

21-33122-544

Contact, Pin, Coaxial Type JT-R, LJT-R and TV-R Crimp (MIL-DTL-38999 Series I, II and III)
Installation Instructions

See table on reverse side for coaxial cable recommended, type assembly instructions code, stripping dimensions, tool selector settings, crimping tool, positioner and insertion/removal tool information.

NOTE: The 21-33122-544 coaxial contact terminates only the inner single shield coaxial portion of Raychem cable part number 9530A5314.

Cable P/N 9530A5314 is triaxial. Strip back a sufficient length of the outer jacket and outer shield to expose inner coaxial portion of the cable.

Type
Assembly

- I A Strip inner coaxial portion of the 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. Slide shield crimp sleeve back over cable inner jacket.
2. Flare inner shield as illustrated and strip cable dielectric.
- C 1. Slide rear insulator over cable center conductor until dielectric butts against rear insulator.
2. Slide inner socket contact over cable center conductor. Cable center conductor must be visible through the inspection hole in the inner socket contact wire well.
3. Crimp inner socket contact wire well using crimp tool and positioner listed in table on back.
- D Slide outer contact over inner socket assembly and under cable shield until inner socket contact and front insulator are fully seated.
- E 1. Bring shield crimp sleeve forward over cable shield and observe .240 – .270 dimension. Trim excess shield ahead of shield crimp sleeve.
2. Crimp shield crimp sleeve using tool and positioner listed in table on back 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 .156 inch.

CONTACT INSERTION

Using insertion tool (see table), insert contact assembly into 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.

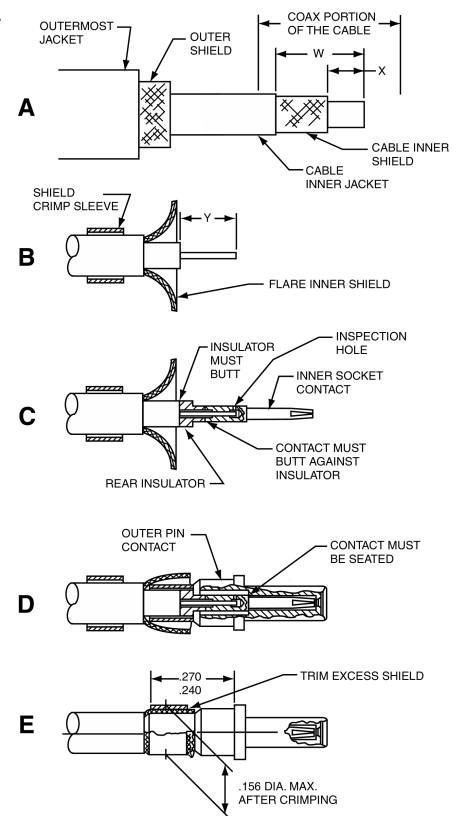
CONTACT REMOVAL

Position removal tool (see table) 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 wire and simultaneously remove tool, contact and cable.

L-2035-R
February 2004

FSCM77820

21-33122-544



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PART NO.	COAXIAL CABLE ACCOMMODATED	TYPE ASSEMBLY INSTRUCTIONS	STRIPPING DIMENSIONS			TOOLS						
			W	X	Y	INNER CONTACT			OUTER CONTACT			
						TOOL SELECTOR SETTING NO.	BASIC CRIMPING TOOL	POSITIONER	BASIC CRIMPING TOOL	POSITIONER	INSERTION TOOL	REMOVAL TOOL
21-33122-544	9530A5314	I	0.340	0.140	0.190	3	M22520/2-01	M22520/2-34 or K323 (DANIELS)	M22520/31-01 or GS200 (DANIELS)	M22520/31-02 or G2P330 (DANIELS)	M81969/8-09 or M81969/14-04	M81969/8-10 or M81969/14-04