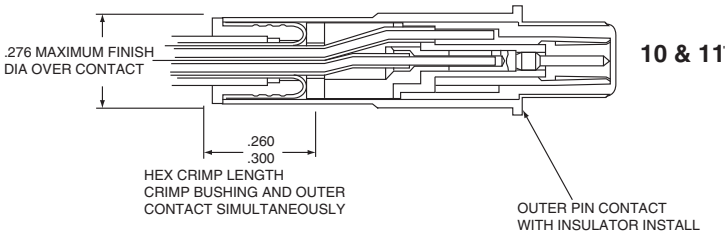
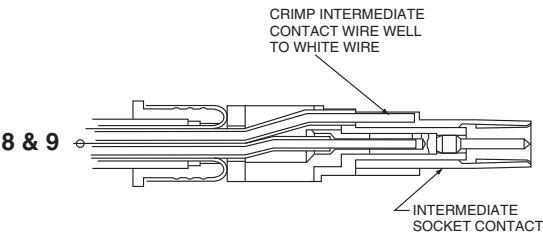
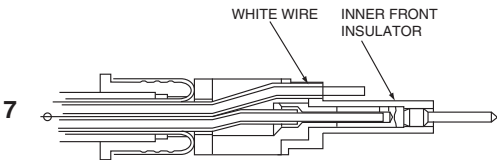
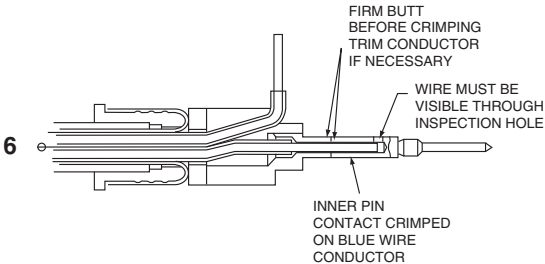
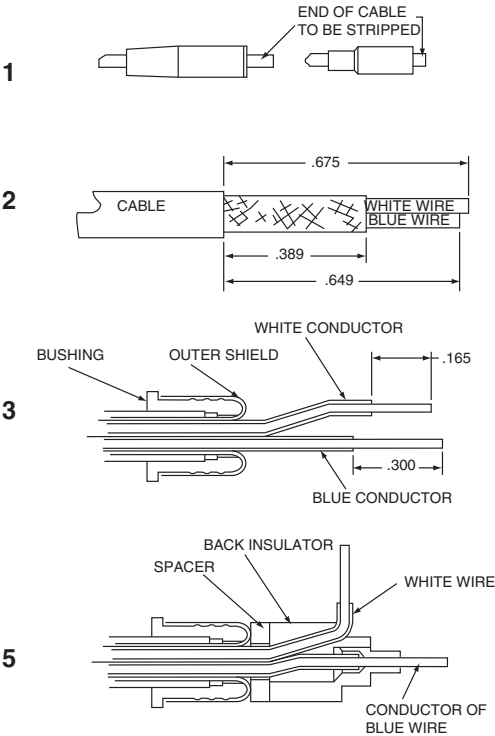


Contact, Pin, Concentric Twinaxial Type, (MIL-DTL-38999 Series I & III)
Installation Instructions

1. Rubber end first, slide piggyback grommet seal back over cable jacket
2. Strip cable per Figure 2.
3. Assemble crimp bushing over cable jacket, flair outer shield as shown. (Cut off flat braid inner shield and fillers as close to outer shield as possible). Strip inner wires as shown.
4. Assemble spacer insulator over blue and white wire.
5. Bend white wire away from blue wire and assemble back insulator over blue wire and butt firmly against spacer insulator. Align slot with white wire.
6. Fit inner pin contact over blue wire conductor. (See Fig. 6) and crimp with M22520/2-01 tool and M22520/2-37 positioner. Use tool selector setting number five (5).
7. Assemble inner front insulator over center pin contact being careful to align slot with white wire as insulator is slid back until it butts firmly.
8. Slide intermediate contact over inner front insulator 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.
9. Crimp intermediate contact wire well using tool M22520/5-01 and die set M22520/5-200. (Die set has a blade for location of slot and a double indent portion to crimp wire side).
10. Slide outer pin contact, with insulator installed, over assembly until it butts firmly. A small gap at the bushing will occur.
11. Crimp assembly, bushing and outer contact, with tool M22520/5-01 and die set M22520/5-200.
12. Insert the contact assembly into the connector grommet until it seats firmly. Tug slightly on wire to insure contact has properly seated.
13. Slide Piggyback grommet down cable until it butts firmly on contact.

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Amphenol

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EQUIVALENT APPLICATION TOOLS		
DIE SET	POSITIONER	CONTACT REMOVAL
M22520/5-200 OR AMPHENOL® 11-12101 OR DANIELS Y631	M22520/2-37 OR AMPHENOL® 11-12102 OR DANIELS K709	DANIELS DRK 264-8