

21-33732-15

Contact, Pin, Coaxial, Type LJT-R and TV-R, Crimp, Size 12
(MIL-C-38999 Series I & III)
Installation Instructions

- A. Strip twinaxial cable as shown (2.75 approx.). Apply a small amount of DC4 lubricant to wires and slide piggyback grommet seal (red silicone rubber part) over both wire jacket insulations.
- B. Clean wire of DC4 lubrication and strip center conductors as shown.
- C. Crimp conductor of blue/white insulated wire to small pin contact. Insulation must butt contact wire well end and conductor must be visible in contact inspection hole.

Tool: M22520/2-01 (selector setting 5)

Positioner: K532 (Daniels Mfg. Co. Part No.)

Crimp conductor of blue insulated wire to inner socket contact. Insulation must butt contact wire well end and conductor must be visible in contact inspection hole.

Tool: M22520/2-01 (selector setting 5)

Positioner: K323 (Daniels Mfg. Co. Part No.)

- D. Slide orange/tan colored insulator over inner socket contact until socket contact shoulder comes to a firm butt.
- E. Assemble small pin contact and insulator and socket contact into the outer pin contact as illustrated. Insulator must come to a firm butt inside the outer pin contact and the small pin must be visible in the outer contact inspection hole.

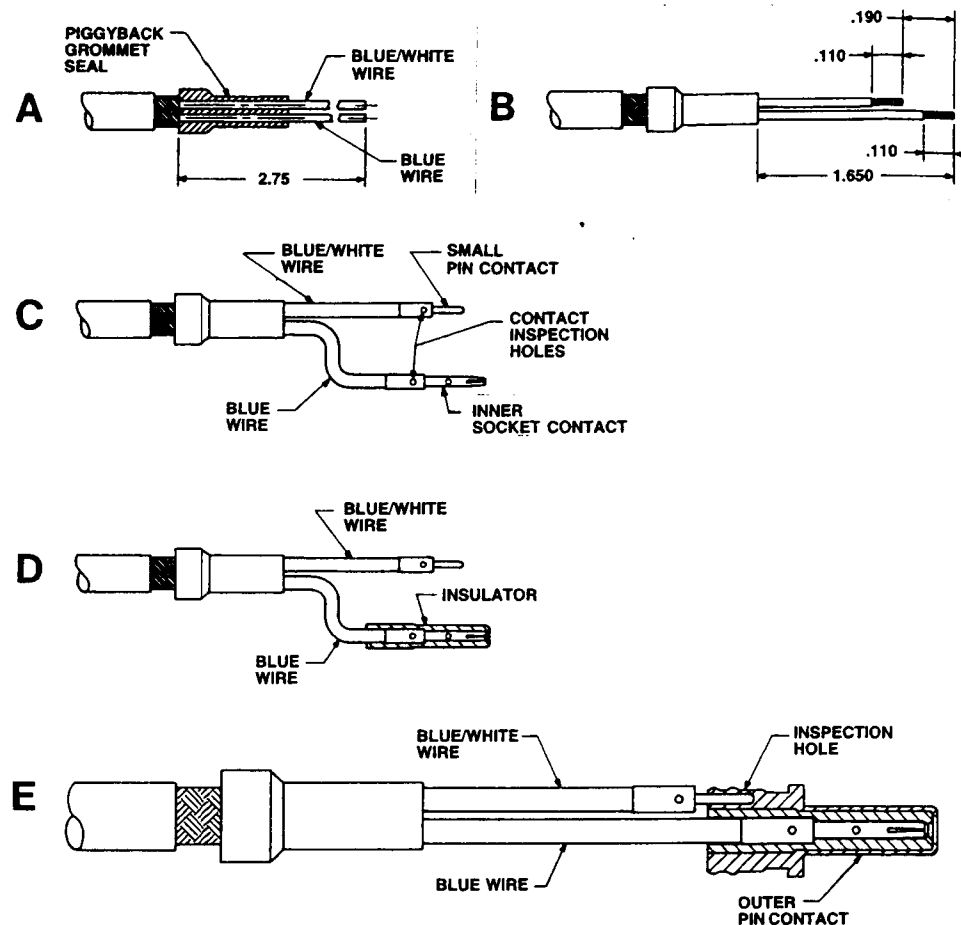
Hold components firmly in position shown and crimp outer pin contact with tool GS200. Positioner G2P330 comes already attached to the tool. (Tool and positioner are Daniels Mfg. Co. Part No.)

Crimp once with tool indenter over small pin location in outer contact. Rotate contact assembly 45 degrees and crimp a second time. This completes crimping required.

Lightly lubricate the piggyback grommet seal and slide down wires to the contact. Wipe off excess lubricant from wire and seal. Insert contact into connector using size 12 insertion tool. The large end of the piggyback grommet seal will extend above the connector grommet face.

To remove contact, lubricate wires and rear of piggyback grommet seal and slide seal up wires far enough to use removal tool (Daniels Mfg. Co. Part No. DRK264-12).

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Amphenol Aerospace

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