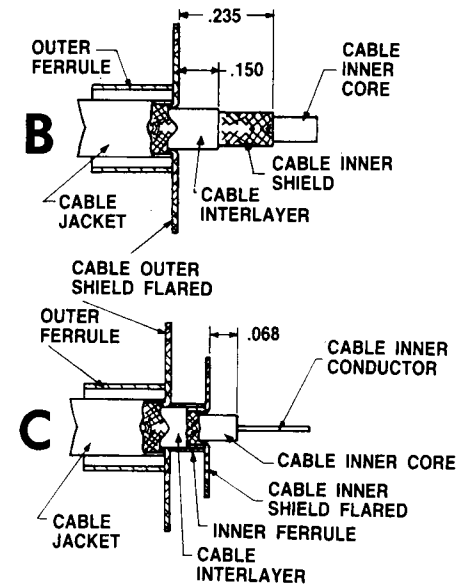
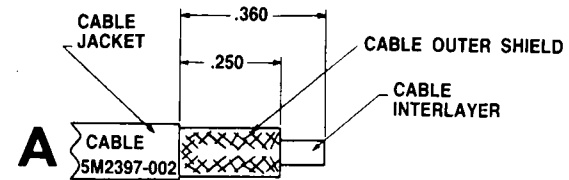


21-33800-1

Triaxial Contact
Installation Instructions

- A. 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 cuts.
- B. 1. Assemble outer ferrule back over cable jacket.
2. Flare cable outer shield as shown.
3. Strip cable interlayer insulation and inner shield as shown.
- C. 1. Assemble inner ferrule over cable interlayer and flare cable inner shield as shown.
2. Strip inner cable core insulation as shown.
- D. 1. Slide inner insulator over cable inner conductor until insulator butts cable inner core.
2. Slide inner pin contact over cable inner conductor until it butts against inner insulator.
3. Cable inner conductor must be visible through the inspection hole in the inner pin contact wire well.
4. Crimp inner pin contact wire well using a M22520/2-01 crimp tool and a DANIELS K803 positioner.
- E. 1. Slide intermediate socket contact and insulator assembly over the inner pin contact and inner insulator assembly until inner pin contact is seated in the intermediate contact insulator.
2. Form cable inner shield over intermediate socket contact and slide inner ferrule forward as shown. Observe .270 - .300 dimension.
3. Crimp intermediate contact and ferrule assembly with M22520/4-01 tool and a DANIELS GP781 positioner.
Crimp as follows:
Crimp once, rotate the contact assembly 45° and crimp a second time. After crimping the second time the diameter over the shield crimp sleeve must not be greater than .117.
- F. 1. Slide outer pin contact and insulator assembly over intermediate socket contact assembly until the intermediate contact is seated against the outer pin contact insulator inside shoulder as shown.
- G. 1. Form cable outer shield over the outer pin contact assembly. Bring outer ferrule forward over cable outer shield and outer pin assembly.
Observe .390 - .420 dimension.
Trim excess shield ahead of the outer crimp ferrule.



2. Crimp outer ferrule and outer pin contact assembly using a DANIELS GS208 crimp tool and a DANIELS GP782 positioner.

Crimp as follows:

Crimp once, rotate the contact assembly 45° and crimp a second time. After crimping the second time, the diameter over the outer crimp ferrule 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 contact is felt to snap into position within 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.

