing shoulder as shown.
14. Strip cable core .100 ahead of inner shield.
15. Assemble front white teflon insulator over cable inner conductor and cable core until insulator butts against the cable inner shield as shown.
- F. 16. Trim fit inner conductor so the inner socket contact wire well end butts against the white teflon insulator and the cable inner conductor must be visible in the inner socket contact wire well inspection hole.
17. Crimp inner socket contact to cable inner conductor using tool frame part number M22520/2-01 and a Daniels Mfg. Co. positioner part number "K873". For 21-33197-4 assembly use tool selector setting 3.
- G. 18. Slide intermediate contact and insulator assembly over inner socket contact assembly until inner socket contact bottoms in intermediate contact insulator recess as shown.
19. Crimp intermediate pin contact assembly and inner crimp bushing shoulder using crimp tool frame part number M22520/5-01 and die set part number M22520/5-05B (.178 hex). Observe the .375 crimp length shown. Caution: Do not pull on this assembly after crimping.
- H. 20. Slide outer socket contact and insulator assembly over the crimped intermediate pin contact and insulator assembly until the intermediate pin contact and insulator assembly firmly bottoms in the outer socket contact insulator recess as shown.
21. Crimp the outer socket contact and outer crimp bushing using tool frame part number M22520/5-01 and Die set part number M22520/5-45A (.231 hex). Observe the .240-.270 crimp length shown.

#### CONTACT INSERTION INTO THE CONNECTOR

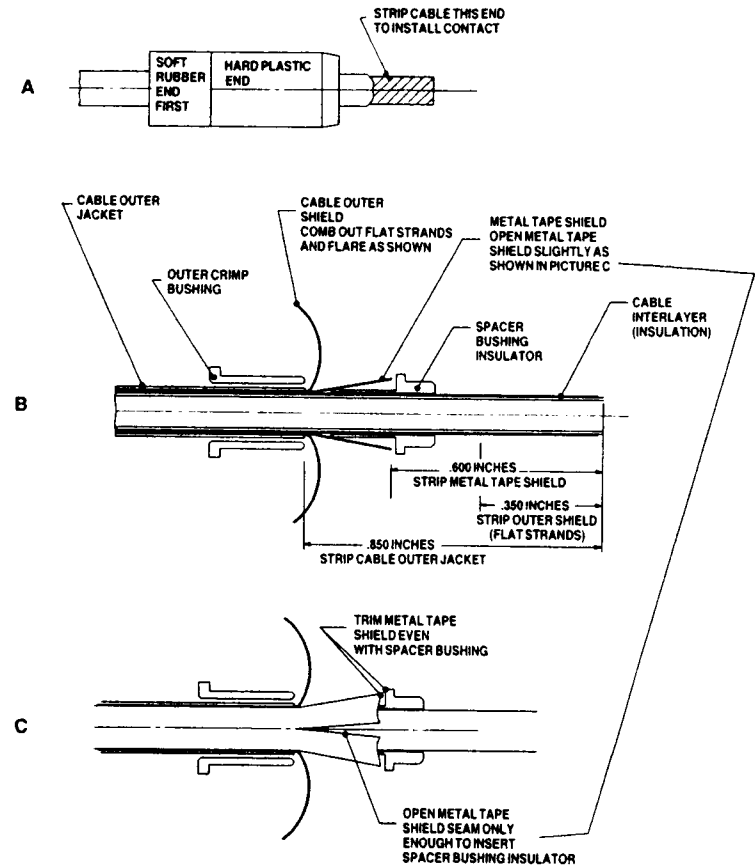
Hand insert contact through proper grommet opening until contact firmly seats inside the connector insert cavity. Tug slightly on cable to insure contact has properly seated in the insert retention device. Slide the piggyback grommet seal down the cable until the hard plastic portion comes to a firm butt inside the grommet cavity.

#### CONTACT REMOVAL FROM THE CONNECTOR

Slide the piggyback grommet seal up the cable and out of the grommet cavity approximately 1.000 inch. Position Daniels Mfg. Co. removal tool part number DRK264-8 around the cable jacket and slide tool down the cable until tool tips enter the rear grommet and come to a positive stop. Hold the tool tip firmly against the positive stop on the contact and grip the cable jacket and simultaneously remove tool, contact and cable.

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