

21-033591-031

Contact, Socket, Coaxial Type LJT-R, TV-R (MIL-DTL-38999 Series I & III)
Installation Instructions

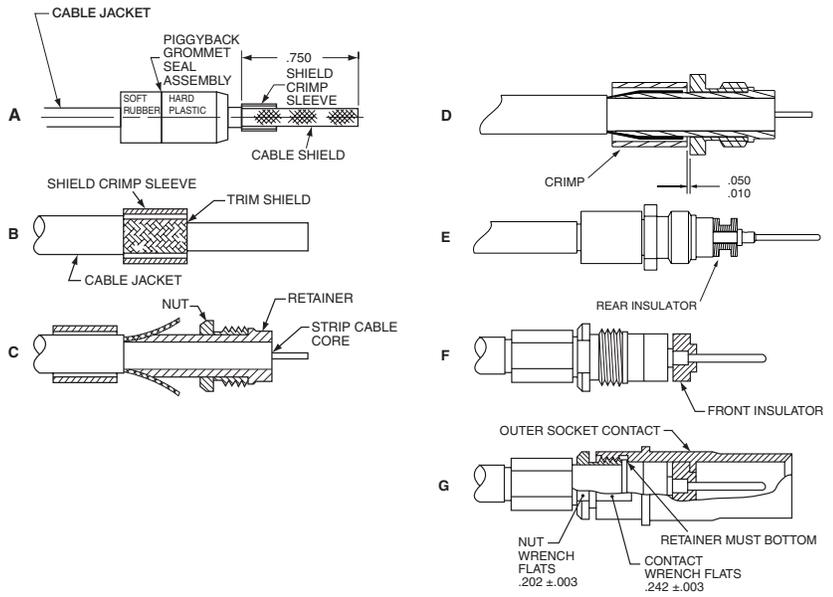
See table for coaxial cable recommended, tool selector settings, crimping tool and positioner information.

- A** 1. The contact incorporates a piggyback grommet seal. This member must be slid onto the cable prior to assembly of the coaxial contact to the coaxial cable (rubber end first).
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. Hot wire stripping is recommended
- 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. Flare outer shield back over cable jacket and remove inner foil shield as close to outer shield as possible.
3. Position nut on retainer as illustrated.
4. Slide nut and retainer assembly under the cable shields until retainer bottoms against shields.
5. Strip cable core (inside insulation) flush with end of retainer, exposing cable center conductor.
- D** 1. Bring shield crimp sleeve forward over cable shields and observe .010 to .050 inch dimension.
2. Crimp shield crimp sleeve using tool and die listed in table on back. 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.
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 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.

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

PART NO.	COAXIAL CABLE ACCOMODATED	TOOLS					CONTACT REMOVAL TOOL PART NO.	
		INNER CONTACT			SHIELDED SLEEVE			
		TOOL SELECTOR SETTING NO.	BASIC CRIMPING TOOL	POSITIONER	BASIC CRIMPING TOOL	DIE		DIE CLOSURE
21-033591-031	BELDEN 1855A	Solder Termination			M22520/5-01 M22520/10-01	M22520/5-05 M22520/10-07	B B	MIL-I-81969/14-12 or DANIELS DRK-264-8 or AMPHENOL 11-9170

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 wire sealing member from grommet, (piggyback grommet seal). Position removal tool part number MIL-I-81969/14-12 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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Sidney, New York 13838-1395 | Website: www.amphenol-aerospace.com