Note: 21-33190-22 Contact with Piggyback Grommet seal is designed for use in MIL-DTL-38999 Series I and III standard connector arrangements 17-2, 21-75, 21-79, 25-7 and 25-46 only. For 21-33190-22, the Piggyback Grommet Seal (part number 21-33321-5 or -6) is supplied with the connector assembly.

1. Assemble Piggyback Grommet Seal: See Figure 1.
2. Strip cable per Figure 2.
3. Bushing and shield location:
   3.1 Slide crimp bushing over cable jacket, large end first until small end is even with cable jacket.
   3.2 Flare outer shield back over crimp bushing.
   3.3 Unwrap conductive foil and pull back over first shield and crimp bushing. Flatten foil.
   3.4 Flare inner shield back over outer shield and conductive foil.
   3.5 Cut off fillers as close to shield as possible.
4. Assemble spacer insulator over blue and white wire.
5. Bend white wire away from blue wire and assemble back insulator over blue wire and butt firmly against spacer insulator. Align slot with white wire.
6. Fit inner pin contact over blue wire conductor. (See Fig. 6) and crimp with M22520/2-01 tool and M22520/2-37 positioner. Use tool selector setting number five (5).
7. Assemble inner front insulator over center pin contact being careful to align slot with white wire as insulator is slid back until it butts firmly.
8. Slide intermediate contact over inner front insulator being sure all strands of the white conductor enter small hole in the intermediate contact large end. Slot in intermediate contact should be 180 degrees opposite white wire.
9. Crimp intermediate contact wire well using tool M22520/5-01 and die set M22520/5-200. (Die set has a blade for location of slot and a double indent portion to crimp wire side).
10. Slide outer pin contact, with insulator installed, over assembly until it butts firmly. A small gap at the bushing will occur.
11. Crimp assembly, bushing and outer contact, with tool M22520/5-01 and die set M22520/5-200.
12. Insert the contact assembly into the connector grommet until it seats firmly. Tug slightly on wire to insure contact has properly seated.
13. Slide Piggyback grommet down cable until it butts firmly on contact.

L-1253-C
May 2002

FSCM 77820
EQUIVALENT APPLICATION TOOLS

DIE SET POSITIONER CONTACT REMOVAL

<table>
<thead>
<tr>
<th>DIE SET</th>
<th>POSITIONER</th>
<th>CONTACT REMOVAL</th>
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<tbody>
<tr>
<td>M22520/5-200</td>
<td>M22520/2-37</td>
<td>DANIELS DRK 264-8</td>
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<tr>
<td>OR AMPHENOL® 11-12101</td>
<td>OR AMPHENOL® 11-12102</td>
<td>OR DANIELS K709</td>
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<td>OR DANIELS Y631</td>
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FIRM BUTT BEFORE CRIMPING TRIM CONDUCTOR IF NECESSARY
WIRE MUST BE VISIBLE THROUGH INSPECTION HOLE
INNER PIN CONTACT CRIMPED ON BLUE WIRE CONDUCTOR
WHITE WIRE INNER FRONT INSULATOR
CRIMP INTERMEDIATE CONTACT WIRE WELL TO WHITE WIRE
INTERMEDIATE SOCKET CONTACT

.276 MAXIMUM FINISH DIA. OVER CRIMPED CONTACT
HEX CRIMP LENGTH CRIMP BUSHING AND OUTER CONTACT SIMULTANEOUSLY
OUTER PIN CONTACT WITH INSULATOR INSTALL