21-33724-15

Contact, Pin, Size 8 Crimp Type Shielded Twinaxial-Triaxial Installation Instructions

Contact is for use in MIL-C-38999 Series I and Series III Style Electrical Connectors. Connector arrangements applicable are 17-2, 21-75, 21-79, 25-7, 25-26, 25-46 (Consult factory for availability).

NOTES: This contact requires the use of a piggyback grommet seal which is supplied with the contact. Installation instructions are as follows:

A. 1. For harness assemblies part number 21-33722 series, slide part numbered heat shrink sleeve over cable jacket as shown. Do not heat shrink at this time.

2. Assemble piggyback grommet seal over cable jacket, rubber end first as shown.

B. 1. Strip cable jacket to dimension shown (.50 max). Caution must be used so that shield strands are not cut or nicked during stripping operation.

2. Assemble crimp bushing over end of cable, flange end first as shown. Wrap cable with tape to support crimp bushing position. (Tape must be removed after assembly is completed).

3. Flare shield back over the crimp bushing. Do not comb out shield. Trim shield strands even with front of crimp bushing flange as illustrated. A .015 max gap is permissible.

C. 1. Strip blue and white wire insulation as shown. Be sure not to cut or nick wire strands of conductor while removing insulation.

D. 1. Assemble spacer insulator over blue and white wires and firmly butt against shield.

E. 1. Assemble 4 piece contact and insulator module on wires as shown. Typically, the blue wire gets terminated to the center contact, but for harness assemblies 21-33722 Series, the white wire must go to the pin center contact wire well and the blue wire must go to the intermediate socket contact wire well. Trim bare wire conductor lengths such that the wire insulation of both wires seat in the conical entry of the rear guide insulator and the wire conductors are both visible in the inspection hole of each contact wire well.

CAUTION: For harness assemblies 21-33722 Series, be very sure white insulated wire is in the inner pin contact wire well.

F. CRIMPING:

Using an M22520/5-01 crimp tool frame and Daniels Y994 crimp tool dieset, simultaneously crimp both inner and intermediate contact wire wells. The module assembly to be crimped has a flat surface on one side for contact alignment in the dieset.

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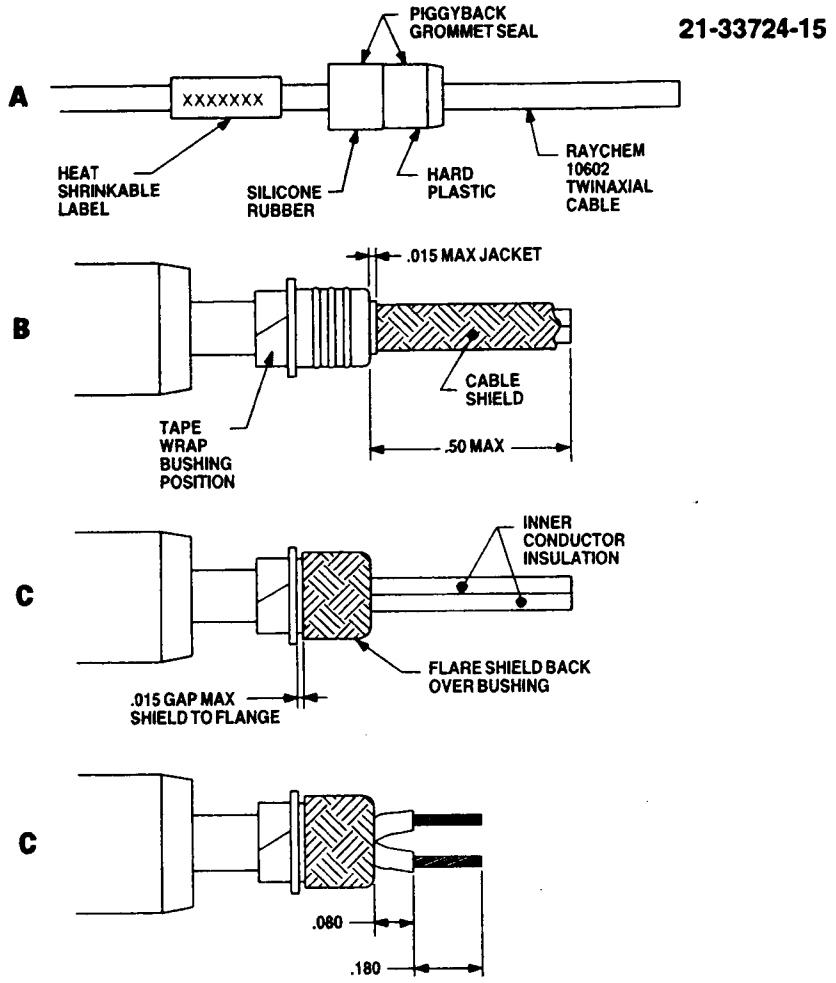

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G. 1. Assemble the outer contact as follows:
Hold the rear crimp bushing firmly and slide the outer pin contact, large end first, over the module, spacer insulator and shield over the crimp bushing. The outer contact must be pushed over the crimp bushing and shield as far as possible and a small gap may appear between the end of the outer pin contact and the crimp bushing rear flange.

2. Crimping:
Crimp Tool Frame: M22520/5-01
Crimp Tool Dieset: M22520/5-45 Closure A (.231 Hex)
With outer pin contact firmly seated on crimp bushing, insert rear portion of pin contact and crimp bushing flange into dieset cavity A to dimension shown and fully cycle crimp tool handles to crimp contact and crimp bushing flange. Release tool handles and examine contact crimp joint.

3. Remove tape wrap, in back of crimp bushing, from cable jacket dia.

H. If heat shrink label is required, slide piggyback grommet seal down cable so that the heat shrink label may be positioned per drawing requirement (21-33722 Series). Heat shrink label in place using a hot air device. Use only enough heat to shrink label.

I. CONTACT INSERTION INTO CONNECTOR:
Contact is hand inserted. Contact must be aligned with hole in connector rear grommet and not inserted at an angle. Push forward on wire until contact is felt to snap into connector retention device. A very slight tug on the wire will confirm the contact has locked into the retention device. Slide the piggyback grommet seal down the wire and into the connector rear grommet hole until it comes to a firm butt.

J. CONTACT REMOVAL FROM THE CONNECTOR:
Carefully slide the piggyback grommet seal out of the connector rear grommet hole and up the wire far enough to permit the use of a contact removal tool. Place a Daniels Mfg. Co. removal tool part number DRK-264-8 or equivalent tool, around wire and slide tool toward connector until tool tips enter rear grommet cavity, pass over contact crimp end and come to a positive stop on the contact retention shoulder. Grip wire and simultaneously remove tool, wire and contact. Other available removal tools: Amphenol Angle Tool, part number 11-9170; Military Tool, part number MIL-I-81969/14-06.

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