

Application Tools

The following data includes information pertaining to the application tools which have been established for crimping, inserting, and removing contacts incorporated in the TV, CTV and MIL-DTL-38999 Series III connectors. For additional information on coax, twinax and triax contact tools, see High Speed Contact section of this catalog.

All crimping tools included are the “full cycling” type and when used as specified in the installation instructions L-624 covering the TV, CTV and MS series connectors, will provide reliable crimped wire to contact terminations. There is a possibility of additional crimping tools other than those included being available at present or in the future for this specific application.

CRIMPING TOOLS

Contact Size/Type	Crimping Tool	Turret Die or Positioner	Contact Size/Type	Crimping Tool	Turret Die or Positioner
12 Pin and Socket	M22520/1-01	M22520/1-04	8 Coaxial Inner Pin and Socket	M22520/2-01	M22520/2-31
16 Pin and Socket	M22520/1-01 M22520/7-01	M22520/1-04 M22520/7-04		M22520/5-01	M22520/5-05 Die Closure B
20 Pin and Socket	M22520/1-01 M22520/2-01 M22520/7-01	M22520/1-04 M22520/2-10 M22520/7-08	8 Coaxial Outer Pin and Socket	M22520/5-01	M22520/5-41 Die Closure B
22, 22D, 22M Pin	M22520/2-01 M22520/7-01	M22520/2-09 M22520/7-07		M22520/10-01	M22520/10-07 Die Closure B
22, 22D, 22M Socket Series I, III	M22520/2-01 M22520/7-01	M22520/2-07 M22520/7-05	16 Coaxial Inner Pin and Socket	M22520/2-01	M22520/2-35
22D Socket Series II	M22520/2-01 M22520/7-01	M22520/2-06 M22520/7-06	16 Coaxial Outer Pin and Socket	M22520/4-01	M22520/4-02
8 Twinax Center Pin and Socket	M22520/2-01	M22520/2-37	12 Coaxial Inner Pin and Socket	M22520/2-01	M22520/2-34
8 Twinax Intermediate Outer Pin & Socket	M22520/5-01	M22520/5-200	12 Coaxial Outer Pin and Socket	M22520/31-01	M22520/31-02
			10 (Power)	TP-201423	

Where 2 or 3 tools are listed for a contact size, only one tool and its die or positioner are required to crimp the contact. The above crimping tools and positioners are available from the approved tool manufacturer.

INSERTION TOOLS

Use with Contact Size	Plastic Tools		Metal Tools			
	MS Part Number	Color	Angle Type		Straight Type Commercial Part No.	Color
			MS Part No.	Commercial Part No.		
10 (Power)	M81969/14-05*	Gray / (White)	M81969/8-11	†	†	Green
12	M81969/14-04*	Yellow / (White)	M81969/8-09	11-8674-12††	11-8794-12††	Yellow
16	M81969/14-03*	Blue / (White)	M81969/8-07	11-8674-16††	11-8794-16††	Blue
20	M81969/14-10*	Red / (Orange)	M81969/8-05	11-8674-20††	11-8794-20††	Red
22	M81969/14-09	Brown/White	M81969/8-03	11-8674-22††	11-8794-22††	Brown
22D, 22M	M81969/14-01*	Green / (White)	M81969/8-01	11-8674-24††	11-8794-24††	Black
8 Coaxial	None Required					
8 Twinax	None	None	None	None	None	Red

REMOVAL TOOLS

Use with Contact Size	Plastic Tools		Metal Tools				
	MS Part Number	Color	For Unwired Contacts Commercial Part No.	Angle Type		Straight Type Commercial Part No.	Color
				MS Part No.	Commercial Part No.		
10 (Power)	M81969/14-05*	(Gray) / White	†	M81969/8-12	†	†	Green / White
12	M81969/14-04*	(Yellow) / White	11-10050-11††	M81969/8-10	11-8675-12††	11-8795-12††	Yellow / White
16	M81969/14-03*	(Blue) / White	11-10050-10††	M81969/8-08	11-8675-16††	11-8795-16††	Blue / White
20	M81969/14-10*	(Orange) / Red	11-10050-9††	M81969/8-06	11-8675-20††	11-8795-20††	Red / Orange
22	M81969/14-09*	(Brown)/White	11-10050-8††	M81969/8-04	11-8675-22††	11-8795-22††	Brown/White
22D, 22M	M81969/14-01*	(Green) / White	11-10050-7††	M81969/8-02	11-8675-24††	11-8795-24††	Green / White
8 Coaxial	M81969/14-12	Green	None	None	11-9170††	DRK264-8†††	N/A
8 Twinax	M81969/14-12	Green	None	None	11-9170††	N/A	N/A

For information about contacts see page 29. The M81969/8, 11-8674, 11-8675, and 11-8794 metal contact insertion and removal tools will accommodate wires having the maximum outside diameter as follows: Contact size 12: dia. is .155, size 16: dia. is .109, size 20: dia. is .077, size 22D: dia. is .050. When wire diameters exceed those specified, the plastic tools must be used.

* Double end insertion/removal tool.

** Twinax insertion tools are available only in a straight type, metal version.

† To be determined.

†† Contact Daniels Manufacturing Co. or Astro Tool Corp. for availability.

††† Daniels Manufacturing Co. part number