21-33211-15

Contact, Pin, Coaxial, Type LJT-R and TV-R, Crimp
(For use in MIL-C-38999 Series I & III Electrical Connectors)
Installation Instructions

See table on reverse side for coaxial cable accommodated crimping tools and dies, insertion and removal instructions and removal tool part number.

A 1. The contact incorporates a piggyback grommet seal. Assemble the piggyback grommet seal over the cable jacket, rubber end first, before stripping the cable jacket.
2. Strip cable jacket .775 inches as illustrated. Ends must be cut cleanly and at right angles to the axial plane of the cable. The cable must not be deformed while making cuts.

B 1. Slide shield crimp sleeve over cable jacket as illustrated.
2. Trim both shields to .330 inches dimension as illustrated.

C 1. Position nut on grooved retainer as illustrated.
2. Flare shields and slide nut and retainer assembly under the cable shields until the retainer bottoms against shields.

D 1. Bring shield crimp sleeve forward over cable shields and observe .010 to .050 inch dimension.
2. Crimp shield crimp sleeve using tool and die listed in table on back. Nut must rotate freely after crimping shield crimp sleeve.

E 1. Trim dielectric cable core to dimension shown. (A .016 inch flat washer may be employed to aid in trimming the dielectric cable core).

F 1. Trim fit center conductor to the inner socket contact wire well. Socket wire well end must butt dielectric cable core (insulation) and the cable center conductor must be visible in the socket contact wire well inspection hole.
2. Remove inner socket contact from center conductor.

G SOLDER TERMINATION OF INNER SOCKET CONTACT
1. Tin cable center conductor, and using a 47.5 watt soldering iron, solder the cable center conductor into the inner socket contact wire well. A pin vise can be used to hold the inner socket contact.
2. Slide front insulator over the inner socket contact assembly, large inside diameter first.

H. 1. Slide outer pin contact, threaded end first, over front insulator and inner socket assembly and thread nut into rear of outer pin contact.
2. Tighten nut until metal to metal bottoming is achieved between retainer shoulder and outer pin contact. Torque on nut shall be 30—36 inch ounces. CAUTION: Do not allow the cable to rotate while tightening the nut.

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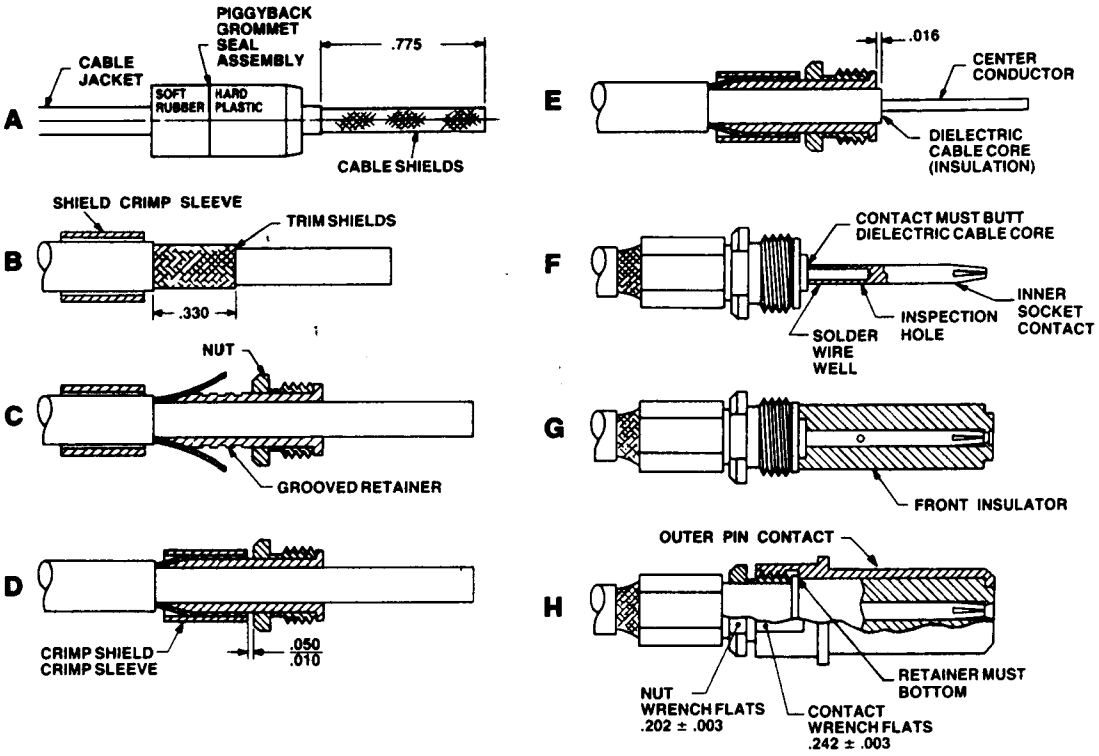

AMPHENOL corporation
an LPL company

PART NO.	COAXIAL CABLE ACCOMMODATED		INNER CONTACT	TOOLS		
				SHIELD CRIMP SLEEVE		
				BASIC CRIMP TOOL	DIE SET	DIE CLOSURE
21-33211-15	CENTER CONDUCTOR	.040 ± .001	SOLDER TERMINATION	M22520/5-01	M22520/5-43	B
	DIELECTRIC CABLE CORE	.118 ± .001				
	INNER SHIELD (FLAT CONSTRUCTION)	.130 ± .002		ALTERNATE TOOL AND DIE SET		
	OUTER SHIELD (ROUND CONSTRUCTION)	.153 ± .004				
	JACKET	.177 ± .004		M22520/10-01	M22520/10-19	N/A

CONTACT INSERTION INTO CONNECTOR

Contacts are inserted by hand. Slide the wire sealing member (piggyback grommet seal) on the cable and over the crimped shield crimp sleeve. Insert the contact/cable assembly into proper rear grommet hole. Contact must be aligned with hole and not inserted at an angle. Push forward until contact and wire sealing member is felt to snap into position within the insert. Gently tug on the cable to assure retention.

CONTACT REMOVAL FROM THE CONNECTOR

Remove wire sealing member from grommet, (piggyback grommet seal). Position Daniels removal tool DRK-264-8 or Bendix 11-9170 or M81969/14-06 around cable and slide tool toward connector until tool tips enter rear grommet and come to a positive stop on contact. Grip cable and simultaneously remove tool, contact and cable.