

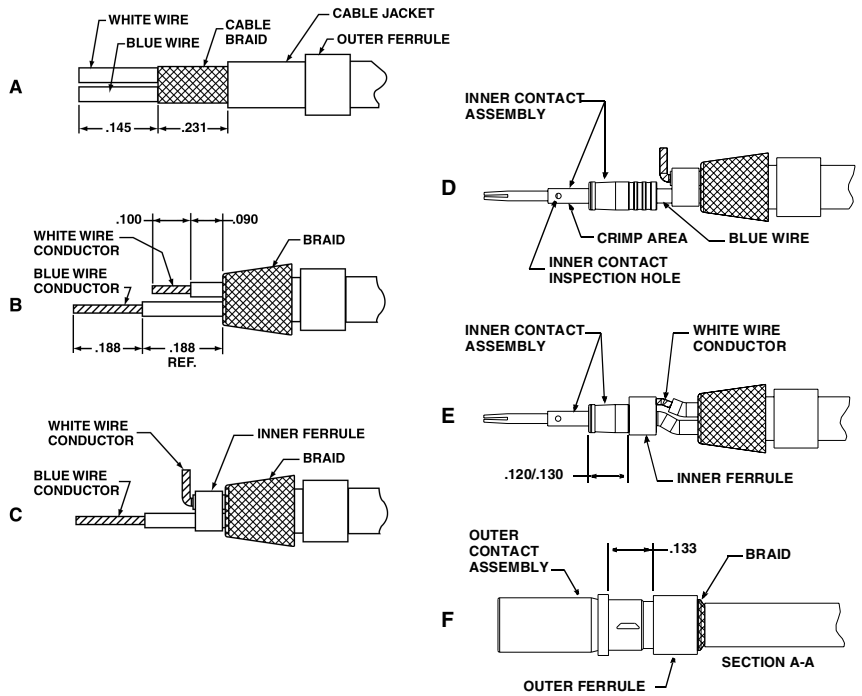
21-33640-25 (SOCKET)

Contact, Size 12, Socket, Twinaxial,
Type JT-R, (MIL-DTL-38999 Series II) 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 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 inner ferrule (step C1).)
- C. 1. Assemble inner ferrule over blue and white wires until flush against cable braid.
2. Bend conductor of white wire as shown, to hold inner 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. Slide inner ferrule forward and over the white 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 45 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.
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.

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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
21-33640-25	JT Twinax Socket	M17/176-00002	5	MH992	K1360	GS212 GP1271	GS200-1 GP959

* Use setting 5 for 24 AWG inner wires.
Use setting 4 for 26 AWG inner wires.