## 21-033468-021 (PLUG)

Continued on back

L-2119-ED

July 2015

2

H 1.

2.

table below.

21-033468-021 (PLUG)

inner ID#1 position shown in View 1.

contacts will lock in place.)

are aligned as shown in View I.

## Transition Adapter, Plug, Quadrax Type High Speed, to Board, Installation Instructions

See table on reverse side for quadrax cable recommended, tool selector settings, crimping tool and positioner information.

- A 1. Cut cable for assembly of transition adapter plug.
- 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.
- 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 wire pairs. Trim excess cable braid.
- Cut inner wire pairs with foils in place to dimension shown. All wires must be cut to equal length. It may be helpful to cut one wire pair to length. Then cut remaining wire pair to equal length as the first wire pair.
- E 1. Strip individual differential pair foil shield as close to flaired cable braid as possible.
- 2. 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.
  - 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.
  - 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. Observe the black insulator's keyway. When the inner pin assembly is held in the vertical position (with inner pin contacts on top), the inner pin

contact with the black insulator keyway to its left will be positioned at the

With inner contacts positioned in their approximate final locations (pair #1 contacts aligned with pair #1 insulator window, pair #2 contacts aligned with pair #2 insulator window with the inner contacts approxi-

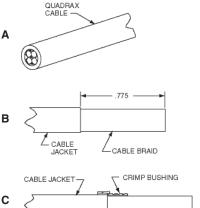
mately lined up with contact cavities), assemble front insulator over the inner contacts as shown, being careful to guide the inner contacts through the insulators. The insulator must butt the crimp ferrule, and inner contact retention shoulders must click in front of the retention tines. (Inner

Align black insulator keyway with the outer contact's rivet key. Slide the

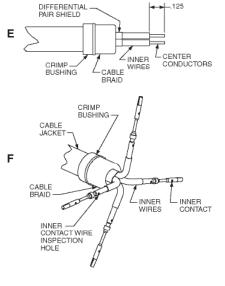
inner contact assembly inside the outer contact body until fully seated.

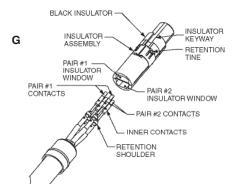
Observe the mating end of the assembly to make certain inner contacts

Crimp outer contact body in the area indicated using crimp tools listed in









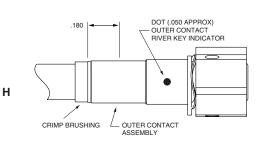
.450

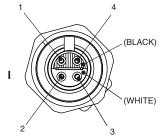
TRIM

EXCESS

NNER WIRE

PAIRS (WITH FOIL)





Amphenol Part	Description	Twinax Cable Recommended	Inner Crimp Tools		Outer Crimp Tools	
Number			Tool (Setting)	Positioner	Tool	Die Set (Location)
21-033468-021	Quadrax Transition Adapter Plug (100 Ohm)	Thermax 1536-224 (100 Ohm)	M22520/2-01 (4)	Daniels K1777	M22520/5-01	M22520/5-45 (A) or Daniels Y1999 (A

Amphenol Suggested Wiring					
Differential Pair	Inner ID	Wire Color			
4	1	Red			
I	4	Blue			
2	2	Yellow			
2	3	Green			

## Amphenol

Amphenol Aerospace 40-60 Delaware Avenue Sidney, New York 13838-1395 Website: www.amphenol-aerospace.com

## 21-033468-021 (PLUG)

CABLE BRAID

CRIMP ---/ BUSHING

D

FSCM77820

## Continued on back

## PSCM77820

## 21-033468-021 (PLUG) July 2015 03-6112-1

- contact with the black insulator keyway to its left will be positioned at the inner ID#1 position shown in View I. held in the vertical position (with inner pin contacts on top), the inner pin Observe the black insulator's keyway. When the inner pin assembly is เย
- (Inner contacts will lock in place.) ner contact retention shoulders must click in front of the retention tines. through the insulators. The insulator must butt the crimp ferrule, and ininner contacts as shown, being careful to guide the inner contacts mately lined up with contact cavities), assemble front insulator over the aligned with pair #2 insulator window with the inner contacts approxi-#1 contacts aligned with pair #1 insulator window, pair #2 contacts With inner contacts positioned in their approximate final locations (pair .2
- are aligned as shown in View I. Observe the mating end of the assembly to make certain inner contacts inner contact assembly inside the outer contact body until fully seated. Align black insulator keyway with the outer contact's rivet key. Slide the .F H
- table below. Crimp outer contact body in the area indicated using crimp tools listed in .2
- (mdO 00f) A) 6661Y sleinsD (mdO 001) (7) **Buld netter Plug** 10 M225220/5-01 **TATIN Slains** 1236-224 21-033468-021 M225220/2-01 Transition (A) 84-8/0282SM Тћегтах Quadrax (Location) (Setting) 1001 Positioner рәриәшшорәу JedmuN J92 9iQ 1001 Description The IonardmA **Twinax Cable** Outer Crimp Tools Inner Crimp Tools

## lonshqmA

Website: www.amphenol-aerospace.com Sidney, New York 13838-1395 40-60 Delaware Avenue Amphenol Aerospace

Slide crimp bushing, large diameter end first, over cable braid until cable jacket butts inside shoulder of crimp bushing.

ble. Cable must not be deformed while making cuts.

Type High Speed, to Board,

Installation Instructions

See table on reverse side for quadrax cable recommended, tool selec-

tor settings, crimping tool and positioner information.

A 1. Cut cable for assembly of transition adapter plug.

ductor is properly positioned.

D 1. Flair cable braid back over crimp bushing as illustrated to expose

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 ca-

- inner wire pairs. Trim excess cable braid. 2. Cut inner wire pairs with foils in place to dimension shown. All wires must be cut to equal length. It may be helpful to cut one wire

- pair to length. Then cut remaining wire pair to equal length as the
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- braid as possible.
- 2. 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

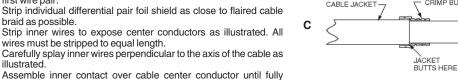
- illustrated.

seated against inner wire insulation. Observe center conductor

through the contact's wire inspection hole, to make certain con-

Crimp inner contact to center conductor using crimp tools listed in

table on back. Repeat steps F2 and F3 until all inner contacts are



D

Α

В



CABLE

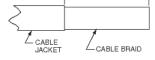
BRAID

NNER WIRE

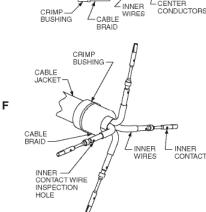
PAIRS (WITH FOIL)

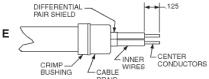
.450

EXCESS









## 21-033468-021 (PLUG)

B 1.

C 1.

2.

3.

crimped.

นออมุก

Vellow

Blue

кеq

Color

**Wire** 

3

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(ATIHW)

(RLACK)

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Janner

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BuiniW beteggue lonadqmA

2

Pair

Differential

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TOATHOO RETUO

(XOA99A 020.) TOD

STOATNOO RENN

Z# HI¥c

PAIR #2 CONTACTS

WOONIW ROTAJURN

TINE RETENTION

YAWY 3> ROTAJUSN надлооне

RETENTION

DNIHSOHR AWING

08ŀ

PAIR #1 -----CONTACTS

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MODNIW WODNIW

ROTAJUSNI YJ8MBSSA

BLACK INSULATOR

F# AIA9

н

# Transition Adapter, Plug, Quadrax

QUADRAX CABLE —

CABLE BRAID

CRIMP ---/ BUSHING