

21-33114-42 ()

M39029/25-206

Contact, Pin, Coaxial Type PT-SE, Crimp
Installation Instructions

- A. 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 cuts. Hot wire stripping is recommended.
- B. 1. Slide shield crimp sleeve back over cable jacket.
2. Slide retainer over the cable core and under the cable shield. Retainer must butt bottom against cable shield.
3. Slide back insulator over center conductor and cable core until it butts against the retainer.
4. Slide inner socket contact over cable center conductor. Cable center conductor must be visible through inspection hole in inner socket contact. Contact must butt against the back insulator.
5. Crimp inner socket contact using crimp tool M22520/2-01, setting No. 7, and positioner M22520/2-32.
- C. Slide front insulator, large end first, over the inner socket contact until insulator seats against inner socket contact shoulder.
- D. 1. Slide outer pin contact over insulator and retainer assembly, and under cable shield. Outer pin contact must butt against front insulator.
2. Bring shield crimp sleeve forward over cable shield and butt against outer pin contact shoulder.
3. Crimp the shield crimp sleeve using tool M22520/5-01 and M22520/5-10 die.
- E. Illustrates final assembly.

Contact Insertion

Using Bendix insertion tool P/N 11-8369-2 or P/N 11-8660-2, insert contact assembly into rear connector grommet hole. Contact must be aligned with hole and not inserted at an angle. Pilot pin, Bendix P/N 10-406910-123 may be used to aid insertion of socket contacts. Install pilot into socket prior to insertion and remove through front of connector.

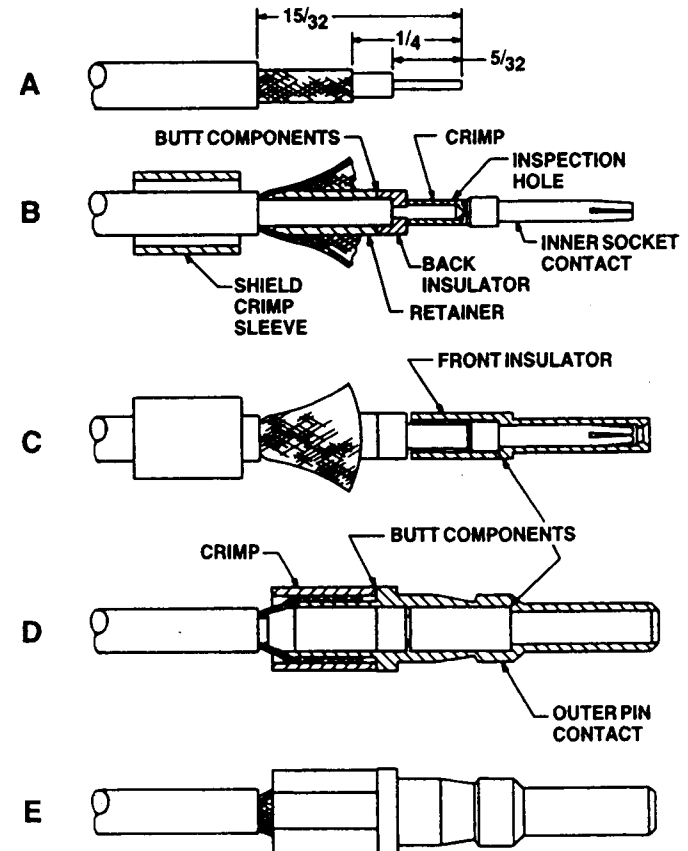
Contact Removal

Position Bendix removal tool P/N 11-7880-12 around contact and insert through front face of connector, until contact retaining bushing is engaged. Rotate tool slightly to open bushing. Disengage contact by pushing the spring loaded sleeve of the tool fully toward the rear of the connector. Remove contact by gripping contact wire well and pulling straight to rear. Do not pull on wire.

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