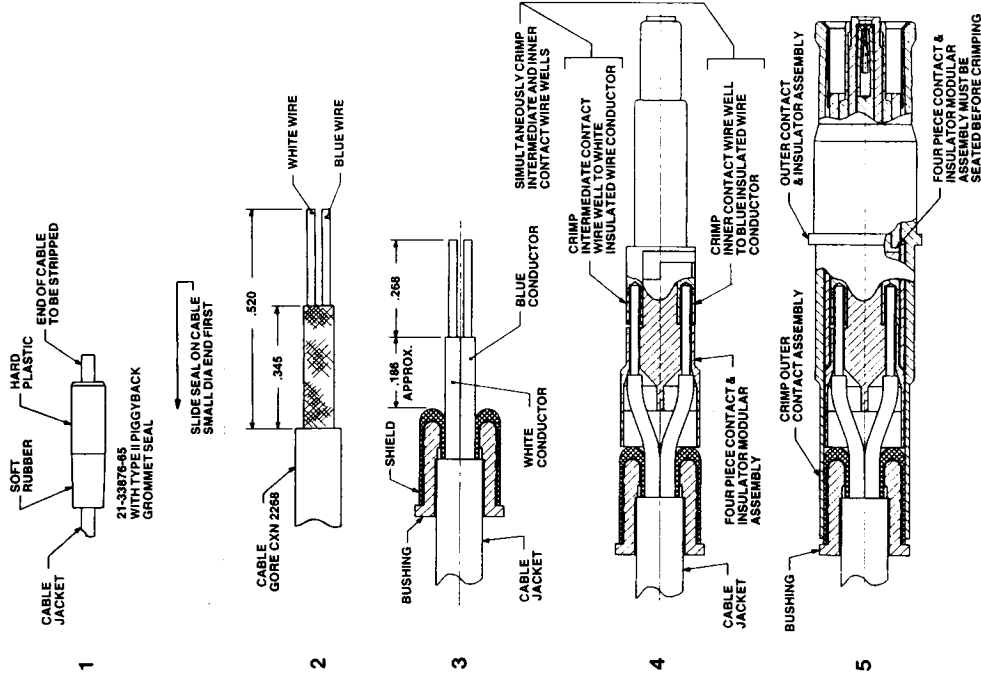


21-33875-65

Contact, Socket, Concentric Twinaxial Type,
Shielded, Crimp (MIL-C-38999 Series I & II)
Installation Instructions

21-33875-65



Note: 21-33875-65 contact with Type II Seal is designed for use in MIL-C-38999 Series I and III standard connector arrangements 17-2, 21-75, 21-79, 25-7, and 25-46.

For 21-33875-65: Type II Seal provided with connector.

1. Assemble Seal. See Figure 1.
2. Strip cable per Fig. 2.
3. Assemble crimp bushing over cable jacket, flair shield back over crimp bushing and strip inner wires as shown.
4. Assemble intermediate and inner contact (Four piece contact & insulator modular assembly) over wires as shown.
 - A. White insulated wire for intermediate contact.
 - B. Blue insulated wire for inner contact.
 - C. Wire conductors must be visible in the inspection hole of both intermediate and inner contact wire wells before crimping.
 - D. Simultaneously crimp intermediate and inner contact wire wells using DANIELS Crimp Tool Part Number AFMSP-31.
5. Slide outer contact and insulator assembly over four piece contact and insulator modular assembly until it butts firmly. A small gap at the bushing will occur. Crimp assembly, bushing and outer contact, with tool M22520/5-01 and die set DANIELS Y771 or hex cavity of DANIELS Y631.
6. Type II Seal:
Slide Piggyback Grommet seal on the cable and over outer contact until it butts firmly on contact. Insert contact assembly and seal into the connector grommet until it seats firmly. (See contact insertion instructions).

Contact Insertion into Connector (For Contacts with Type II Seal)

Contacts are inserted by hand. Slide the wire sealing member (piggyback grommet seal) on the cable and over the crimped end of the contact. Insert the contact/cable assembly and seal 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 are felt to snap into position within the insert. Gently tug on the cable to assure retention.

Contact Removal from Connector (For Contacts with Type II Seal)

Remove wire sealing member from grommet, (piggyback grommet seal). Position removal tool part number MIL-I-81969/14-06, Daniels DRK-264-8 or Bendix 11-9170 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.

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