

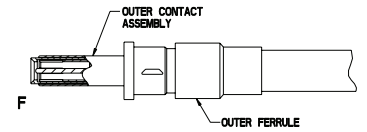
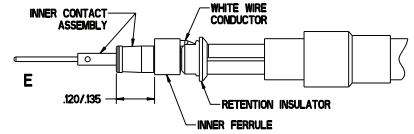
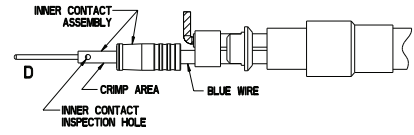
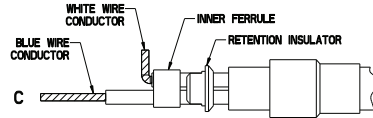
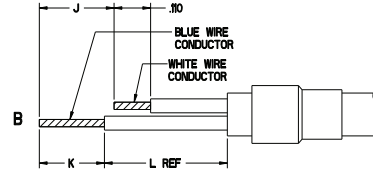
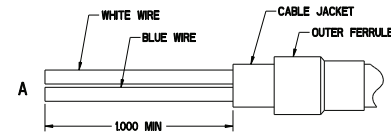
21-033908-121 (SOCKET)
21-033909-121 (PIN)

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

See table on reverse side for cable recommended and crimp tool information.

- A. 1. Assemble outer ferrule over cable jacket, small diameter end first.
2. Strip away cable outer jacket, shield & fillers as illustrated.
- B. 1. Trim & strip blue & white wires as shown (optional method: wire insulation of blue and white wires may be cut at this point, then removed after assembly of retention insulator & inner ferrule (step C1)).
- C. 1. Assemble retention insulator & inner ferrule over blue & white wires as shown.
2. Bend conductor of white wire as shown, to hold inner ferrule & retention insulator in position.
- D. 1. Assemble inner contact assembly over blue wire conductor, until conductor is visible through the inner contact inspection hole.
2. Crimp the inner contact using the crimp tool and positioner listed in table.
- E. 1. Form white wire conductor forward, over the rear of the inner contact assembly. Slide inner ferrule forward over white wire conductor as shown.
2. Crimp inner ferrule using crimp tool and positioned listed in table. Crimp once, rotate tool 45 degrees and crimp again. Continue to rotate tool 15 degrees and crimp until ferrule diameter is .105 max (may take 3 to 4 rotate/crimps).
3. Slide the retention insulator forward until it butts the rear of the inner contact assembly.
- F. 1. Slide outer contact assembly over inner contact assembly, until inner contact assembly snaps into the retention clips of the outer contact assembly (you should hear and/or feel the inner contact assembly snap into the retention clips. If uncertain, a slight pull on the inner assembly can be applied to verify the inner contact is seated within the retention clips).
2. Push the inner contact assembly fully forward inside the outer contact assembly, slide the outer ferrule forward until the inside shoulder butts against the retention insulator.
3. Crimp the outer contact and ferrule using the crimp tool and positioner listed in the table. Crimp once, rotate tool 45 degrees and crimp again. (.156 DIA max. over the ferrule after crimping. Rotate tool 45 degrees and crimp again if necessary).
4. For pin contacts only: after crimping, check the center pin contact to make certain it is approximately centered inside the outer contact. If not centered, carefully bend the center contact into position using Amphenol Aerospace recommended syringe tip (EFD, Inc. part no. 5122-B) or straightening tool (10-597492-001, see sketch)

21-033908-121 (SOCKET)
21-033909-121 (PIN)



Amphenol Aerospace

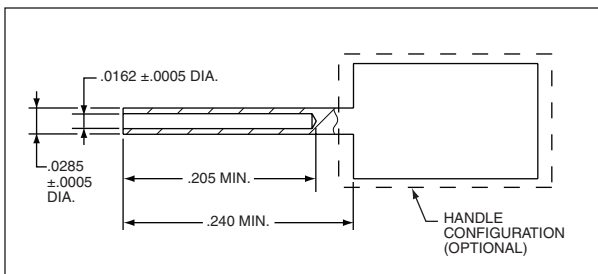
AMPHENOL CORPORATION
Amphenol Aerospace
40-60 Delaware Avenue
Sidney, New York 13838-1395
www.amphenol-aerospace.com

L-2092-AL
December 2017

FSCM77820

Contact Part Number	Description	Cable Accommodated	Inner Tool Setting	Inner Crimp Tool	Inner Tool Positioner	Intermediate Tool and Positioner	Outer Tool and Positioner	J	K	L
21-033908-121	Twinax Socket	M17/176-00002 (inner wires only)	4	MH992	K1365	GS212 GP1271 or GP1613	GS200-1 GP959	.328	.300	.700
21-033909-121	Twinax Pin	M17/176-00002 (inner wires only)	4	MH992	K1365	GS212 GP1271 or GP1613	GS200-1 GP959	.194	.166	.834

CENTER PIN STRAIGHTENING TOOL



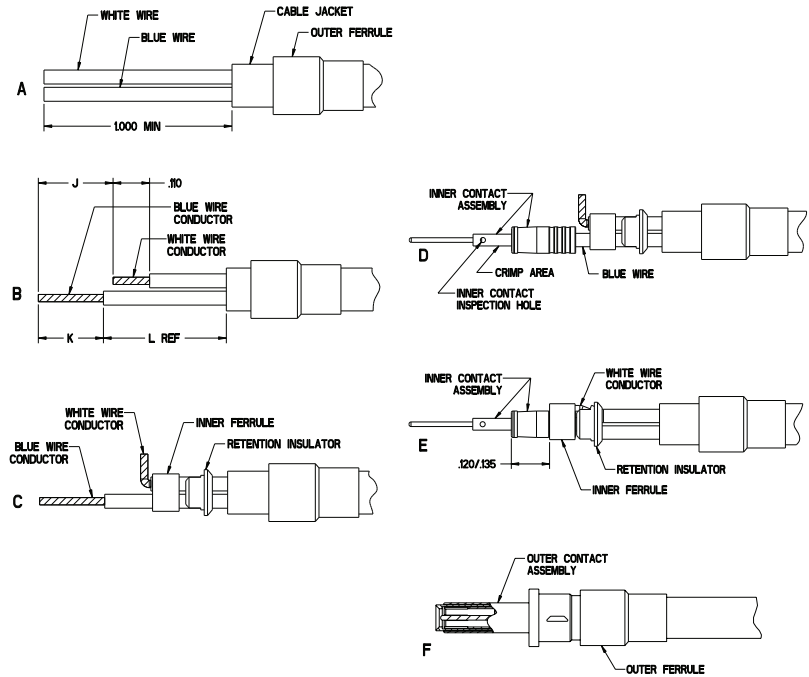
21-033908-121 (SOCKET)
21-033909-121 (PIN)

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

See table on reverse side for cable recommended and crimp tool information.

- A. 1. Assemble outer ferrule over cable jacket, small diameter end first.
2. Strip away cable outer jacket, shield & fillers as illustrated.
- B. 1. Trim & strip blue & white wires as shown (optional method: wire insulation of blue and white wires may be cut at this point, then removed after assembly of retention insulator & inner ferrule (step C1)).
- C. 1. Assemble retention insulator & inner ferrule over blue & white wires as shown.
2. Bend conductor of white wire as shown, to hold inner ferrule & retention insulator in position.
- D. 1. Assemble inner contact assembly over blue wire conductor, until conductor is visible through the inner contact inspection hole.
2. Crimp the inner contact using the crimp tool and positioner listed in table.
- E. 1. Form white wire conductor forward, over the rear of the inner contact assembly. Slide inner ferrule forward over white wire conductor as shown.
2. Crimp inner ferrule using crimp tool and positioned listed in table. Crimp once, rotate tool 45 degrees and crimp again. Continue to rotate tool 15 degrees and crimp until ferrule diameter is .105 max (may take 3 to 4 rotate/crimps).
3. Slide the retention insulator forward until it butts the rear of the inner contact assembly.
- F. 1. Slide outer contact assembly over inner contact assembly, until inner contact assembly snaps into the retention clips of the outer contact assembly (you should hear and/or feel the inner contact assembly snap into the retention clips). If uncertain, a slight pull on the inner assembly can be applied to verify the inner contact is seated within the retention clips).
2. Push the inner contact assembly fully forward inside the outer contact assembly, slide the outer ferrule forward until the inside shoulder butts against the retention insulator.
3. Crimp the outer contact and ferrule using the crimp tool and positioner listed in the table. Crimp once, rotate tool 45 degrees and crimp again. (.156 DIA max. over the ferrule after crimping. Rotate tool 45 degrees and crimp again if necessary).
4. For pin contacts only: after crimping, check the center pin contact to make certain it is approximately centered inside the outer contact. If not centered, carefully bend the center contact into position using Amphenol Aerospace recommended syringe tip (EFD, Inc. part no. 5122-B) or straightening tool (10-597492-001, see sketch)

21-033908-121 (SOCKET)
21-033909-121 (PIN)

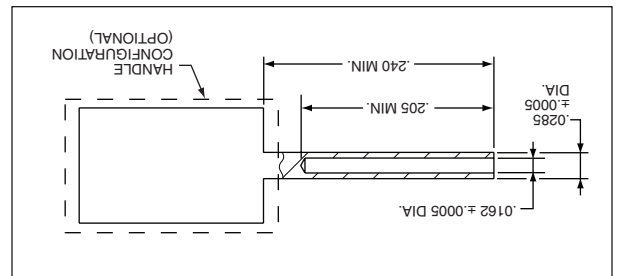


Amphenol Aerospace

AMPHENOL CORPORATION
Amphenol Aerospace
40-60 Delaware Avenue
Sidney, New York 13838-1395
www.amphenol-aerospace.com

L-2092-AL
December 2017

FSCM77820



CENTER PIN STRAIGHTENING TOOL

Contact Part Number	Description	Cable Accommodated	Inner Tool Setting	Inner Crimp Tool	Inner Tool Positioner	Intermediate Tool and Positioner	Outer Tool and Positioner	J	K	L
21-033909-121	Twinax Pin	M17/176-00002 (Inner wires only)	4	MH992	K1365	GS212 GP1271 or GP1613	GS200-1 GP959	.194	.166	.834
21-033908-121	Twinax Socket	M17/176-00002 (Inner wires only)	4	MH992	K1365	GS212 GP1271 or GP1613	GS200-1 GP959	.328	.300	.700