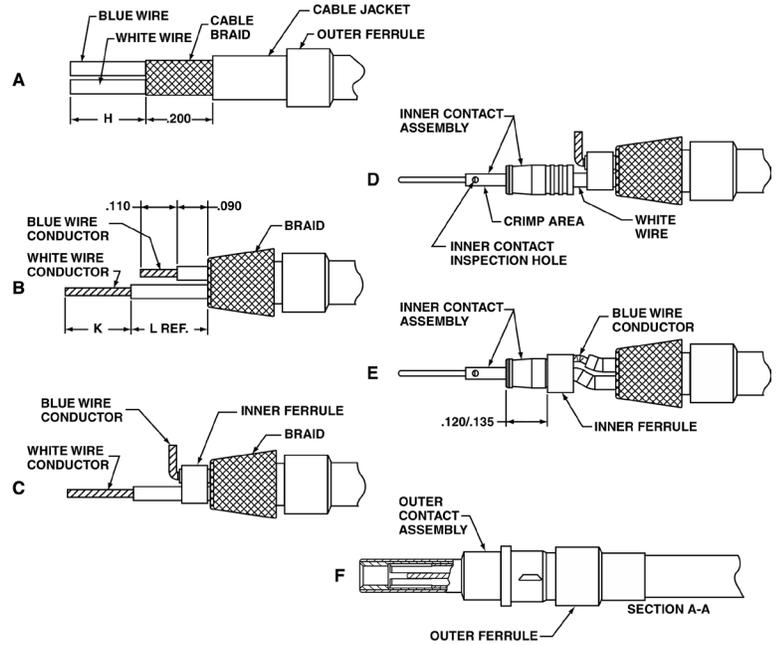


Contact, Size 12, Pin, Twinaxial,
Type ARINC (M83527), Crimp
Installation Instructions

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 cable as illustrated.
- B. 1. Flare cable braid back as shown.
2. Cut off cable fillers (not shown) as close to cable braid as possible.
3. Trim & strip blue and white wires as shown. (Optional method: wire insulation of blue and white wires may be cut at this point, and then removed after assembly of inner ferrule (step C1).)
- C. 1. Assemble inner ferrule over blue and white wires until flush against cable braid.
2. Bend conductor of blue wire as shown, to hold inner ferrule in position.
- D. 1. Assemble inner contact assembly over white 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 on back.
- E. 1. Unravel and fan out blue wire conductor strands. Form conductor strands forward, over the rear of the inner contact assembly. Slide inner ferrule forward and over the blue wire conductor as shown.
2. Crimp inner ferrule using crimp tool and positioner listed in table. Crimp once, rotate tool 45 degrees and crimp again. Crimp until ferrule diameter is .105 Max. (May take 3 to 4 crimps).
- F. 1. Slide outer contact assembly over inner contact assembly, until inner contact assembly snaps into the retention clips of the outer contact assembly.
2. While pushing the inner contact assembly fully forward inside the outer contact, form the cable braid over the rear of the outer contact. Slide the outer ferrule forward over the cable braid until it comes to a stop.
3. Crimp the outer contact and ferrule using the crimp tool and positioner listed in the table. Crimp once, rotate the tool 45 degrees and crimp again. (.156 Dia. Max. over the ferrule after crimping). Rotate tool 45 degrees and crimp again if necessary.
4. After crimping, check the center pin contact to make certain it is approximately centered inside the outer contact. If not centered, with a pointed tool or loose mating socket, carefully bend the center contact into position.



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Contact Part Number	Description	Cable Accommodated	Inner Tool Setting	Inner Crimp Tool	Inner Tool Positioner	Intermediate Tool and Positioner	Outer Tool and Positioner	H	K	L
21-33631-4	Twinax Pin	EPD32263A	3	MH992	K1365	GS225 GP1271	GS200-1 G2P1902	.196	.206	.190
		10612	4							
		GSC-12-2548-00	4							