

21-33875-1
 21-33875-2
 21-33875-3

Contact, Socket, Concentric Twinaxial Type Shielded Crimp
 (MIL-DTL-38999 Series I & III)
 Installation Instructions

Note: 21-33875-3 contact with Type I Seal is designed for use in MIL-DTL-38999 Series III special connector arrangement 25-20 only.

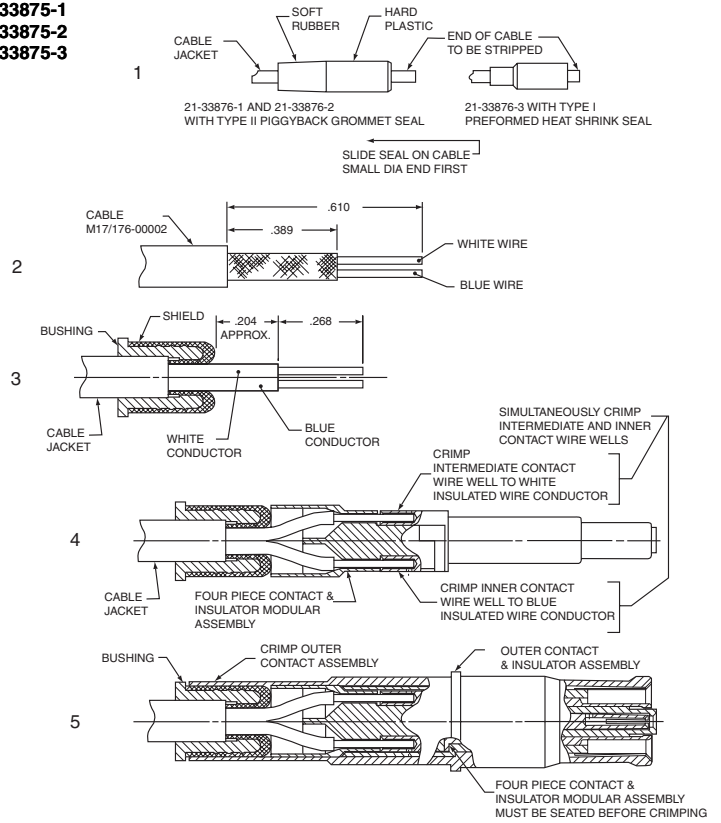
Note: 21-33875-1 and 21-33875-2 contacts with Type II Seal are designed for use in MIL-DTL-38999 Series I and III standard connector arrangements 17-2, 21-75, 21-79, 25-7, and 25-46.

For 21-33875-1: Type II Seal provided with connector.

For 21-33875-2: Type II Seal provided with contact.

1. Assemble Seal. See Figure 1.
 Type I: Preformed heat shrinkable contact wire seal.
 Type II: Piggyback grommet seal.
2. Strip cable per Fig. 2.
3. Screw crimp bushing over cable jacket, flair shield back over crimp bushing and strip inner wires as shown. (Cut off fillers as close to shield as possible.)
4. Assemble intermediate and inner contact (Four piece contact & insulator modular assembly) over wires as shown.
 - A. White insulated wire for intermediate contact.
 - B. Blue insulated wire for inner contact.
 - C. Wire conductors must be visible in the inspection hole of both intermediate and inner contact wire wells before crimping.
 - D. Simultaneously crimp intermediate and inner contact wire wells using DANIELS Crimp Tool Part Number AFMSP-31.
5. Slide outer contact and insulator assembly over four piece contact and insulator modular assembly until it butts firmly. A small gap at the bushing will occur. Crimp assembly, bushing and outer contact, with tool M22520/5-01 and die set DANIELS Y771 or hex cavity of DANIELS Y631.
6. Type I Seal:
 Slide performed heat shrink seal over outer contact until large end is even with base of chamfer on outer contact. Heat shrink seal in place with hot air appliance. Insert contact assembly into the connector grommet until it seats firmly (see contact insertion instructions.)
7. Type II Seal:
 Slide Piggyback Grommet seal on the cable and over outer contact until it butts firmly on contact. Insert contact assembly and seal into the connector grommet until it seats firmly. (See contact insertion instructions).

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**Contact Insertion into Connector
(For Contacts with Type I Seal)**

Position insertion tool part number MIL-I-81969/14-12 around cable and slide tool toward contact until tool comes to a positive stop on the contact shoulder. Simultaneously insert the contact/cable assembly and tool into proper rear grommet hole. Contact must be aligned with hole and not inserted at an angle. Push forward on the insertion tool until contact is felt to snap into position within the insert. Remove insertion tool and gently pull on the cable to assure retention.

**Contact Insertion Into Connector
(For Contacts with Type II Seal)**

Contacts are inserted by hand. Slide the wire sealing member (piggyback grommet seal) on the cable and over the crimped end of the contact. Insert the contact/cable assembly and seal 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 are felt to snap into position within the insert. Gently tug on the cable to assure retention.

**Contact Removal from Connector
(For Contacts with Type I Seal)**

Position removal tool part number MIL-I-81969/14-12, Daniels DRK-264-8 or Amphenol 11-9170 around the 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.

**Contact Removal From Connector
(For Contacts with Type II Seal)**

Remove wire sealing member from grommet, (piggyback grommet seal). Position removal tool part number MIL-I-81969/14-12, Daniels DRK-264-8 or Amphenol 11-9170 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.