

21-33191-22

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

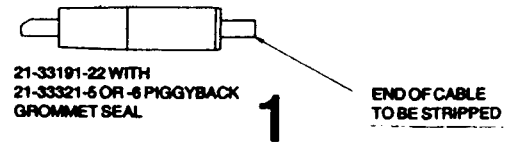
Note: 21-33191-22 Contact with Piggyback Grommet Seal is designed for use in MIL-C-38999 Series I and III standard connector arrangements 17-2, 21-75, 21-79, 25-7 and 25-46 only. For 21-33191-22, the Piggyback Grommet Seal (part number 21-33321-5 or -6) is supplied with the connector assembly.

1. Assemble Piggyback Grommet Seal: See Figure 1.
2. Strip cable per Figure 2.
3. Bushing and shield location:
 - 3.1 Slide crimp Pushing over cable jacket, large end first, until small end is even with cable jacket.
 - 3.2 Flare outer shield back over crimp bushing.
 - 3.3 Unwrap conductive foil and pull back over first shield and crimp Pushing. Flatten foil.
 - 3.4 Flair inner shield back over outer shield and conductive foil.
 - 3.5 Cut off fillers as close to shield as possible.
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 socket 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 socket 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 large front insulator over intermediate contact assembly until it butts firmly.
11. Slide outer socket contact over insulators until inside components firmly butt. A small gap at the bushing will occur.
12. Crimp assembly, bushing and outer contact, with tool M22520/5-01 and die set M22520/5-200.
13. Insert the contact assembly into the connector grommet until it seats firmly. Tug slightly on wire to insure contact has properly seated.
15. Slide Piggyback Grommet down cable until it butts firmly on contact.

L-1253-D
April 1999

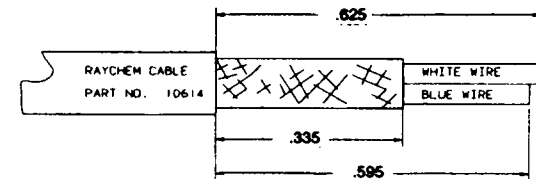
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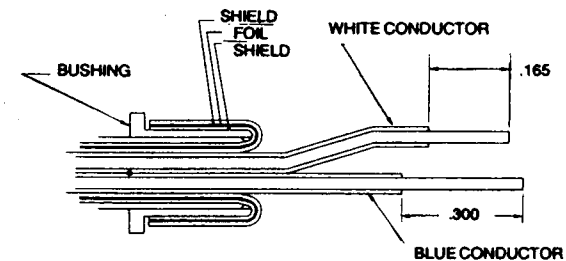


SLIDE SEAL ON END OF CABLE
SMALL END FIRST

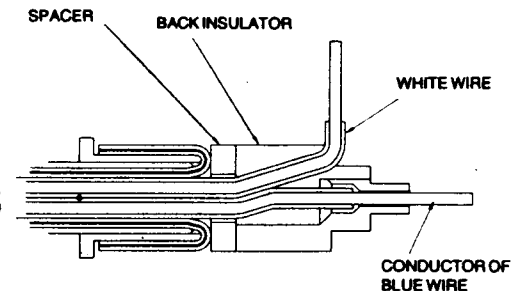
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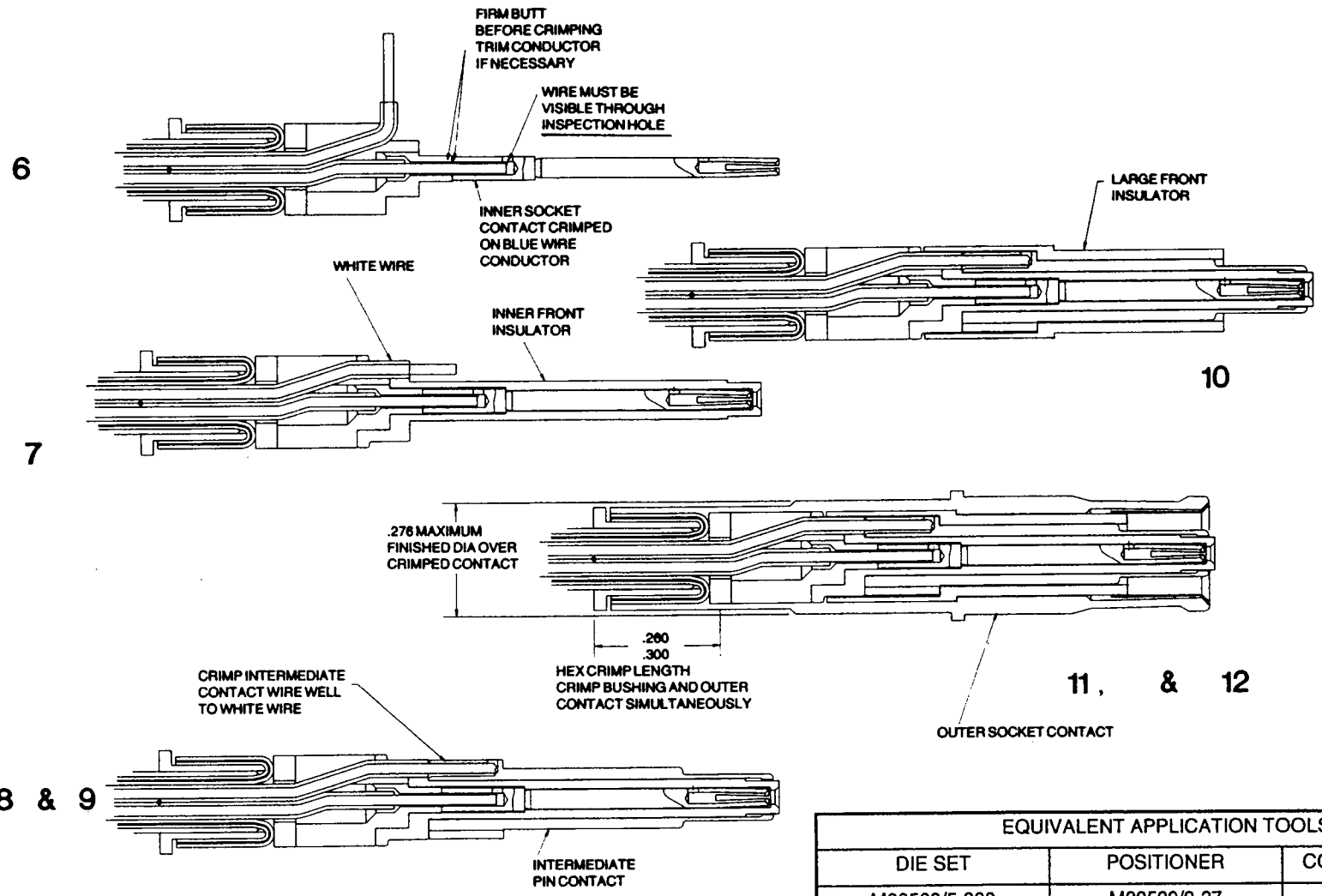


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Amphenol Aerospace

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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