

JN1104S75T  
21-33908-1

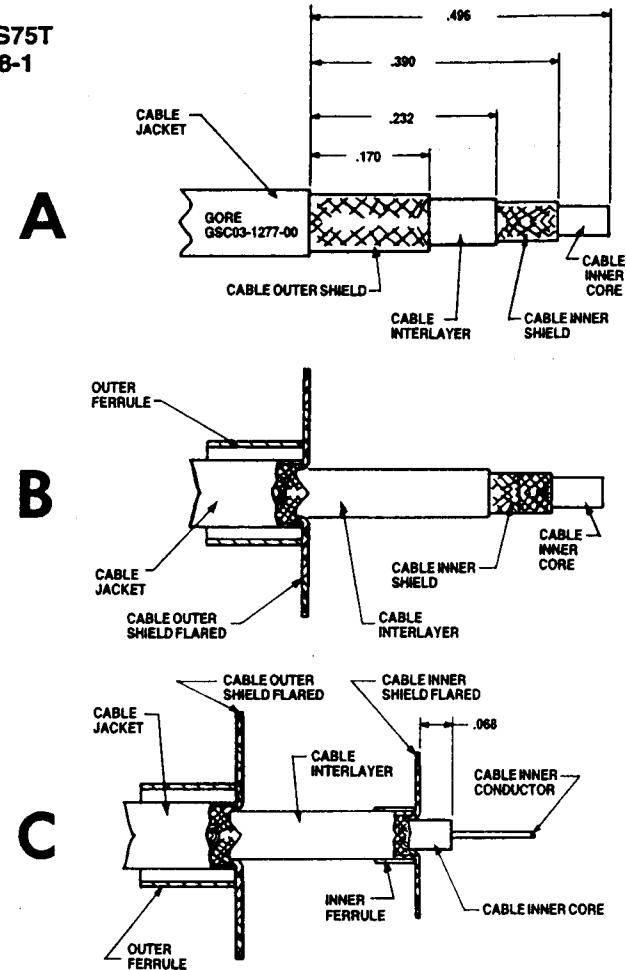
Contact, Socket, Triaxial, Size 12  
Installation Instructions

- A. 1. Strip cable as illustrated. Ends must be cut cleanly and at right angles to the axial plane of the cable. The cable must not be deformed while making the cuts.
- B. 1. Assemble outer ferrule back over cable jacket.  
2. Flair cable outer shield as shown.
- C. 1. Assemble inner ferrule over cable interlayer and flare cable inner shield as shown.  
2. Strip inner cable core insulation as shown.
- D. 1. Slide inner insulator over cable inner conductor until insulator butts cable inner core.  
2. Slide inner socket contact over cable inner conductor until it butts against inner insulator.  
3. Cable inner conductor must be visible through the inspection hole in the inner socket contact wire well.  
4. Crimp inner socket contact wire well using M22520/2-01 crimp tool and a DANIELS K803-1 positioner, setting #3.
- E. 1. Slide intermediate pin contact and insulator assembly over the inner socket contact and inner insulator assembly until inner socket contact is seated in the intermediate contact insulator.  
2. Form cable inner shield over intermediate pin contact and slide inner ferrule forward as shown. Observe .270-.300 dimension.  
3. Crimp intermediate contact and ferrule assembly with a DANIELS GS212 tool and a DANIELS TH553 positioner. Crimp as follows: Crimp once, rotate the contact assembly 45° and crimp a second time. After crimping the second time, the diameter over the shield crimp sleeve must not be greater than .095.
- F. 1. Slide the outer socket contact and insulator assembly over the intermediate pin contact assembly until the intermediate contact is seated against the outer socket contact insulator inside shoulder as shown.
- G. 1. Form cable outer shield over the outer socket contact assembly. Bring outer ferrule forward over cable outer shield and outer socket assembly. Observe .260-.290 dimension. Trim excess shield ahead of the outer crimp ferrule.  
2. Crimp outer ferrule and outer socket contact assembly using a DANIELS GS200-1 crimp tool and a DANIELS GP959 positioner. Crimp as follows: Crimp once, rotate the contact assembly 45° and crimp a second time. After crimping the second time, the diameter over the outer ferrule must not be greater than .152.

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Amphenol Aerospace

AMPHENOL CORPORATION  
Amphenol Aerospace  
40-60 Delaware Avenue  
Sidney, New York 13838-1395

