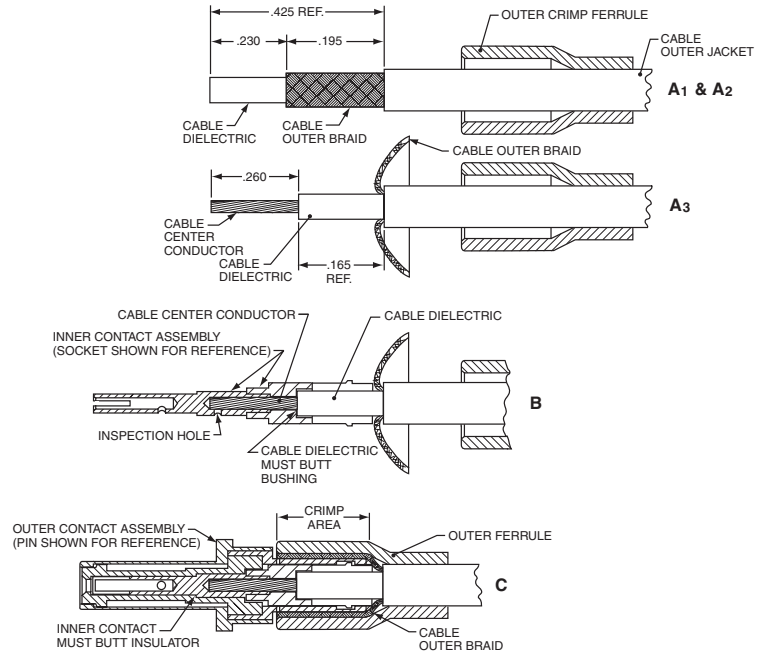


Contact, Pin and Socket, Coaxial,
Type MIS-23393-003 Crimp, Size 12
Installation Instructions

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

- A. 1. Slide outer crimp ferrule over cable outer jacket as shown.
2. Strip 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.
3. Flare outer braid, then strip cable dielectric as shown.
- B. 1. Assemble inner contact assembly over cable center conductor and cable dielectric until inside bore of bushing butts against cable dielectric.
2. Cable center conductor must be visible through the inspection hole in the inner contact wire well.
3. Crimp inner contact wire well using crimp tool listed in table.
- C. 1. Carefully slide outer contact assembly over inner contact assembly and under cable outer braid until inner contact butts against insulator shoulder as illustrated. (Inner contact assembly will snap into the locked position when fully assembled inside the outer contact assembly).
2. Bring outer crimp ferrule forward over cable outer braid until ferrule comes to a stop. (Continue to push the inner contact assembly fully forward while bringing the outer crimp ferrule into position).
3. Crimp outer crimp ferrule using crimp tool listed in table. (.156 Max. over ferrule after crimping). Trim excess braid ahead of crimp ferrule, if necessary.



Amphenol Aerospace

Amphenol® Part Number	Description	Coaxial Cable Accommodated	Tools				
			Inner Contact			Outer Contact	
			Crimp Tool	Setting	Positioner (Daniels)	Tool	Positioner
21-033006-001	Size 12 Coax Pin	RG316 (M17/113-RG316)	M22520/2-01	3	K597	M22520/5-01	M22520/5-03 (A) or M22520/5-35 (B)
21-033005-001	Size 12 Coax Socket		M22520/2-01	3	K593 or K597		

CONTACT INSERTION INTO CONNECTOR

Using insertion tool (part number M81969/8-09 or M81969/14-04), 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 FROM CONNECTOR

Position removal tool (part number M81969/8-10 or M81969/14-04) 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.

