

21-33197-10 (Socket)
21-33198-10 (Pin)

Contact, Pin & Socket, Triaxial, Type LJT-R and TV-R Crimp, Size 8
(MIL-C-38999 Series I and III)

Standard contact arrangements available in Series I and III are: 17-2, 21-75, 21-79, 25-7, 25-17, 25-26 and 25-46

Installation Instructions

1. Slide piggyback grommet seal over cable outer jacket, rubber seal end first.
2. Slide the outer crimp ferrule over the cable outer jacket as shown.
3. Strip cable outer jacket .800 inches as shown. Do not cut or nick outer shield wire strands under the jacket.
4. Strip cable outer shield .600 inches as shown.
Do not cut or nick cable interlayer dielectric insulation under outer shield.
5. Slide intermediate crimp ferrule over cable interlayer dielectric insulation as shown.
6. Strip cable interlayer dielectric insulation .430 inches as shown. Do not cut or nick intermediate shield wire strands under the cable interlayer.
7. Strip cable intermediate shield wire strands .275 inches as shown. Do not cut or nick cable core dielectric insulation under the intermediate shield.
8. Flare intermediate shield and strip the cable core insulation .235 inches as shown. Do not cut or nick cable center conductor wire strands under the cable core insulation.
9. Slide support insulator, large end first, over cable center conductor and butt firmly against the cable core dielectric insulation. Be sure all wire strands of center conductor pass through the insulator and are not pushed back into the insulator rear portion.
10. Trim cable center conductor strands to fit inner contact wire well. All the center conductor strands must be inside the inner contact wire well and visible through the wire well inspection hole. The inner contact must firmly butt the support insulator which firmly butts the cable core dielectric insulation.
11. Crimp the inner contact wire well using a M22520/2-01 crimp tool and a "Daniels" Mfg. Co." contact positioner part number "K873". Tool selector setting shall be number 4.
12. Carefully slide the intermediate contact with an insulator already installed over the inner contact, support insulator and under the cable intermediate shield strands until the inner contact seats in the insulator cavity within the intermediate contact.
13. Using a "Daniels Mfg. Co." reduction type crimp tool: Part Number GS 209 (Turret Head comes with tool), red positioner, simultaneously crimp the intermediate contact three outer rings. Crimp once and then rotate the contact in the tool 45 degrees

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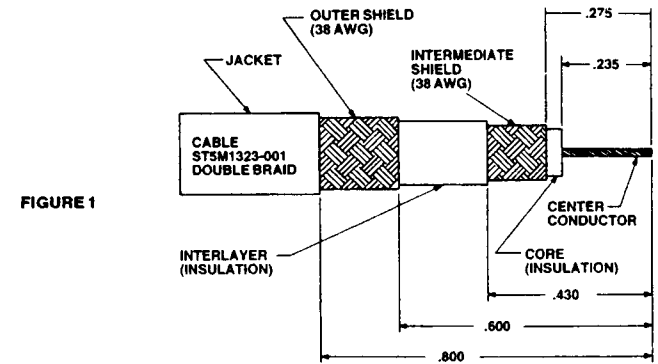


FIGURE 1

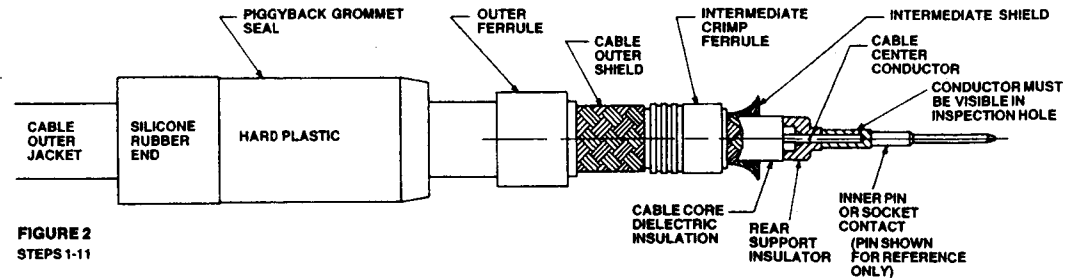


FIGURE 2
STEPS 1-11

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and crimp a second time. After the second crimp, the effective diameter over the crimped contact three rings shall not exceed .1695 inches.

14. Form the cable intermediate shield wire strands forward over the crimp area of the intermediate crimp ferrule and trim strands to within .010 of crimped end ring of the intermediate contact. Bring the intermediate crimp ferrule forward over the shield until the ferrule end is within .010/.030 of the intermediate contact crimped end ring.

CAUTION: Do not allow the ferrule to extend over the intermediate contact crimped rings.

Using same Daniels tool (GS 209), blue positioner, crimp only the intermediate ferrule once and then rotate contact in tool 45 degrees and crimp (ferrule only), a second time. After the second crimp, the effective diameter over the crimped ferrule shall not exceed .1695 inches.

15. Carefully slide the outer contact with insulator already installed, over the crimped intermediate contact assembly and under the cable outer shield strands until the intermediate contact is fully seated in the insulator cavity within the outer contact.
16. Form the cable outer shield wire strands forward over the crimp area of the outer contact and bring the outer crimp ferrule forward over the shield until the ferrule is within the dimension shown.
17. With all internal components firmly seated, simultaneously crimp the outer crimp ferrule and outer contact crimp ring using a M22520/5-01 crimp tool frame and an M22520/5-45 die set cavity "A" (.231 hex .)
18. Electrical Test: (Optional)

Assembled contact shall meet the following requirements:

1. A test voltage of 500 volts AC RMS shall be applied between the inner and intermediate contacts, and between the intermediate and outer contacts.
2. The voltage shall be applied for a period of 2 seconds minimum.
3. The leakage current shall not exceed one (1) milliampere.
4. There shall be no evidence of breakdown or flashover.

CONTACT INSERTION INTO CONNECTOR

Hand insert the contact assembly 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 CONNECTOR

Slide the piggyback grommet seal up the cable and out of connector 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.

FIGURE 3
STEPS 12 & 13

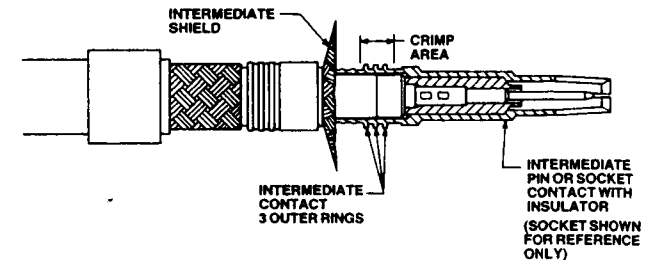


FIGURE 4
STEP 14

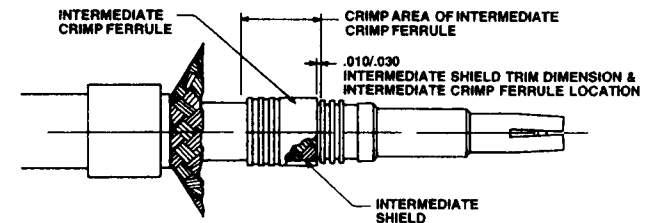


FIGURE 5
STEPS 15-17

