

Contact, Socket, Coaxial, Type LJT-R and TV-R, Crimp  
(MIL-DTL-38999 Series I & III Electrical Connectors)

## Installation Instructions

- A**
1. The contact incorporates a piggyback grommet seal. Assemble the piggyback grommet seal over the cable jacket, rubber end first, before stripping cable.
  2. Strip cable 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 shield crimp sleeve over cable shield until flush with edge of cable jacket.
  2. Trim shields flush with edge of shield crimp sleeve.
- C**
1. Slide shield crimp sleeve back over cable jacket.
  2. Flair outer shield back over cable jacket and remove copper tape as close to outer shield as possible.
  3. Position nut on retainer as illustrated.
  4. Slide nut and retainer assembly under the cable shield until retainer bottoms against shield.
  5. Strip cable core (inside insulation) flush with end of retainer, exposing cable center conductor.
- D**
1. Bring shield crimp sleeve forward over cable shield and observe .010 to .050 inch dimension.
  2. Crimp shield crimp sleeve using M22520/5-01 tool frame and M22520/5-05(B) die set. Nut must rotate freely after crimping shield crimp sleeve.
- E**
1. Install rear insulator on back of inner pin contact. Trim fit contact and insulator assembly to center conductor. Trim center conductor to allow rear insulator to butt against the retainer when inner pin contact is installed. Center conductor must be visible through inspection hole in inner pin contact wire well.
  2. Tin center conductor, and using a 47.5 watt soldering iron, solder the center conductor into the inner pin contact wire well. A pin vise can be used to hold the inner pin contact.
- F**
1. Slide front insulator, large end first, over the inner pin contact until insulator seats against the inner pin contact shoulder.
- G**
1. Slide outer socket contact over inner pin assembly and insulator, and thread nut into rear of outer socket contact.
  2. Tighten nut until metal to metal bottoming is achieved between retainer shoulder and outer socket contact. Torque on nut shall be 30–36 inch ounces. DO NOT allow the cable to rotate while tightening the nut.

## CONTACT INSERTION INTO CONNECTOR

Contacts are inserted by hand. Slide the wire sealing member (piggyback grommet seal) on the cable and over the crimped shield crimp sleeve. Insert the contact/cable assembly into proper rear grommet hole. Contact must be aligned with hole and not inserted at an angle. Push forward until contact and wire sealing member is felt to snap into position within the insert. Gently tug on the cable to assure retention.

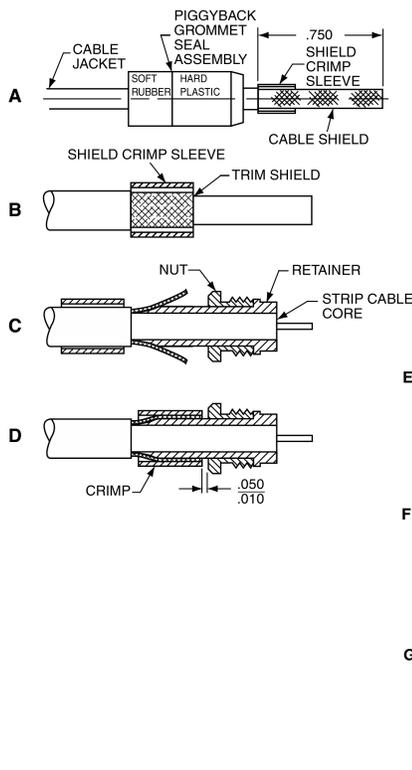
## CONTACT REMOVAL FROM THE CONNECTOR

Remove the wire sealing member from the grommet (piggyback grommet seal). Position Amphenol removal tool, part number 11-9170, or Daniels DRK-264-8 around cable and slide tool toward connector until tool tips enter rear grommet and come to a positive stop on contact. Grip cable and simultaneously remove tool, contact and cable.

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