21-33833-211 (RECEPTACLE)
21-33833-231 (RECEPTACLE)

Transition Adapter, Differential Twinax
Type High Speed, Wired
Installation Instructions

See table on reverse side for twinax cable recommended, tool selector settings, crimping tool and positioner information.

A 1. Cut cable for assembly of transition adapter receptacle.
B 1. Strip cable jacket to expose cable outer braid as illustrated. Ends must be cut cleanly and at right angles to the axial plane of the cable. Cable must not be deformed while making cuts.
C 1. Slide crimp bushing over cable braid until cable jacket butts inside shoulder of crimp bushing as shown.
D 1. Flair cable outer braid back over crimp bushing as illustrated to expose inner wires. Trim excess cable braid.
2. Cut off any inner braids, wraps or cable fillers as close to outer cable braid as possible.
3. Cut inner wires to dimension shown. All wire must be cut to equal length.
E 1. Strip inner wires to expose center conductors as illustrated. All wires must be stripped to equal length.
F 1. Carefully splay inner wires perpendicular to the axis of the cable as illustrated.
2. Assemble inner contact over cable center conductor until fully seated against inner wire insulation. Observe center conductor through the contact's wire inspection hole, to make certain conductor is properly positioned.
3. Solder or crimp inner contact to center conductor using crimp tools listed in table on back. Repeat steps F2 and F3 for the remaining inner contact.
G 1. Position rear insulator against cable braid as illustrated. Make certain insulator slots are aligned with splayed inner contact wires. One-by-one, position wired inner contacts inside the insulator slots as shown. The inner contact's OD undercut must be positioned to capture the insulator's front retention shoulder as illustrated.

L-2119-CB **FSCM77820**
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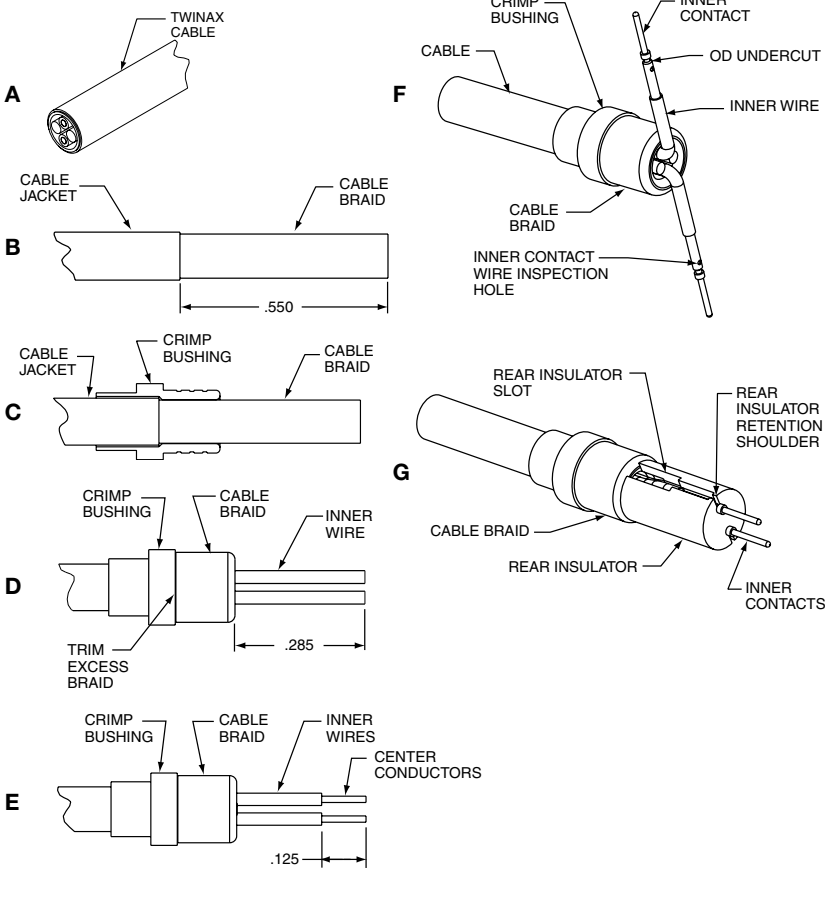

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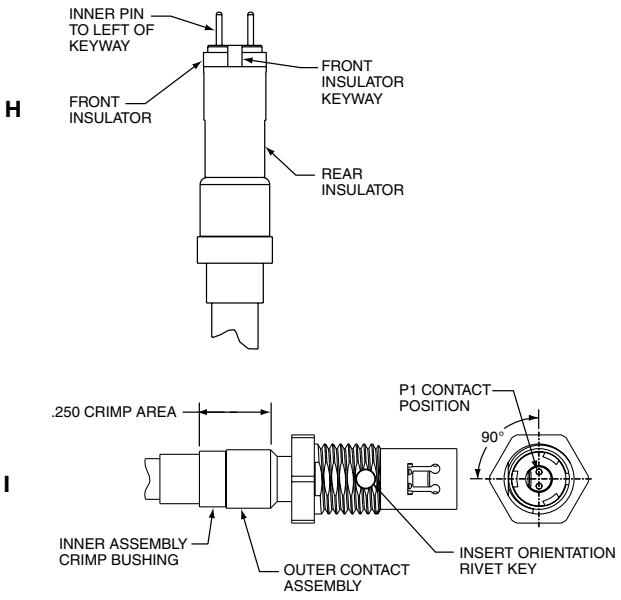
H 1. With inner contacts positioned inside rear insulator slots, assemble front insulator over the inner contacts as shown. The front insulator must butt the rear insulator.
2. Observe the front insulator keyway. When the inner assembly is held in the vertical orientation as shown (with inner pin contacts pointed up), the inner pin to the left of the insulator keyway will be positioned at the P1 inner contact position shown in View I.
I 1. Align front insulator keyway with the outer contact's insert orientation rivet key. Slide the inner contact assembly inside the outer contact assembly until fully seated. Observe the mating end of the assembly to make certain rivet key & keyway are engaged and contacts are aligned as shown (ref. 90 degrees).
2. Crimp the outer contact body and bushing shoulder in the area indicated using crimp tools listed in table.



Amphenol Part Number	Description	Twinax Cable Recommended	Inner Crimp Tools		Outer Crimp Tools	
			Tool (Setting)	Positioner	Tool	Die Set (Location)
21-33833-211 or 21-33833-231	Differential Twinax Transition Adapter Receptacle (100 Ohm)	CALMOUNT 3007-1923-12-7 or Equivalent	M22520/2-01 (1)	K1745S**	M22520/5-01	M22520/5-05 (B)

** Daniels Manufacturing Corp. Part Number

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