

21-33190-625 (PIN)
21-33191-628 (SOCKET)

AS39029/113-625 (PIN)
AS39029/114-628 (SOCKET)

Contact, Pin & Socket, Concentric Twinaxial Type, (MIL-DTL-38999 Series I & III)
 Installation Instructions

Note: Type I Seal is designed for use in MIL-DTL-38999 Series III special connector arrangement 25-20 for MIL-STD-1760 applications only.

Type II Seal is designed for use in MIL-DTL-38999 Series I and III standard connector arrangements 25-46, 21-75, 21-79 and others.

Type II seal, if needed, will be provided with connector.

Type I seal is provided with the contact.

Use only one seal type, depending on the connector arrangement and discard the other seal.

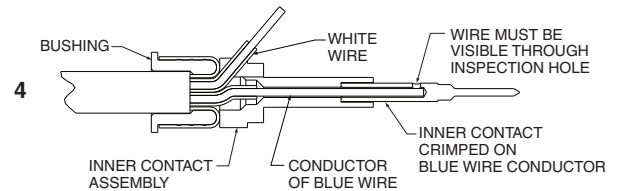
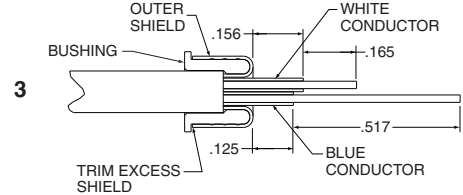
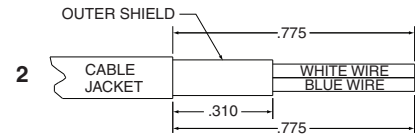
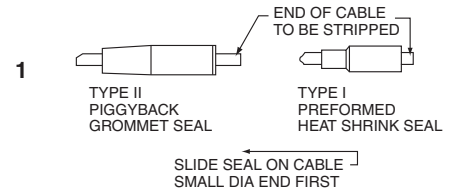
1. Assemble Seal: See Figure 1.
 Type I: Pre-formed heat shrinkable contact/wire seal.
 Type II: Piggyback grommet seal.
2. Strip cable per Figure 2.
3. Assemble crimp bushing over cable jacket, until cable jacket butts inside shoulder of busing. Flair outer shield as shown. (Cut off fillers as close to outer shield as possible). Strip inner wires as shown. Trim excess shield.
4. Bend white wire away from blue wire and assemble inner contact assembly over blue wire and butt firmly against crimp bushing as shown. Align insulator slot with white wire. Crimp inner contact to blue wire conductor with M22520/2-01 tool and M22520/2-37 positioner. Use tool selector setting number five (5).
5. Slide rear intermediate contact over inner contact assembly as shown, being sure all strands of the white conductor enter small hole in the intermediate contact large end. Slot in intermediate contact should be 180 degrees opposite white wire. Crimp rear intermediate contact wire well using tool M22520/5-01 and die set M22520/5-105. (Die set has a blade for location of slot and a double indent portion to crimp wire side).
6. Slide outer contact assembly over inner contact 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 M22520/5-105.

Type I Seal:

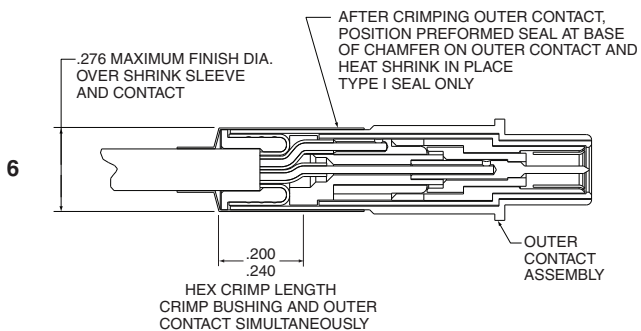
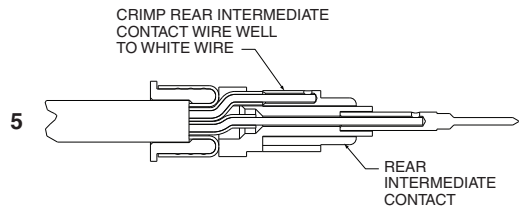
Slide pre-formed heat shrink seal over outer contact until large end is even with base of chamfer on outer contact (See Fig. 12). Heat shrink seal in place with hot air appliance.

Type II Seal:

Insert the contact assembly into the connector grommet until it seats firmly. Tug slightly on wire to insure contact has properly seated. Slide Piggyback grommet down cable until it butts firmly on contact.



Amphenol



EQUIVALENT APPLICATION TOOLS		
DIE SET	POSITIONER	CONTACT REMOVAL
M22520/5-105 OR AMPHENOL® 11-12101 OR DANIELS Y631	M22520/2-37 OR AMPHENOL® 11-12102 OR DANIELS K709	DANIELS DRK 264-8