21-33191 21-33191	-		21-33191-27 21-33191-29 21-33191-30		
	Contact, Socket, Concentric Twina	axial Type, (MIL-DTL-38999 Series I & III)	2. 00101 00	/	END OF CABLE TO BE STRIPPED
	Installatio	on Instructions	inecial 1		
	33191-27 Contact with Type I Seal is do nector arrangement 25-20 for MIL-STD-12	esigned for use in MIL-DTL-38999 Series III s	pecial	21-33191-29 AND 21-33191-30	21-33191-27 WITH TYPE I
		be II Seal are designed for use in MIL-DTL-38999)	WITH TYPE II PIGGYBACK	PREFORMED HEAT SHRINK S
Serie	es I and III standard connector arrangeme	ents 17-2, 25-46, 21-75, 21-79, 25-7 and 25-46 of	nly.	GROMMET SEAL	
	21-33191-30 Type II seal provided with co			SLIDE SEAL ON O	
	21-33191-29 Type II seal provided with co ble Seal: See Figure 1.	ntact.		SMALL DIA END I	FIRST
	Pre-formed heat shrinkable contact/wire	seal.			625
	Piggyback grommet seal.		2		
	able per Figure 2.				
Assemt	ble crimp bushing over cable jacket, flai o shield as possible). Strip inner wires as sl	r outer and inner shields as shown. (Cut off fil	lers as	.33	35
	ble spacer insulator over blue and white v				.595
	•	mble back insulator over blue wire and butt	firmly		
against	t spacer insulator. Align slot with white wi	re.			
Fit inne	er socket contact over blue wire condu	ctor. (See Fig. 6) and crimp with M22520/2-0	1 tool	BUSHING OUTER & INNER SHIELD	^{DS} ↓ .165
	22520/2-37 positioner. Use tool selector selecto	cket contact being careful to align slot with	white		
	insulator is slid back until it butts firmly.	cket contact being caleful to aligh slot with	white 3		
Slide in	ntermediate contact over inner front in	sulator being sure all strands of the white co	onduc-		.300
		t large end. Slot in intermediate contact sho	uld be		
	grees opposite white wire.	and Maaran die eet Maaran / and			BLUE CONDUCTOR
set has	a blade for location of slot and a double i	ool M22520/5-01 and die set M22520/5-200 ndent portion to crimp wire side).	א. עוש	BACK INSUL	ator 🗖
	rge front insulator over intermediate con			SPACER	WHITE WIRE
. Slide o	uter socket contact over insulators unti	inside components firmly butt. A small gap	at the	$\langle \rangle$	WHITE WIRE
	g will occur.				
		h tool M22520/5-01 and die set M22520/5-200	4 & 5		
 Type I S Slide pr 		tact until large end is even with base of chamfe			
	ontact (See Fig. 13). Heat shrink seal in pla				CONDUCTOR OF
Type II S	Seal: Go to Step 14.				BLUE WIRE
	the contact assembly into the connecto re contact has properly seated.	r grommet until it seats firmly. Tug slightly o	n wire	۸mnhan	a l
	Seal: Slide Piggyback grommet down cab	le until it butts firmly on contact		Amphen	UI
. iypeii:		ie and it batts minly on contact.			AMPHENOL CORPORATION
1253-L					Amphenol Aerospace 40-60 Delaware Avenue
oril 2014		FSCM	77820		Sidney, New York 13838-139
	, TRIM C	E CRIMPING DNDUCTOR			
6 e	HEFOR	E CRIMPING SONDUCTOR SSARY //WIRE MUST BE //VISIBLE THROUGH INSPECTION HOLE			
	BEFOR TRIM C	E CRIMPING SNDUCTOR SSARY ~ WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IIIMPED IE			
	BEFOR TRIM C IF NECL INNER SOCK CONTACT CF ON BLUE WIL	E CRIMPING SNDUCTOR SSARY ~ WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IIIMPED IE	POSITION PREFO	OUTER CONTACT.	
	BEFOR TRIM C IF NECL IF NECL I	E CRIMPING DODUCTOR SSARY - WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IMPED RE	POSITION PREFO	RMED SEAL AT BASE OUTER CONTACT,	
	UNITE WIRE	E CRIMPING SNDUCTOR SSARY ~ WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IIIMPED IE	POSITION PREFO OF CHAMFER ON	RMED SEAL AT BASE OUTER CONTACT,	
	UNITE WIRE	E CRIMPING DONDUCTOR SSARY //WIRE MUST BE //WIRE THROUGH INSPECTION HOLE ET IMPED BE	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN	RMED SEAL AT BASE OUTER CONTACT,	
	UNITE WIRE	E CRIMPING DONDUCTOR SSARY - WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IMPED RE S	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY	RMED SEAL AT BASE OUTER CONTACT,	
6 •	UNITE WIRE	E CRIMPING SONDUCTOR SSGARY -WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IMPED 1E SULATOR .276 DIA.	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY	RMED SEAL AT BASE OUTER CONTACT,	
6 e	UNITE WIRE	E CRIMPING SONDUCTOR SSGARY -WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IMPED 1E SULATOR .276 DIA.	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY	RMED SEAL AT BASE OUTER CONTACT,	
6 e	UNITE WIRE	E CRIMPING SONDUCTOR SSGARY -WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IMPED 1E SULATOR .276 DIA.	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY	RMED SEAL AT BASE OUTER CONTACT,	
6 e	UNITE WIRE	E CRIMPING SONDUCTOR SSGARY -WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IMPED 1E SULATOR .276 DIA.	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY	IRMED SEAL AT BASE OUTER CONTACT, K IN PLACE	LARGE FRONT INSULATOR 10
6 •	UNITE WIRE	E CRIMPING SONDUCTOR SSGARY -WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IMPED 1E SULATOR .276 DIA.	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY	RMED SEAL AT BASE OUTER CONTACT, K IN PLACE	10
6 e	WHITE WIRE	E CRIMPING SONDUCTOR SSGARY -WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IMPED 1E SULATOR .276 DIA.	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY	IRMED SEAL AT BASE OUTER CONTACT, KIN PLACE	LARGE FRONT INSULATOR 10
6 •	CRIMP INTERMEDIATE CONTACT WIRE WIRE	E CRIMPING SONDUCTOR SSGARY -WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IMPED 1E SULATOR .276 DIA.	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY	IRMED SEAL AT BASE OUTER CONTACT, KIN PLACE	10
6 •	EFOR TRIM C IF NEC UNER SOCK CONTACT CF ON BLUE WIR CONDUCTOR	E CRIMPING SONDUCTOR SSGARY -WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IMPED 1E SULATOR .276 DIA.	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY	IRMED SEAL AT BASE OUTER CONTACT, KIN PLACE	10
6 •	CRIMP INTERMEDIATE CONTACT WIRE WIRE	E CRIMPING SONDUCTOR SSGARY -WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IMPED 1E SULATOR .276 DIA.	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY	IRMED SEAL AT BASE OUTER CONTACT, KIN PLACE	10
6	CRIMP INTERMEDIATE CONTACT WIRE WIRE	E CRIMPING SONDUCTOR SSGARY -WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IMPED 1E SULATOR .276 DIA.	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY	IRMED SEAL AT BASE OUTER CONTACT, KIN PLACE	10
6	CRIMP INTERMEDIATE CONTACT WIRE WIRE	E CRIMPING SONDUCTOR SSGARY -WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IMPED 1E SULATOR .276 DIA.	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY	IRMED SEAL AT BASE OUTER CONTACT, K IN PLACE	10
6	CRIMP INTERMEDIATE CONTACT WIRE WIRE	E CRIMPING SONDUCTOR SSGARY -WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IMPED 1E SULATOR .276 DIA.	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY	IRMED SEAL AT BASE OUTER CONTACT, K IN PLACE	10
6	CRIMP INTERMEDIATE CONTACT WIRE WIRE	E CRIMPING SONDUCTOR SSGARY -WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE ET IMPED 1E SULATOR .276 DIA.	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY	RMED SEAL AT BASE OUTER CONTACT, K IN PLACE	LARGE FRONT INSULATOR 10 10 11, 12 & 13 ET CONTACT CONTACT REMOVAL
	CRIMP INTERMEDIATE CONTACT WIRE WELL CONDUCTOR	E CRIMPING DNDUCTOR SSARY VISIBLE THROUGH INSPECTION HOLE ET IMPED RE SULATOR SULATOR SULATOR SULATOR SULATOR SULATOR SULATOR SULATOR SULATOR SULATOR	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY	IRMED SEAL AT BASE OUTER CONTACT, K IN PLACE	10 10 10 11, 12 & 13 ET CONTACT CONTACT REMOVAL DANIELS
6 •	CRIMP INTERMEDIATE CONTACT WIRE WELL CONDUCTOR	E CRIMPING DNDUCTOR SSARY VISIBLE THROUGH INSPECTION HOLE ET IMMED RE R R R R R R R R R R R R R R R R R	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY MAXIMUM FINISH AFTER SHRINK EVE AND CONTACT U HEX CRIMP LENC CRIMP BUSHING CONTACT SIMULT DIE SET M22520/5-200 OR	IRMED SEAL AT BASE OUTER CONTACT, K IN PLACE	LARGE FRONT INSULATOR 10 10 11, 12 & 13 ET CONTACT CONTACT REMOVAL
6	CRIMP INTERMEDIATE CONTACT WIRE WELL CONDUCTOR	E CRIMPING DNDUCTOR SSARY VISIBLE THROUGH INSPECTION HOLE ET IMPED RE SULATOR SULATOR SULATOR SULATOR SULATOR SULATOR SULATOR SULATOR SULATOR SULATOR	POSITION PREFO OF CHAMFER ON AND HEAT SHRIN TYPE I ONLY	IRMED SEAL AT BASE OUTER CONTACT, K IN PLACE	LARGE FRONT INSULATOR 10 10 11, 12 & 13 ET CONTACT CONTACT REMOVAL DANIELS