

# Typical Contact Installation Instructions for Coax Contacts

The following is an example of a contact instruction sheet that would be shipped within the package of contacts for a Crimp, Size 12 Coax Contact for use in Subminiature, D38999 connectors. The sheet provides detailed instructions for assembling the component parts and for crimping the contact to coaxial cable, along with the recommended cable and tooling to be used. Installation instructions are included within all contacts for D38999 connectors. For installation instructions for other connector series, there are separate documents (not included in packaging of parts) as follows: L-633 for Miniature solder types, L-613 for Miniature SE types, L-660 for Miniature CE types, and L-650 for MS/Standard and Heavy Duty types. For any other instructions needed, consult Amphenol. Most installation instructions can be found on-line at [www.amphenol-aerospace.com](http://www.amphenol-aerospace.com) (from home page, go to Service Instructions and enter contact part number or instruction sheet number).

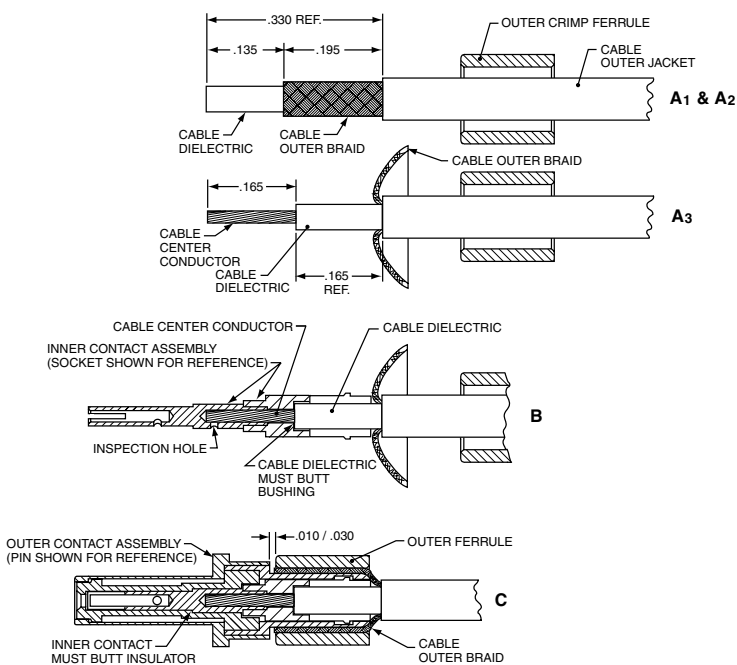
**21-033651-011 (PIN)**  
**21-033650-011 (SOCKET)**

Contact, Pin and Socket, Coaxial,  
Type LJT-R & TV-R, (MIL-DTL-38999 Series I & III) Crimp,  
Size 12  
Installation Instructions

See table on reverse side for coaxial cable recommended and crimp tool information.

- A. 1. Slide outer crimp ferrule over cable outer jacket as shown.
2. Strip cable outer braid 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.
3. Flare outer braid, then strip cable dielectric as shown.
- B. 1. Assemble inner contact assembly over cable center conductor and cable dielectric until inside bore of bushing butts against cable dielectric.
2. Cable center conductor must be visible through the inspection hole in the inner contact wire well.
3. Crimp inner contact wire well using crimp tool listed in table.
- C. 1. Carefully slide outer contact assembly over inner contact assembly and under cable outer braid until inner contact butts against insulator shoulder as illustrated. (Inner contact assembly will snap into the locked position when fully assembled inside the outer contact assembly.)
2. Bring outer crimp ferrule forward over cable outer braid as illustrated. (Continue to push the inner contact assembly fully forward while bringing the outer crimp ferrule into position.)
3. Crimp outer crimp ferrule using crimp tool listed in table (.156 Max. over ferrule after crimping). Trim excess braid ahead of crimp ferrule, if necessary.

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**CONTACT INSERTION INTO CONNECTOR**

Using insertion tool (part number M81969/8-09 or M81969/14-04), insert contact assembly into rear connector grommet hole. Contact must be aligned with hole and not inserted at an angle. Push forward until contact is felt to snap into position within insert. Remove tool.

**CONTACT REMOVAL FROM CONNECTOR**

Position removal tool (part number M81969/8-10 or M81969/14-04) around cable and slide tool down wire until tool tips enter rear grommet and come to a positive stop. Hold tool tip firmly against positive stop on contact, grip wire and simultaneously remove tool, contact and cable.

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Amphenol <sup>®</sup> Part Number	Description	Coaxial Cable Accommodated	Tools				
			Inner Contact			Outer Contact	
			Crimp Tool	Setting	Positioner (Daniels)	Tool	Positioner
21-033651-011	Matched Impedance* Size 12 Coax Pin	RG316 (M17/113-RG316)	MH992 (Daniels)	5	K1360	M22520/5-01	M22520/5-03 (A) or M22520/5-35 (B)
		RG179 (M17/094-RG179)	MH992 (Daniels)	4	K1360		
21-033650-011	Matched Impedance* Size 12 Coax Socket	RG316 (M17/113-RG316)	MH992 (Daniels)	5	K1360		
		RG179 (M17/094-RG179)	MH992 (Daniels)	4	K1360		

\* Matched Impedance applies when contacts are terminated to RG316 cable only.

38999

- III
- HD
- Dualok
- II
- I
- SJT
- Accessories
- Aquacon
- Herm/Seal
- PCB

**HIGH SPEED**  
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Connectors  
Cables

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Matrix | Pyle

26500  
Pyle

5015  
Crimp Rear  
Release  
Matrix

22992  
Class 1

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Shells

Options  
Others