

**21-033380-031 (PIN)**

Contact, Pin, Coaxial,  
Type TV-R Special (2M), Size 12  
Installation Instructions

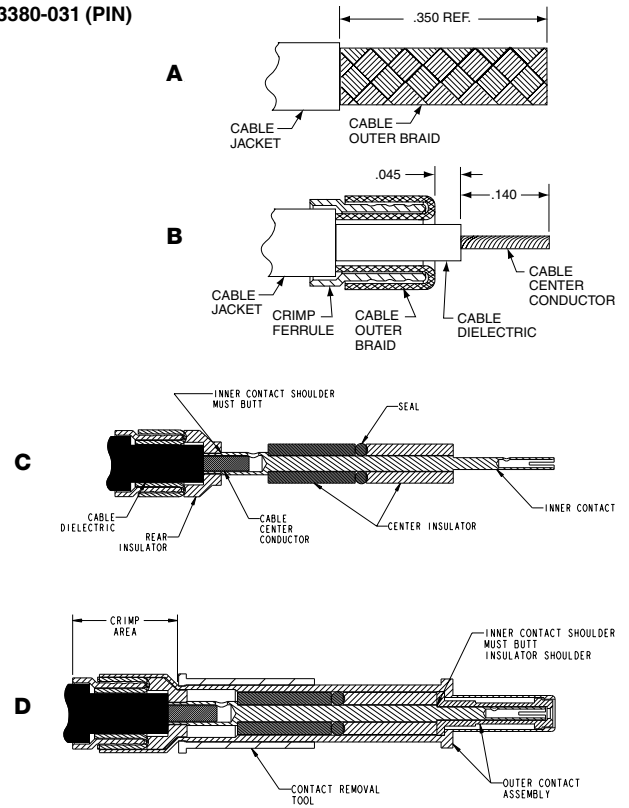
See table for coaxial cables recommended and crimp tool information.

Note: Contacts are designed to terminate to Raychem 5020A1311 cables.

- A. 1. Strip cable jacket to expose cable outer braid, 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 crimp ferrule (see note above), large diameter end first, over cable outer braid until cable jacket butts inside shoulder of crimp ferrule.
- 2. Flair cable outer braid back over crimp ferrule as illustrated.
- 3. Strip cable dielectric to expose cable center conductor as illustrated.
- C. 1. Slide rear insulator, large inside diameter end first, over cable center conductor until cable dielectric butts the inside shoulder of rear insulator.
- 2. Pre-tin the inner contact wire well. Then solder the cable center conductor into the inner contact wire well. After soldering, the inner contact rear must be positioned inside the rear insulator bore, and the inner contact shoulder must butt the rear insulator where illustrated.
- 3. Slide one center insulator over inner contact until it butts inner contact shoulder as illustrated.
- 4. Assemble seal over inner contact until it butts center insulator.
- 5. Slide center insulator over inner contact until it butts seal as illustrated.
- D. 1. Slide outer contact assembly over inner contact assembly until inner contact assembly butts outer contact insulator as illustrated. A slight forward pressure on inner contact assembly will be needed to fully compress inner O-ring seal.
- 2. Crimp outer contact body rear and crimp ferrule using crimp tool and positioner listed in table. Trim excess braid around crimp ferrule.

Note: Removal tool should be positioned fully forward when crimping the outer contact and ferrule, then returned to initial position.

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**CONTACT INSERTION INTO CONNECTOR**

Insert contact assembly into rear connector grommet hole by hand.

**CONTACT REMOVAL FROM CONNECTOR**

Remove contact using removal tool included on contact body.

Amphenol <sup>®</sup> Part Number	Description	Coaxial Cable Recommended	Outer Tools	
			Tool	Positioner
21-033380-031	Matched and Sealed Size 12 Coax Pin	Raychem 5020A1311	M22520/5-01	M22520/5-05 (Location 'B')