

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

*See table on reverse side for coaxial cable recommendation, stripping dimensions, tool selector settings, crimping tool and positioner information.

Installation Instructions

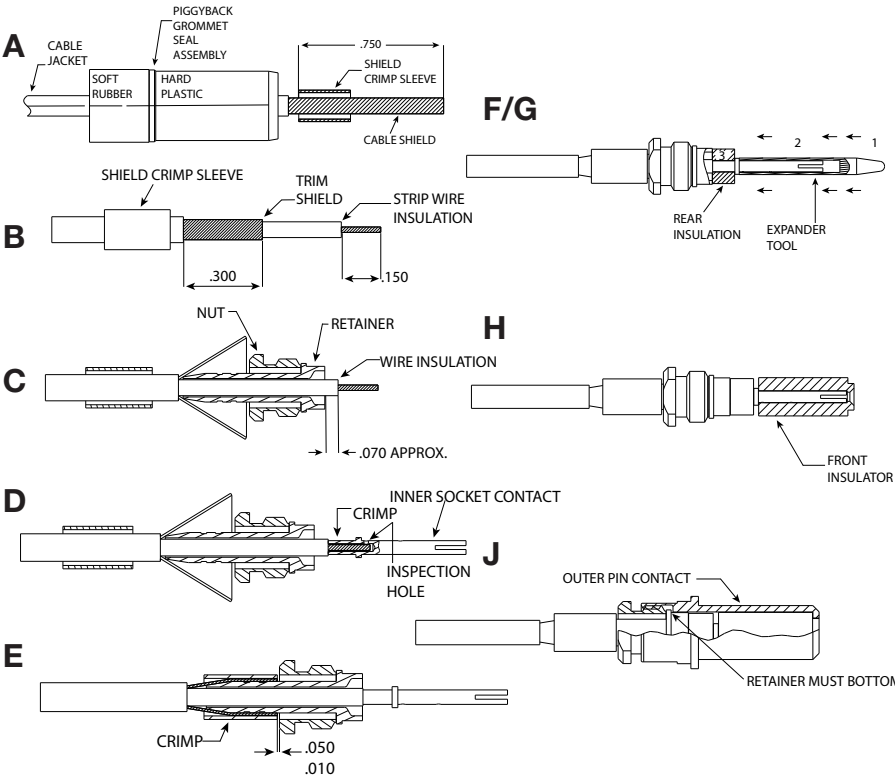
- A 1. The contact incorporates a piggyback grommet seal. Assemble the piggyback grommet seal over the cable jacket, rubber end first, before stripping cable.
2. Strip cable as illustrated. Ends must be cut cleanly and at right angles to the axial plane of the cable. The cable must not be deformed while making cuts. Hot wire stripping is recommended.
- B 1. Slide shield crimp sleeve over cable jacket.
2. Trim shield and strip wire insulation to indicated dimensions
- C 1. Position nut on retainer as illustrated.
2. Slightly flare shield and slide nut and retainer assembly under the cable shield until retain bottoms against braid. (Approximately .070 of the wire insulation should be exposed.)

FOR CRIMP TERMINATION OF THE CENTER CONTACT

- D 1. Slide inner socket contact over cable center conductor. Cable center conductor must be visible through the inspection hole in the inner socket contact wire well.
2. Crimp inner socket contact using crimp tool and positioner listed in table on back.
- E 1. Slide nut and retainer assembly forward until retainer is flush with edge of wire insulation.
2. Bring shield crimp sleeve forward over cable shield to maintain indicated gap.
- F 1. Slide rear insulator on Expander Tool (Amphenol P/N 11-10136, or locally fabricated equivalent).
2. Slide tool over inner socket contact. Push rear insulator with push rod (Amphenol P/N 11-10135, or locally fabricated equivalent), until it seats between retainer end and inner socket contact shoulder.
3. Remove push rod expander and proceed to step H

FOR SOLDER TERMINATION OF THE CENTER CONTACT

- G 1. Crimp shield crimp sleeve per steps E1 E2 and E3.
2. Install rear insulator on back of inner socket contact. Trim fit contact and insulator assembly to center conductor. Trim center conductor to allow rear insulator to butt against the retainer when inner socket contact is installed.
- Tin center conductor, and using a 47.5 watt soldering iron, solder the center conductor into the inner socket contact wire well. A pin vise can be used to hold the inner contact.
- H 1. Slide front insulator, large end first, over the inner socket contact until insulator seats against the inner socket contact shoulder.
- J 1. Slide outer pin contact over inner socket assembly and insulator, then thread nut into rear of outer pin contact .
2. Tighten nut until metal to metal bottoming is achieved between retainer shoulder and outer pin 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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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.

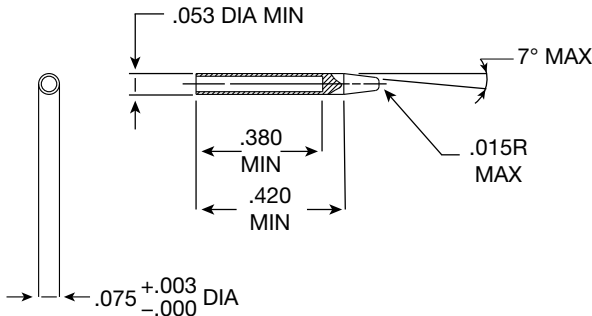
CONTACT REMOVAL FROM THE CONNECTOR

Remove the wire sealing member from the grommet (piggyback grommet seal). Position Amphenol removal tool, part number 11-646404-011 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.

PART NO.	COAXIAL CABLE ACCOMODATED	TOOLS						
		INNER CONTACT*				SHIELD CRIMP SLEEVE		
		X STRIPPING DIMENSION (INCH)	TOOL SELECTOR SETTING NO.	BASIC CRIMPING TOOL	POSITIONER	BASIC CRIMPING TOOL	DIE	DIE CLOSURE
21-033102-049	M17/113-RG316	.750	5	M22520/2-01	M22520/2-31	M22520/5-01	M22520/5-08	A
	M17/094-RG179	.750	3			M22520/10-01	M22520/10-05	A

*Solder Termination Optional

Expander Tool



Push Rod

