

21-33121-557

Contact, Socket, Coaxial Type JT-R, Crimp (MIL-C-38999 Series II)

Installation Instructions

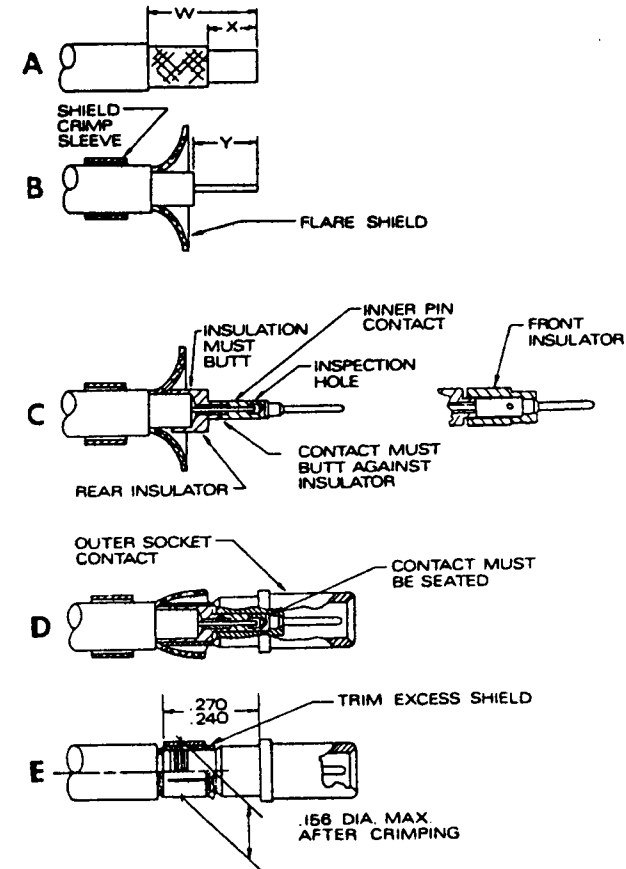
- A. Strip cable as illustrated. Ends must be cut cleanly and at right angles to the axial plane of the cable. The cable must not be deformed while making cuts.
- B. Slide shield crimp sleeve back over the cable jacket. Flare shield as illustrated and strip cable dielectric.
- C. Slide rear insulator over cable dielectric and under cable shield until dielectric bottoms against rear insulator recess.
Slide inner pin contact over cable center conductor. Cable center conductor must be visible through the inspection hole in inner pin contact wire well.
Crimp inner pin contact wire well using crimp tool and positioner listed in table.
Slide front insulator, large end first, over the inner pin contact until insulator seats against inner pin contact shoulder.
- D. Slide outer contact over inner pin assembly and under cable shield until inner pin contact and front insulator are fully seated.
- E. Bring shield crimp sleeve forward over cable shield and observe .240-.270 dimension.
Crimp shield crimp sleeve using tool and positioner in table as follows: Crimp once, rotate the contact assembly 45° and crimp a second time. After crimping the second time, the diameter over the crimp sleeve must not be greater than .156.

CONTACT INSERTION:

Using Bendix® insertion tool P/N 11-8674-12, 11-8794-12 or see table I, insert contact assembly into rear connector grommet hole. Contact must be aligned with hole and not inserted at an angle. Push forward until contact is felt to snap into position within insert. Remove tool.

CONTACT REMOVAL:

Position Bendix® removal tool P/N 11-8675-12, or see table I, around cable and slide tool down wire until tool tips enter rear grommet and come to a positive stop. Hold tool tip firmly against positive stop on contact. Grip the wire and simultaneously remove tool, contact and cable.



L-2035-FZ

October 1985

FSCM77820

 **ALLIED** Amphenol
Products

PART NO.	COAXIAL CABLE ACCOMMODATED	STRIPPING DIMENSIONS			TOOLS						
					INNER CONTACT			OUTER CONTACT			
		W	X	Y	TOOL SELECTOR SETTING NO	BASIC CRIMPING TOOL	POSITIONER	BASIC CRIMPING TOOL	POSITIONER	INSERTION TOOL	REMOVAL TOOL
21-33121-557	MICRODOT 295-3992	0.330	0.140	0.190	4	M22520 2-01	M22520 2-34 K323 (DANIELS)	M22520 31-01 GS200 (DANIELS)	M22520 31-02 G2P330 (DANIELS)	M81969 8-09 or M81969 14-04 or MS27495A12 or MS27534-12	M81969 8-10 or M81969 14-04 or MS27495R12 or MS27534-12