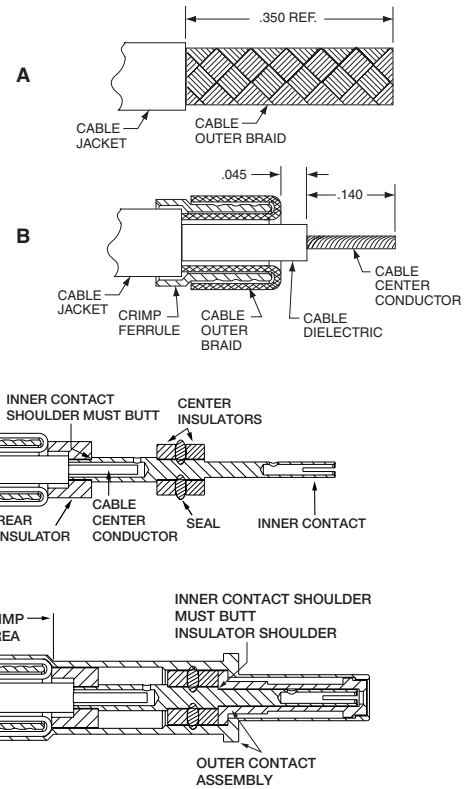


21-33380-21 (PIN)
21-33381-21 (SOCKET)

Contact, Pin and Socket, Coaxial,
 Type TV-R Special (MIL-DTL-38999 Series III Multi-web), Size 12
 Installation Instructions

See table for coaxial cables recommended and crimp tool information.

- 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, 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 second center insulator over inner contact until it butts seal. The seal will need to be compressed slightly by the second center insulator to make space on the inner contact shoulder.
- 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. Insert contact assembly into crimp tool and apply forward pressure on inner contact assembly to fully compress inner O-ring seal. Maintain forward pressure and crimp outer contact body rear & crimp ferrule where illustrated (crimp tool and positioner listed in table). Crimp outer contact once. Rotate contact assembly 45° and crimp a second time (.156 max. over crimp area after crimping). Trim excess braid around crimp ferrule.



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L-2092-Y
 May 2006

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AMPHENOL CORPORATION
 Amphenol Aerospace
 40-60 Delaware Avenue
 Sidney, New York 13838-1395

21-33380-21 (PIN)
21-33381-21 (SOCKET)

CONTACT INSERTION INTO CONNECTOR

Using insertion tool, part number 10-628500-12 (yellow), 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 10-628500-12 (white), 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.

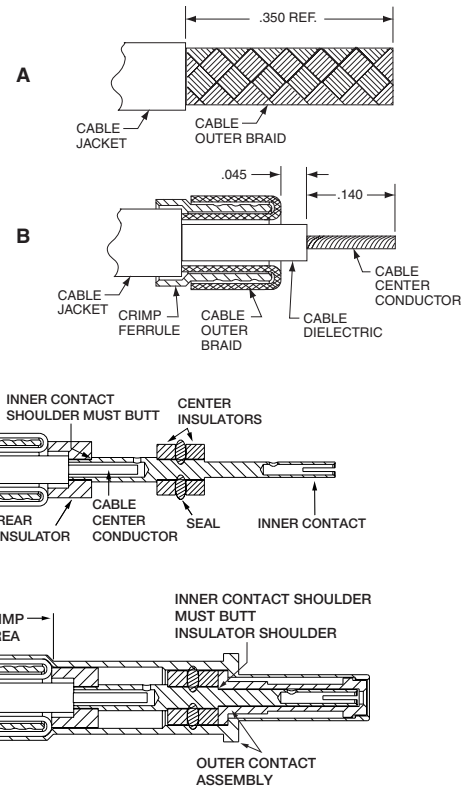
| Amphenol® Part Number | Description | Coaxial Cable Recommended | Outer Tools | |
|-----------------------|--|---------------------------|--------------|------------|
| | | | Tool | Positioner |
| 21-33380-21 | Matched and Sealed Size 12 Coax Pin | RG316 M17/113-RG316 | M22520/31-01 | GP1465 |
| 21-33381-21 | Matched and Sealed Size 12 Coax Socket | RG316 M17/113-RG316 | | |

21-33380-21 (PIN)
21-33381-21 (SOCKET)

Contact, Pin and Socket, Coaxial,
 Type TV-R Special (MIL-DTL-38999 Series III Multi-web), Size 12
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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.
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| Amphenol® Part Number | Description | Coaxial Cable Recommended | Tool | Positioner |
|-----------------------|--|---------------------------|--------------|------------|
| 21-33381-21 | Matched and Sealed Size 12 Coax Socket | RG316 M17/13-RG316 | M22520/31-01 | GP1465 |
| 21-33380-21 | Matched and Sealed Size 12 Coax Pin | RG316 M17/13-RG316 | | |
| | | Outer Tools | | |

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