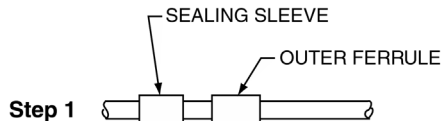
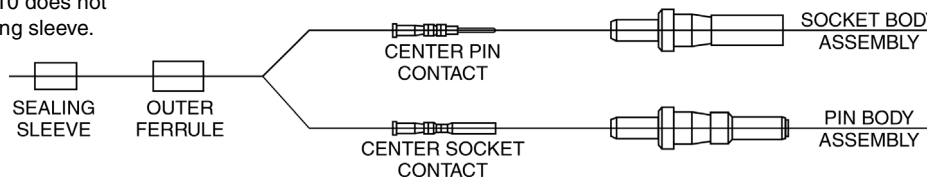


**NO. 1 Shielded Contact  
Assembly Instructions**

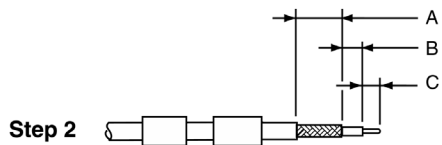
**L-2116**  
Previous document # 21-33580

Note:  
Cable with jacket O.D.  
larger than .110 does not  
require a sealing sleeve.

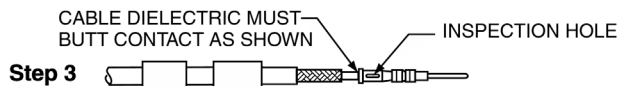
**ILLUSTRATION OF SHIELDED CONTACT**



**Step 1**  
Install sealing sleeve and slide outer ferrule onto cable as shown, prior to stripping cable.



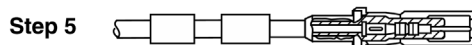
**Step 2**  
Strip cable jacket, braid and dielectric to dimensions indicated in table. All cuts are to be square and sharp. Important - Do not nick braid, dielectric, or center conductor when cutting. If wire ends of center conductor fray, twist them to their normal lay.



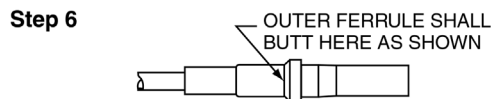
**Step 3**  
Place stripped center conductor into contact until cable dielectric butts and end of wire shows through inspection hole (arrow). Insert contact into crimp tool until fully seated in nest bushing. Crimp with one full stroke. See table for proper nest bushing and crimp tool.



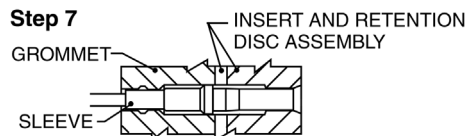
**Step 4**  
Flare out, slightly, the ends of wire braid to facilitate insertion of inner ferrule of body assembly. Do not comb out wire braid.



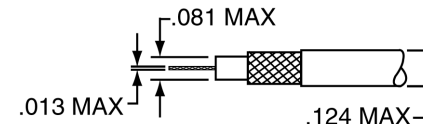
**Step 5**  
Install center contact in body assembly and slide inner ferrule under-neath wire braid as shown. Center contact shall be inserted until it is locked in place in body assembly. A slight pull shall be exerted on cable to assure that the contact is securely locked in place.



**Step 6**  
Slide outer ferrule over wire braid and up against body assembly as shown. No slack shall exist in wire braid. Crimp outer ferrule with crimp tool specified in table. Then slide up sleeve until sleeve touches outer ferrule.



**Step 7**  
The shielded contact, now assembled, shall be inserted into the connector assembly in the same manner as a standard MIL-C-26636 contact. Note: The sleeve shall not protrude beyond .300 inches from edge of grommet.



**WIRE DETAIL**

Amphenol Contact Part Number	48 Series Contact Part Number	Description	Cable Stripping Length			Crimp Tools				Shielded Cable Accomodations
			A	B	C	Center Contacts		Crimp Setting	Outer Ferrule	
			+1/64 -.000	+1/64 -.000	+1/64 -.000	Tool	Nest Bushing			
21-33501-57	48-1227-57	Socket Contact	7/32	5/64	7/64	294-289	294-1631	#1 (.018)	294-529	Raychem 9530All
21-33500-57	48-1226-57	Pin Contact	7/32	5/64	7/64	294-289	294-1631	#1 (.018)	294-529	

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