

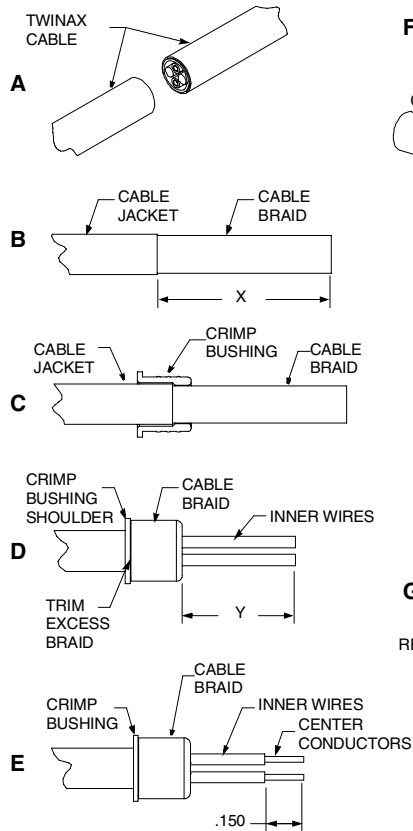
**21-33435-1 (SOCKET)**  
**21-33436-1 (PIN)**

Contact, Pin and Socket, Differential Twinax,  
 Type ARINC High Speed Connector, Special  
 Installation Instructions

See table on reverse side for twinax cable recommended, tool selector settings, crimping tool, positioner and insertion/removal tool information.

- A** 1. Cut cable for assembly of differential twinax contacts.
- B** 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. Cable must not be deformed while making cuts. See table for stripping dimensions.
- C** 1. Slide crimp bushing, large diameter end first, over cable braid until cable jacket butts inside shoulder of crimp bushing.
- D** 1. Flair cable braid back over crimp bushing as illustrated to expose inner wires. Trim excess cable braid. (Cable braid must not cover bushing shoulder).
2. Cut off any inner braids, wraps or cable fillers as close to outer cable braid as possible.
3. Cut inner wires to dimension shown. All wires must be cut to equal length. It may be helpful to cut one wire to length. Then cut remaining wire to equal length as the first wire. See table for dimensional data.
- E** 1. Strip inner wires to expose center conductors as illustrated. All wires must be stripped to equal length.
- F** 1. Carefully splay inner wires perpendicular to the axis of the cable as illustrated.
2. Assemble inner contact over cable center conductor until fully seated against inner wire insulation. Observe center conductor through the contact's wire inspection hole, to make certain conductor is properly positioned.
3. Crimp inner contact to center conductor using crimp tools listed in table on back. Repeat steps F2 and F3 until all inner contacts are crimped.
- G** 1. Position rear insulator against cable braid as illustrated. Make certain insulator slots are aligned with splayed inner contact wires. One-by-one, position wired inner contacts inside the insulator slots as shown. The inner contact's retention shoulder must be positioned in front of the insulator's front surface as illustrated.

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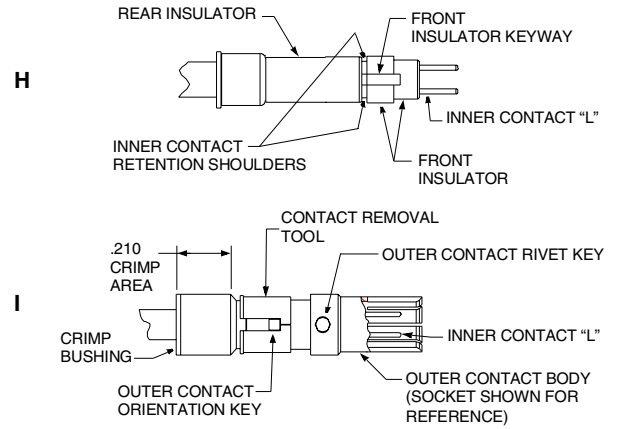
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**21-33435-1 (SOCKET)**  
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- H
1. With inner contacts positioned inside rear insulator slots, assemble front insulator over the inner contacts as shown. The front insulator must butt the inner contact retention shoulders.
  2. Observe the front insulator's keyway. When the inner assembly is held in the horizontal position, as illustrated, the inner pin contact indicated by "L" in drawing will be positioned at the "9 o'clock" orientation position, when viewing the socket contact assembly from the mating end (with the outer contact orientation key held at the "12 o'clock" position).
- I
1. Align front insulator keyway with the outer contact's rivet key. Slide the inner contact assembly inside the outer contact body until fully seated. Observe the mating end of the assembly to make certain the inner contacts are at the "9 o'clock" and "3 o'clock" orientation positions when the outer contact's orientation key is held at the "12 o'clock" position.
  2. Push contact removal tool fully forward against outer contact's retention shoulder, to prevent damage to tool during crimping the outer contact.
  3. Crimp outer contact body in the area indicated using crimp tools listed in table below.
  4. Push the contact removal tool rearward until slotted surface of tool butts the outer contact's orientation key.



Amphenol Part Number	Description	Twinax Cable Recommended	Inner Crimp Tools		Outer Crimp Tools		Dimensional Data	
			Tool (Setting)	Positioner	Tool	Die Set (Location)	X	Y
21-33435-1	Differential Twinax Socket (100 Ohm)	Tensolite 24463/9P025X-2 (100 Ohm)	M22520/2-01 (4)	K1539 (Daniels)	M22520/5-01	M22520/5-45 (A)	.688	.555
21-33436-1	Differential Twinax Pin (100 Ohm)						TBD	TBD

**Contact Insertion into Connector**

Contacts are inserted by hand. Insert the contact assembly into the proper connector cavity. Contact must be aligned with cavity and not inserted at an angle. The contact's orientation key must be in alignment with the connector cavity orientation keyway. Push forward until contact is felt to snap into position within the cavity. Gently tug on cable to assure retention.

**Contact Removal from Connector**

Push contact removal tool fully forward until tool tip comes to a positive stop against the contact's retention shoulder. Grip cable and simultaneously remove contact and cable.

**Amphenol**

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