21-033832-251 (PLUG)

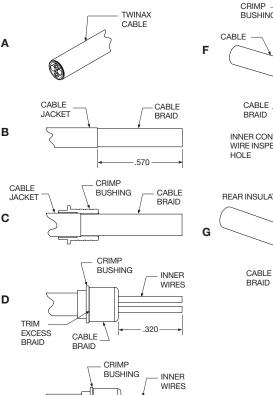
Transition Adapter, Plug, Differential Twinax Type High Speed, to Board, Installation Instructions

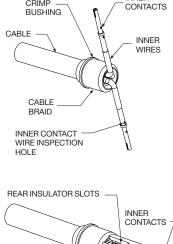
See table on reverse side for twinax cable recommended, tool selector settings, crimping tool, positioner and insertion/removal tool information.

- A 1. Cut cable for assembly of transition adapter plug.
- B 1. 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.
- C 1. Slide crimp bushing, large diameter end first, over cable braid until cable jacket butts inside shoulder of crimp bushing.
- D 1. Flair cable braid back over crimp bushing as illustrated to expose inner wires. Trim excess cable braid.
 - 2. Cut off any inner braids, wraps or cable fillers as close to outer cable braid as possible.
 - Cut inner wires to dimension shown. All wires must be cut to equal length. It may be helpful to cut one wire to length. Then cut remaining wire to equal length as the first wire.
- E 1. Strip inner wires to expose center conductors as illustrated. All wires must be stripped to equal length.
- F 1. Carefully splay inner wires perpendicular to the axis of the cable as illustrated.
- Assemble inner contact over cable center conductor until fully seated against inner wire insulation. Observe center conductor through the contact's wire inspection hole, to make certain conductor is properly positioned.
- 3. Crimp inner contact to center conductor using crimp tools listed in table on back. Repeat steps F2 and F3 until all inner contacts are crimped.
- G 1. Position rear insulator with 4 slots against cable braid as illustrated. Make certain that 2 non-adjacent insulator slots are aligned with splayed inner contact wires. One-by-one, position wired inner contacts inside the insulator slots as shown. The inner contact's retention shoulder must be positioned in front of the insulator's front surface as illustrated. Two of the rear insulator slots will not be used.

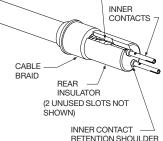
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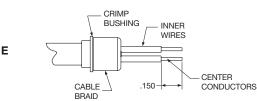
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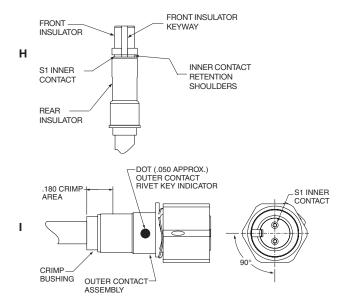
INNER





21-033832-251 (PLUG)

- H 1. With inner contacts positioned inside rear insulator slots, assemble front insulator over the inner contacts as shown. The front insulator must butt the inner contact retention shoulders.
- Observe the front insulator's keyway. When the inner assembly is held in the vertical position (with inner socket contacts on top), the inner socket contact with the insulator keyway to its right will be positioned at the S1 inner contact position shown in View I.
- Align front insulator keyway with the outer contact's rivet key indicator. Slide the inner contact assembly inside the outer contact assembly until fully seated. Observe the mating end of the assembly to make certain contacts are aligned as shown (Ref 90 degrees).
 - 2. Crimp outer contact body in the area indicated using crimp tools listed in table below.



Amphonal Dart	nphenol Part Description	Twinax Cable Recommended	Inner Crimp Tools		Outer Crimp Tools	
			Tool (Setting)	Positioner	ΤοοΙ	Die Set (Location)
21-033832-251	Differential Twinax Transition Adapter Plug	W.L. Gore GSC-05-82559-00 (100 Ohm)	M22520/2-01 (5)	M22520/2-37 Daniels K709	M22520/5-01	M22520/5-45 (A)

Amphenol

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

21-033832-251 (PLUG)

21-033832-251 (PLUG)

- insulator over the inner contacts as shown. The front insulator must butt H 1. With inner contacts positioned inside rear insulator slots, assemble front
- the vertical position (with inner socket contacts on top), the inner socket Observe the front insulator's keyway. When the inner assembly is held in .2 the inner contact retention shoulders.
- 'L I
- Crimp outer contact body in the area indicated using crimp tools listed .2 contacts are aligned as shown (Ref 90 degrees).
- ROTAJUZNI HAAH inner contact position shown in View I. contact with the insulator keyway to its right will be positioned at the S1 CONTACT 81 INNEB
- fully seated. Observe the mating end of the assembly to make certain Slide the inner contact assembly inside the outer contact assembly until Align front insulator keyway with the outer contact's rivet key indicator.
- In table below.

(mdO 00f) (A) Daniels K709 (<u>c</u>) Transition Adapter Plug M225220/5-01 GSC-05-82559-00 21-033832-251 Differential Twinax M225220/5-45 M225220/2-37 M225220/2-01 W.L. Gore (Location) (Setting) Positioner looT Recommended тэатии J92 9iQ looT Description 9lds**D** xsniwT The Ionendera Outer Crimp Tools Inner Crimp Tools

IonendmA

INNER

INNER

CONTACTS

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CONTACTS

INNER

WIRES

CRIMP

CABLE

F

CABLE

BRAID

WIRES

.150

CABLE

BRAID

CENTER

CONDUCTORS

BUSHING

CABLE

BRAID

HOLE

INNER CONTACT

WIRE INSPECTION

REAR INSULATOR SLOTS

CABLE

BRAID

REAR

SHOWN)

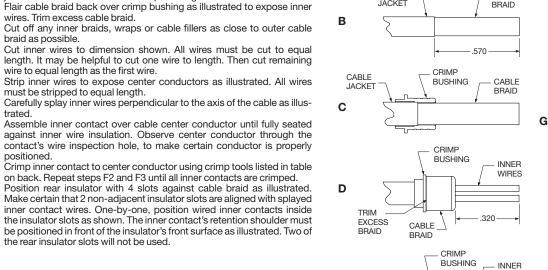
INSULATOR

(2 UNUSED SLOTS NOT

INNER CONTACT

RETENTION SHOULDER

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



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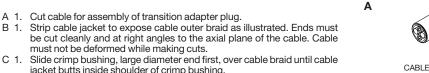
JACKET

TWINAX

CABLE

- F 1. trated. 2. Assemble inner contact over cable center conductor until fully seated against inner wire insulation. Observe center conductor through the contact's wire inspection hole, to make certain conductor is properly

 - positioned.
 - 3 Crimp inner contact to center conductor using crimp tools listed in table
 - on back. Repeat steps F2 and F3 until all inner contacts are crimped.



FSCM77820

VSSEMBLY OUTER CONTACT

RIVEL KEY INDICATOR **DUTER CONTACT**

KEYWAY

ЗНОИГDERS

RETENTION

RONTAJUSNI TNORF

INNER CONTACT

(.XOH44A 060.) 100

BUSHING GRIMP

A3HP

- AMIRO 081

ROTAJUZNI

FRONT

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Ε

B 1. be cut cleanly and at right angles to the axial plane of the cable. Cable must not be deformed while making cuts. C 1. Slide crimp bushing, large diameter end first, over cable braid until cable jacket butts inside shoulder of crimp bushing.

See table on reverse side for twinax cable recommended, tool selector settings, crimping tool, positioner and insertion/removal tool information.

wires. Trim excess cable braid.

wire to equal length as the first wire.

the rear insulator slots will not be used.

CONTACT

S1 INNER

must be stripped to equal length.

braid as possible.

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D 1.

2.

3.

E 1.

G 1.

L-2119-FT

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