

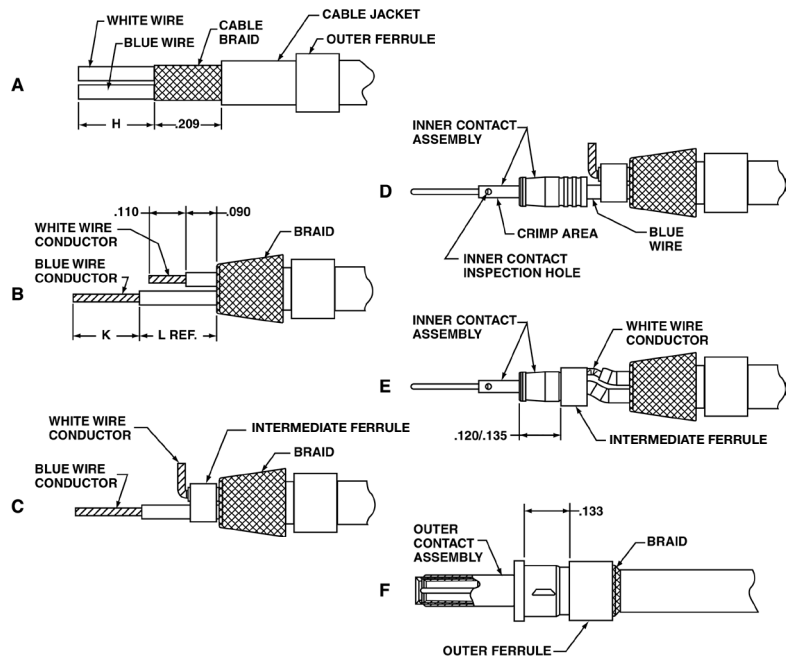
**21-033908-131 (SOCKET)**  
**21-033909-131 (PIN)**

Contact, Size 12, Pin and Socket, Twinaxial,  
 Type LJT-R & TV-R, (MIL-DTL-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, if applicable.  
 3. Trim & strip blue and white wires as shown. (Optional method: wire insulation of blue and white wires may be cut at this point, and then removed after assembly of intermediate ferrule (step C1).)
- C. 1. Assemble intermediate ferrule over blue and white wires until flush against cable braid.  
 2. Bend conductor of white wire as shown, to hold intermediate ferrule in position.
- D. 1. Assemble inner contact assembly over blue 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 white wire conductor forward over the rear of the inner contact assembly. Flatten and spread out conductor wire strands before positioning ferrule. Slide intermediate ferrule forward and over the splayed white wire conductor strands as shown.  
 2. Crimp intermediate ferrule using crimp tool and positioner listed in table. Crimp once, rotate tool 45 degrees and crimp again. Continue to rotate tool 15 degrees 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 (You should hear and/or feel the inner contact assembly snap into the retention clips). If uncertain, a slight pull on the inner assembly can be applied to verify inner contacts seated within the retention clips. After seating, push the inner contact assembly fully forward within the outer contact.  
 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 Amphenol Aerospace recommended syringe tip (EFD, Inc. Part No. 5122-B) or straightening tool per sketch on back.

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**Amphenol Aerospace**

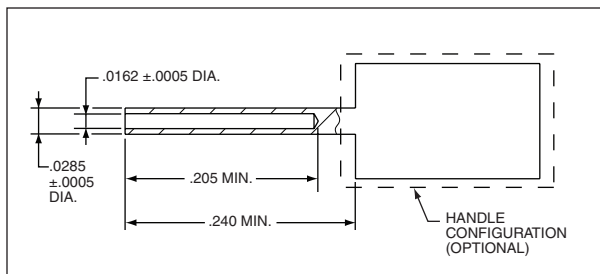
AMPHENOL CORPORATION  
 Amphenol Aerospace  
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 Sidney, New York 13838-1395  
 www.amphenol-aerospace.com

L-2092-AW  
 November 2019

FSCM77820

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
21-033908-131	Twinax Socket	M27500A22SD2T23	4	MH992	M22520/2-35 or K532	GS221 GP1271 (Daniels)	GS200-1 GP959 (Daniels)	.319	.340	.188
21-033909-131	Twinax Pin							.185	.206	.188

**CENTER PIN STRAIGHTENING TOOL**



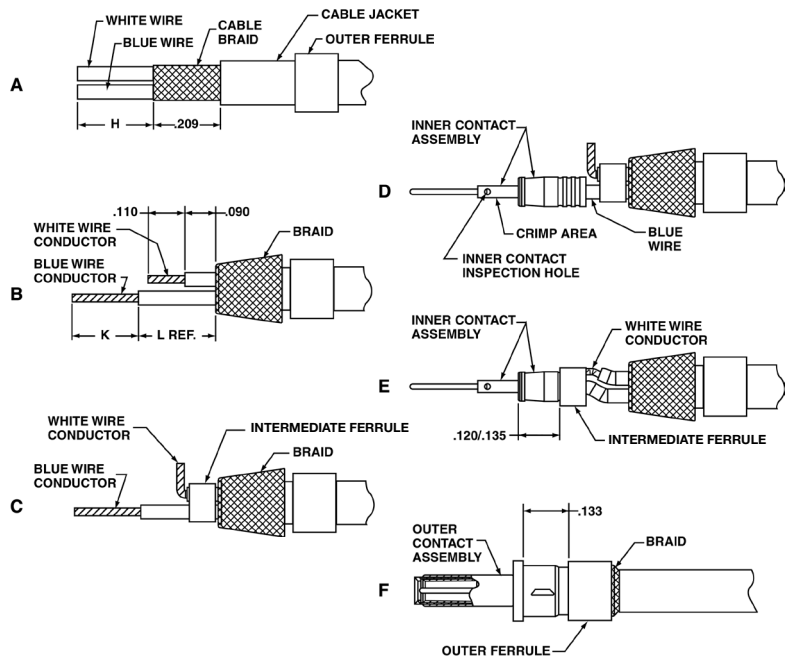
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- C. 1. Assemble intermediate ferrule over blue and white wires until flush against cable braid.  
 2. Bend conductor of white wire as shown, to hold intermediate ferrule in position.
- D. 1. Assemble inner contact assembly over blue wire conductor 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 white wire conductor forward over the rear of the inner contact assembly. Flatten and spread out conductor wire strands before positioning ferrule. Slide intermediate ferrule forward and over the splayed white wire conductor strands as shown.  
 2. Crimp intermediate ferrule using crimp tool and positioner listed in table. Crimp once, rotate tool 45 degrees and crimp again. Continue to rotate tool 15 degrees and crimp until ferrule diameter is .105 Max. (may take 3 to 4 crimps).
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 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).  
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 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 Amphenol Aerospace recommended syringe tip (EFD, Inc. Part No. 5122-B) or straightening tool per sketch on back.

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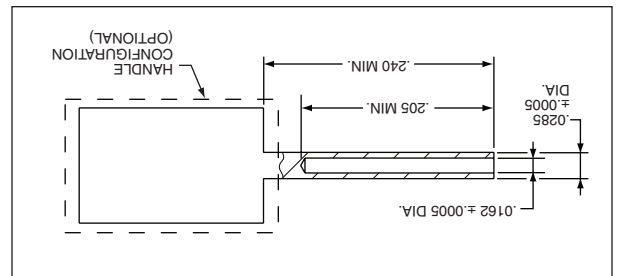


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