

21-33844-1
21-33609-1

Concentric Twinaxial Pin Contact
Installation Instructions

A1. See View A1

1. Assemble thermal fit sleeve over the cable outer jacket diameter to dimension shown.
2. Expose sleeve to a temperature of 275°F to 325°F until sleeve recovers and conforms to the cable outer jacket diameter.

A2. See View A2

1. Strip cable as illustrated. Ends must be cut cleanly and at right angles to the axial plane of the cable. The cable must not be deformed while making the cuts.
2. Assemble ferrule back over the cable jacket and seat against thermal fit sleeve end.

B. 1. Flare shield back over ferrule and strip core insulation as shown.

1. Assemble intermediate and inner contact over wires as shown.
 - 1.1 Blue/Black insulated wire for intermediate socket contact.
 - 1.2 Blue insulated wire for inner pin contact.
 - 1.3 Wire conductors must be visible in the inspection hole of both intermediate and inner contact wire wells before crimping.
2. Simultaneously crimp intermediate and inner contact wire wells using M22520/5-01 crimp tool and a Daniels Y690 die set.

1. Position outer contact and insulator assembly over cable shield.
 2. Intermediate and inner contact assembly (see C), must be seated in the outer contact insulator as shown.
 3. Crimp outer contact using a Daniels GS208 Crimp Tool and a Daniels GP780 Positioner.
 4. Crimp contact as follows:
Crimp once, rotate the contact 45°, and crimp a second time. After crimping the second time, the diameter over the crimped contact area must not be greater than .213.

CONTACT INSERTION:

Using insertion tool Daniels DAK 264-10, insert contact assembly into the rear connector grommet hole, contact must be aligned with hole and not inserted at an angle. Push forward until the contact is felt to snap into position within the insert. Remove tool.

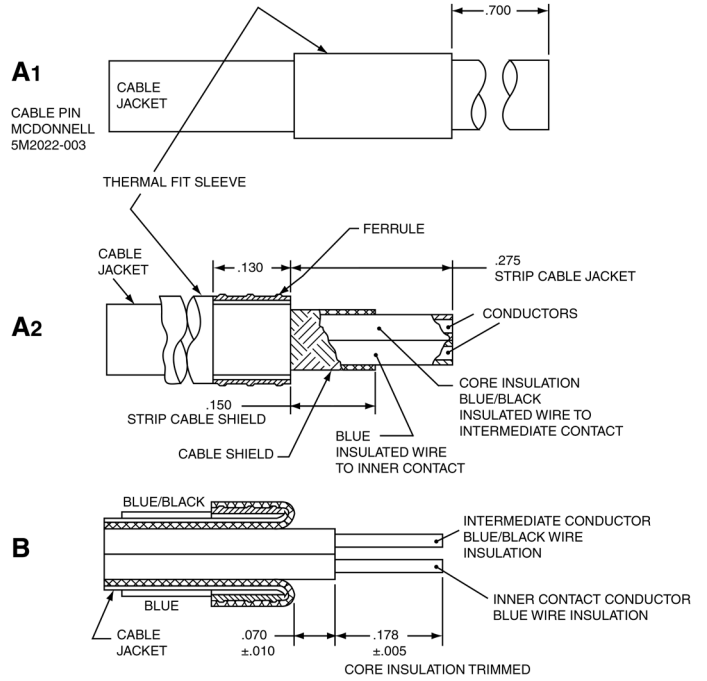
CONTACT REMOVAL:

Position removal tool Daniels DRK 264-10, around cable and slide tool down wire until tool tips enter rear grommet and come to a positive stop. Hold tool tip firmly against positive stop on contact. Grip cable and simultaneously remove tool, contact and cable.

L-1255-A
September 2001

FSCM77820

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