

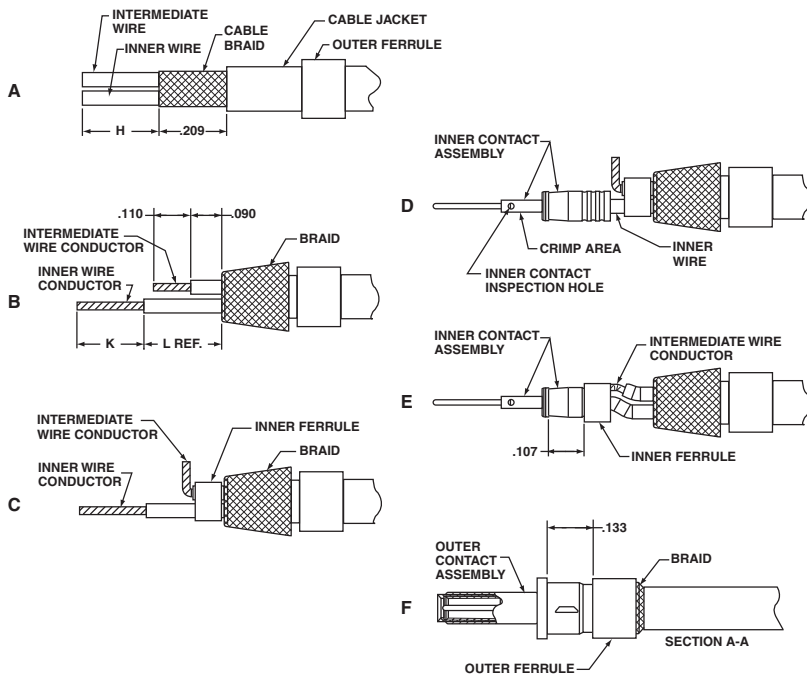
21-33908-91 (SOCKET)
21-33909-91 (PIN)

Contact, Size 12, Pin and Socket, Twinaxial,
 Type LJT-R & TV-R, (MIL-C-38999 Series I & III) Crimp
 Installation Instructions

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

- A.** 1. Assemble outer ferrule over cable jacket (small diameter end first for tapered type ferrules).
 2. Strip cable as illustrated.
- B.** 1. Flare cable braid back as shown.
 2. Cut off cable fillers (not shown) as close to cable braid as possible.
 3. Trim & strip inner and intermediate wires as shown. (Optional method: wire insulation may be cut at this point, and then removed after assembly of inner ferrule (step C1).)
- C.** 1. Assemble inner ferrule over inner and intermediate wires until flush against cable braid.
 2. Bend conductor of intermediate wire as shown, to hold inner ferrule in position.
- D.** 1. Assemble inner contact assembly over inner wire conductor until conductor is visible through the inner contact inspection hole.
 2. Crimp the inner contact using the crimp tool and positioner listed in table on back.
- E.** 1. Form intermediate wire conductor forward, over the rear of the inner contact assembly. Slide inner ferrule forward and over the intermediate wire conductor as shown.
 2. Crimp inner ferrule using crimp tool and positioner listed in table. Crimp once, rotate tool 45 degrees and crimp again. Continue to rotate tool 15 degrees approx. and crimp until ferrule diameter is .105 Max.. (may take 3 to 4 crimps).
- F.** 1. Slide outer contact assembly over inner contact assembly, until inner contact assembly snaps into the retention clips of the outer contact assembly.
 2. While pushing the inner contact assembly fully forward inside the outer contact, form the cable braid over the rear of the outer contact. Slide the outer ferrule forward over the cable braid as shown. (For tapered type ferrules, slide the ferrule forward until it comes to a stop).
 3. Crimp the outer contact and ferrule using the crimp tool and positioner listed in the table. Crimp once, rotate the tool 45 degrees and crimp again. (.156 Dia. Max. over the ferrule after crimping). Rotate tool 45 degrees and crimp again if necessary.
 4. For pin contacts only: After crimping, check the center pin contact to make certain it is approximately centered inside the outer contact. If not centered, carefully bend the center contact into position using syringe tip EFD, Inc. Part No. 5122-B (recommended by Amphenol Aerospace) or straightening tool per sketch on back

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Amphenol Aerospace

Contact Part Number	Description	Cable Accommodated	Inner Tool Setting	Inner Crimp Tool	Inner Tool Positioner	Intermediate Tool and Positioner	Outer Tool and Positioner	H	K	L
21-33908-91	Twinax Socket	VG95218T023D002	4	MH992	M22520/2-35 or K532	GS212 GP1271 or GP1613	GS200-1 GP959	.319	.340	.188
21-33909-91	Twinax Pin							.185	.206	.188

CENTER PIN STRAIGHTENING TOOL

