

21-33122-591

Contact, Pin, Coaxial Type JT-R, LJT-R, TV-R, Crimp (MIL-DTL-38999 Series I, II & III)
Installation Instructions

See table on reverse side for coaxial cable recommended, type assembly instructions code, stripping dimensions, tool selector settings, crimping tool and positioner information.

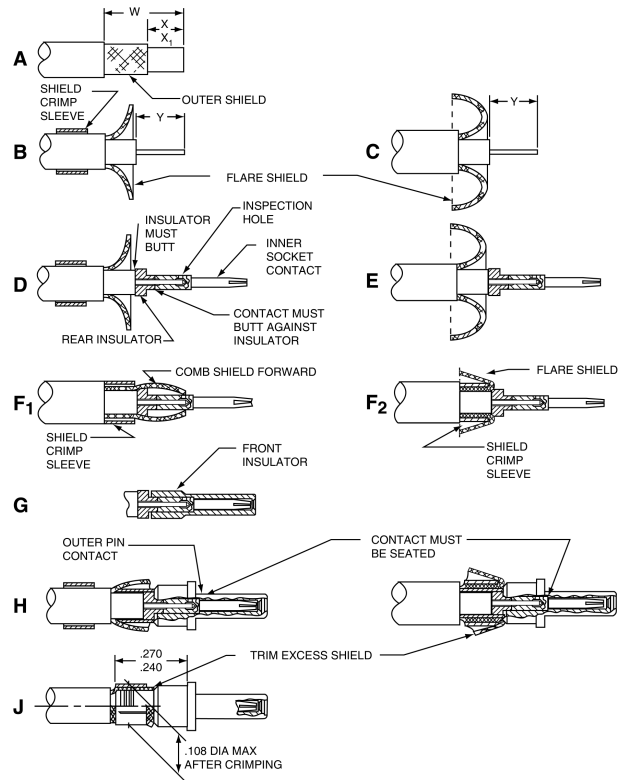
Type
Assy. Figure

- | | | |
|-------|----|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| I, II | 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. |
| I | B | 1. Slide shield crimp sleeve back over cable jacket.
2. Flare shield as illustrated and strip cable dielectric. |
| II | C | Flare shield as illustrated and strip cable dielectric. |
| I, II | D/ | 1. Slide rear insulator over cable center conductor and under cable shield until dielectric bottoms against rear insulator recess. |
| E | | 2. Slide inner socket contact over cable center conductor. Cable center conductor must be visible through the inspection hole in the inner pin contact wire well. |
| | | 3. Crimp inner socket contact wire well using crimp tool and positioner listed in table on back. |
| II | F | 1. Comb shield forward over back insulator and inner socket contact and install shield crimp sleeve.
2. Flare shield in front of crimp sleeve as illustrated. |
| I, II | G | Slide front insulator, large end first, over the inner socket contact until insulator seats against inner socket contact shoulder. |
| I, II | H | Slide outer contact over inner socket assembly and under cable shield until inner socket contact and front insulator are fully seated. |
| I, II | J | 1. Bring shield crimp sleeve forward over cable shield and observe .240 – .270 dimension. Trim excess shield ahead of shield crimp sleeve.
2. Crimp shield crimp sleeve using tool and positioner listed in table on back 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 .108. |

L-2035-GW
August 2005

FSCM 77820

21-33122-591



Amphenol Aerospace

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

PART NO & BIN CODE.	COAXIAL CABLE ACCOMODATED	TYPE ASSEMBLY INSTRUCTIONS	STRIPPING DIMEN- SIONS				TOOLS				
			W	X	Y	X ₁ *	INNER CONTACT			OUTER CONTACT	
							TOOL SELECTOR SETTING NO.	BASIC CRIMPING TOOL	POSITIONER	BASIC CRIMPING TOOL	POSITIONER
21-33122-591	RG-161/U	I	.265	.110	.160	-	3	MS22520/2-01	M22520/2-35 or K532 (DANIELS)	MS22520/4-01	MS22520/4-02
	M17/119-RG174	I	.265	.110	.160	-	3				
	M17/094-RG179	I	.265	.110	.160	-	3				
	RG-187A/U	II	.265	-	.180	.110*	3				
	RG-188A/U	II	.265	-	.160	.110*	5				
	M17/113-RG316	I	.265	.110	.160	-	5				

* Use this dimension only if shield crimp sleeve will go over the cable jacket Dia. and then follow Type I Assembly Instructions.