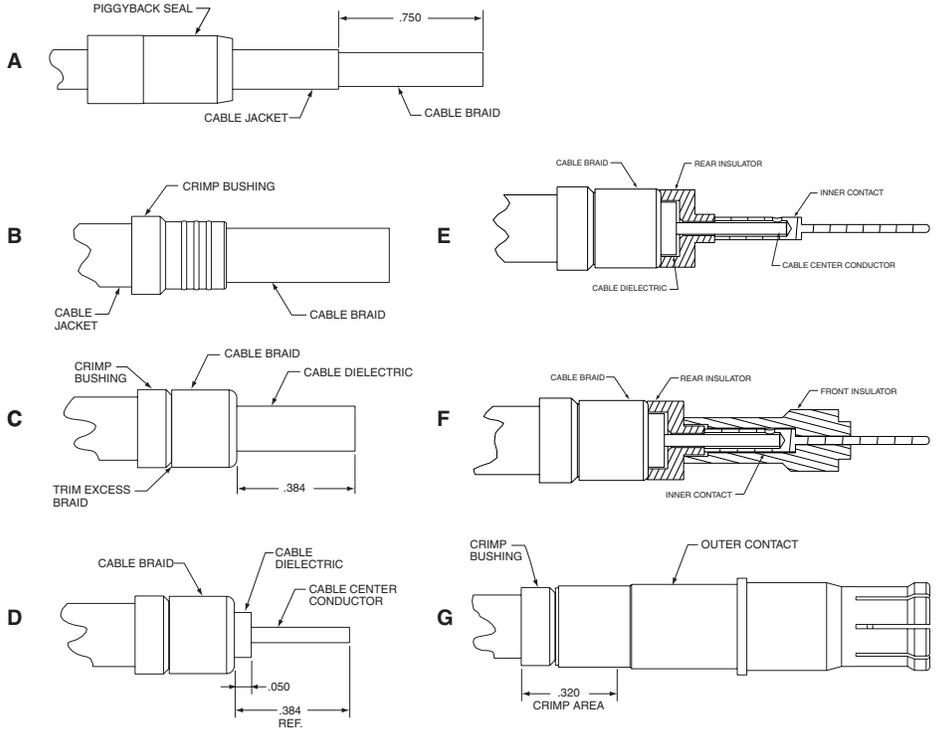


See table on reverse side for coaxial cable recommended, crimping tool and positioner information.

- A**
1. Rubber end first, slide piggyback grommet seal back over cable jacket, before stripping the cable.
  2. Strip cable jacket to expose cable outer braid as illustrated. Ends must be cut cleanly and at right angles to the axial plane of the cable. Cable must not be deformed while making cuts. Hot wire stripping is recommended.
- B**
1. Slide crimp bushing, large diameter end first, over cable braid until cable jacket butts inside shoulder of crimp bushing.
- C**
1. Flair cable braid back over crimp bushing as illustrated to expose cable dielectric. Trim excess cable braid.
  2. Cut away any inner braids and/or wraps as close to outer cable braid as possible.
  3. Cut cable dielectric to dimension shown.
- D**
1. Strip cable dielectric to expose center conductor as illustrated.
- E**
1. Slide rear insulator, large diameter end first, over cable center conductor and dielectric until it butts the cable braid as shown.
  2. Assemble the inner contact over the center conductor until it butts the rear insulator, as shown (trim the cable center conductor if necessary).
  3. Remove the inner contact & tin the cable center conductor using a 47.5 watt soldering iron (inner contact wire well may also be tinned). Solder the center conductor into the inner contact wire well. A pin vice can be used to hold the inner contact.
- F**
1. Slide the front insulator over the inner contact until the inner contact shoulder butts the inside shoulder of the front insulator. A small gap between the front insulator and rear insulator is permissible.
- G**
1. Carefully slide the outer contact over the inner contact assembly until the outer contact is fully seated inside the outer contact.
  2. Crimp the outer contact body & crimp bushing in the area indicated using crimp tool listed in table on back.



PART NO.	COAXIAL CABLE ACCOMMODATED	TOOLS			CONTACT REMOVAL TOOL P/N
		SHIELD CRIMP SLEEVE			
		BASIC CRIMPING TOOL	DIE	DIE CLOSURE	
21-033591-081	GORE CXN3671	M22520/5-01	M22520/5-45	A	MIL-I-81969/14-12 or DANIELS DRK-264-8 or AMPHENOL 11-9170

**CONTACT INSERTION INTO CONNECTOR**

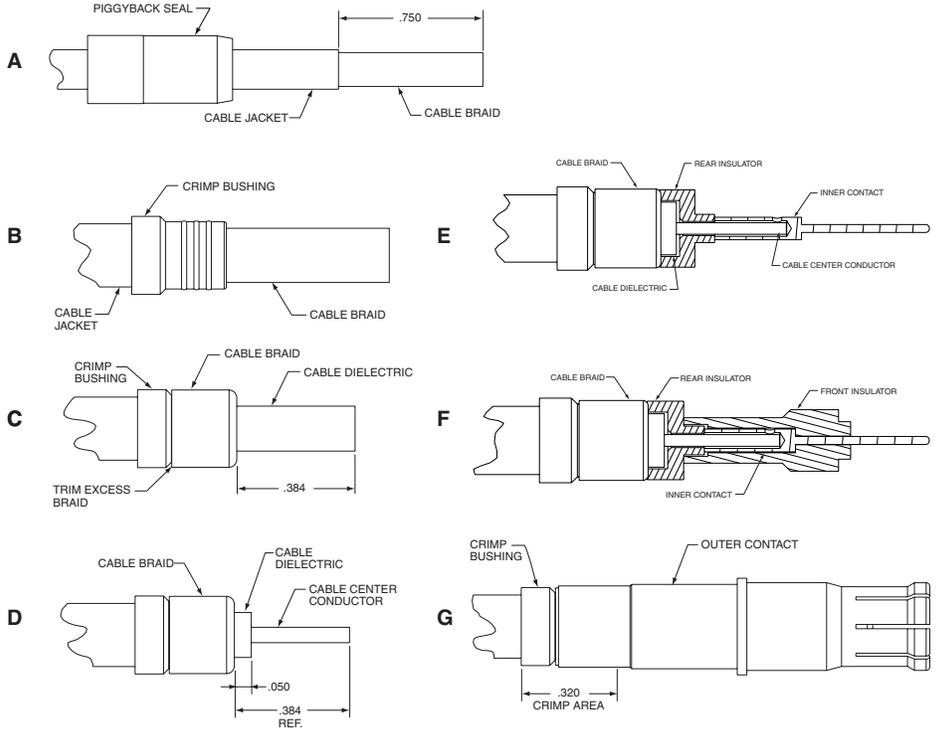
Contacts are inserted by hand. Slide the wire sealing member (piggyback grommet seal) on the cable and over the crimped shield crimp sleeve. Insert the contact/ cable assembly into proper rear grommet hole. Contact must be aligned with hole and not inserted at an angle. Push forward until contact and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

See table on reverse side for coaxial cable recommended, crimping tool and positioner information.

- A 1. Rubber end first, slide piggyback grommet seal back over cable jacket, before stripping the cable.
- 2. Strip cable jacket to expose cable outer braid as illustrated. Ends must be cut cleanly and at right angles to the axial plane of the cable. Cable must not be deformed while making cuts. Hot wire stripping is recommended.
- B 1. Slide crimp bushing, large diameter end first, over cable braid until cable jacket butts inside shoulder of crimp bushing.
- C 1. Flair cable braid back over crimp bushing as illustrated to expose cable dielectric. Trim excess cable braid.
- 2. Cut away any inner braids and/or wraps as close to outer cable braid as possible.
- 3. Cut cable dielectric to dimension shown.
- D 1. Strip cable dielectric to expose center conductor as illustrated.
- E 1. Slide rear insulator, large diameter end first, over cable center conductor and dielectric until it butts the cable braid as shown.
- 2. Assemble the inner contact over the center conductor until it butts the rear insulator, as shown (trim the cable center conductor if necessary).
- 3. Remove the inner contact & tin the cable center conductor using a 47.5 watt soldering iron (inner contact wire well may also be tinned). Solder the center conductor into the inner contact wire well. A pin vice can be used to hold the inner contact.
- F 1. Slide the front insulator over the inner contact until the inner contact shoulder butts the inside shoulder of the front insulator. A small gap between the front insulator and rear insulator is permissible.
- G 1. Carefully slide the outer contact over the inner contact assembly until the inner assembly is fully seated inside the outer contact.
- 2. Crimp the outer contact body & crimp bushing in the area indicated using crimp tool listed in table on back.



PART NO.	COAXIAL CABLE ACCOMMODATED	BASIC CRIMPING TOOL	M22520/5-01	M22520/5-45	A	MIL-1-81969/14-12	DANIELS DRK-264-8 or AMPHENOL 11-9170
						21-033591-081	
TOOLS		SHIELD CRIMP SLEEVE	DIE	DIE	DIE CLOSURE	TOOL P/N	CONTACT REMOVAL TOOL

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 Amphenol removal tool part number 1-9170 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.