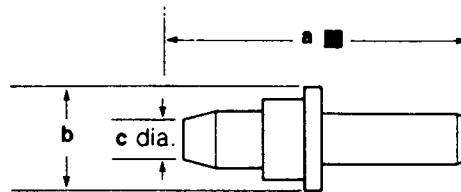
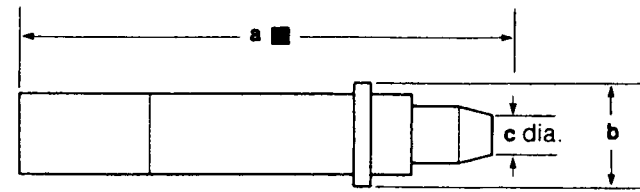


Amphenol® Size #12 Coaxial Contacts
 Order information size 12 Matched Impedance



**Fig. 1 Pin
 (with female contact)**



**Fig. 2 Socket
 (with male contacts)**

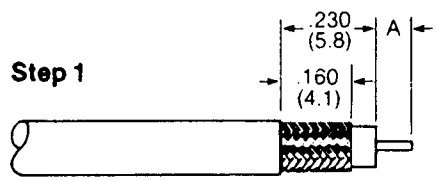
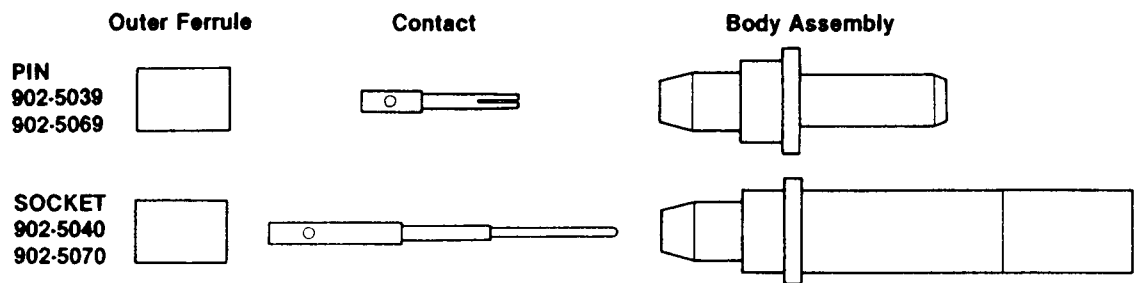
Cable	Description	Config.	Dimensions, Inches (millimeters)			Amphenol Number	Fig. No.
			a ■	b	c★		
RG-316/U (M17/113 -RG316)	Matched Impedance Contacts - do not mate with M39029	Pin	.548 (13.9)	.180 (4.6)	.064 (1.6)	21-33213-1	1
		Socket	.873 (22.2)	.180 (4.6)	.064 (1.6)	21-33214-1	2
	Matched Impedance Contacts - will mate with M39029	Pin	.548 (13.9)	.180 (4.6)	.064 (1.6)	21-33213-2	1
		Socket	.873 (22.2)	.180 (4.6)	.064 (1.6)	21-33214-2	2

★ C dia accommodates cable dielectric

■ Includes outer ferrule

Amphenol

Assembly Instructions



Step 1

Strip cable jacket, braid and dielectric to dimensions shown. All cuts are to be sharp and square.

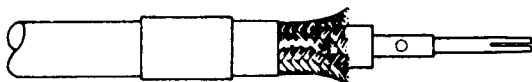
A = .080 (2.0) for 21-33213-1, 21-33214-1.

A = .060 (1.9) for 21-33213-2, 21-33214-2.

Important: Do not nick braid, dielectric, or center conductor.

Tin center conductor using soft solder (60/40). Avoid excessive heat. Do not overtin.

Step 2



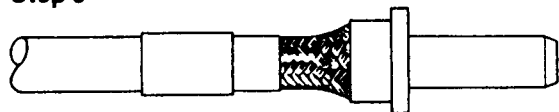
Step 2

Slide outer ferrule onto cable as shown. Flare end of cable braid slightly as shown to facilitate insertion of inner ferrule.

Important: Do not comb out braid.

Place contact on cable center conductor so it butts against cable dielectric. Center conductor should be visible through inspection hole in contact.

Step 3



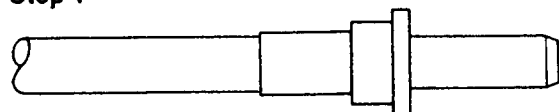
SOLDER METHOD FOR CENTER CONDUCTOR: Soft solder the contact to cable center conductor. Do not get any solder on outside surfaces of contact. Avoid excessive heat to prevent swelling of dielectric.

CRIMP METHOD FOR CENTER CONTACT: Crimp with Tool No. M22520/2-01. Crimp method applies only to 21-33213-2 and 21-33214-2.

For 21-33213-2 use Positioner K878S, setting 2.

For 21-33214-2 use Positioner K867, setting 2.

Step 4



Step 3

Install cable assembly into body assembly so inner ferrule slides under braid. Push cable assembly forward until contact bottoms in the insulator counterbore.

Step 4

Slide outer ferrule over braid and up against connector body. Crimp outer ferrule using Cavity A of Die Set M22520/5-03 and Tool Handle M22520/5-01.