

21-33653-1

Contact, Socket, Coaxial, Type TV-R, Crimp, Size 8 Installation Instructions

See table on reverse side for coaxial cable recommended and crimp tool information.

- A. 1. Slide piggyback grommet seal over cable outer jacket as shown.
2. Slide outer crimp ferrule over cable outer jacket as shown.
- B. 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.
- C. 1. Flare outer braid as illustrated and unravel foil until the cable core dielectric is exposed. Cut off foil as close to outer braid as possible.
- D. 1. Assemble inner contact over cable center conductor until inner contact butts against cable core dielectric. Cable center conductor must be visible through the inspection hole in the inner contact wire well.
2. Crimp inner contact wire well using crimp tool listed in table on back.
- E. 1. Carefully slide outer contact assembly over inner contact and under cable outer braid, until dielectric butts against insulator shoulder as illustrated.
2. Bring outer crimp ferrule forward over cable outer braid and observe .010 - .035 dimension. Trim excess braid ahead of crimp ferrule.
3. Crimp outer crimp ferrule using crimp tool listed in table on back. After crimping, the dimension over the crimp ferrule must not exceed .260.

CONTACT INSERTION INTO CONNECTOR

Contacts are inserted by hand. Slide the wire sealing member (piggyback grommet seal) on the cable and over the crimped end of the contact. Insert the contact/cable assembly and seal into proper rear grommet hole. Contact must be aligned with hole and not inserted at an angle. Push forward until contact and wire sealing member are felt to snap into position within the insert. Gently tug on the cable to assure retention.

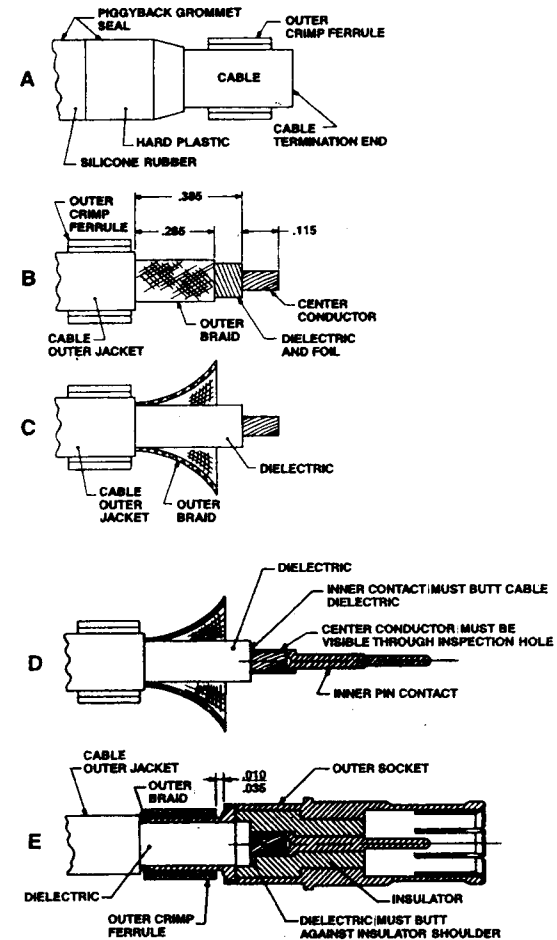
CONTACT REMOVAL FROM CONNECTOR

Remove wire sealing member from grommet, (piggyback grommet seal). Position removal tool part number MIL-I-81969/14-06, Daniels DRK-264-8 or Amphenol 11-9170 around cable and slide tool toward connector until tool tips enter rear grommet and come to a positive stop on contact. Grip cable and simultaneously remove tool, contact and cable.

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Amphenol Aerospace

AMPHENOL CORPORATION
Amphenol Aerospace
40-60 Delaware Avenue
Sidney, New York 13838-1395

Part Number	Coaxial Cable Accommodated	Tools		
		Inner Contact		Outer Contact
		Crimp Tool	Positioner/ Positioner Setting	Crimp Tool/ Die Set
21-33653-1	NRFC-50-COAX-3 (FA19X)	M22520/2-01	K1106 Setting 5	M22520/5-01 Y258