

SHIELDED COAXIAL CONTACT

TYPICAL COAXIAL CONTACT INSTALLATION INSTRUCTIONS

Contact, Pin and Socket, Coaxial,
Type LJ-T-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.

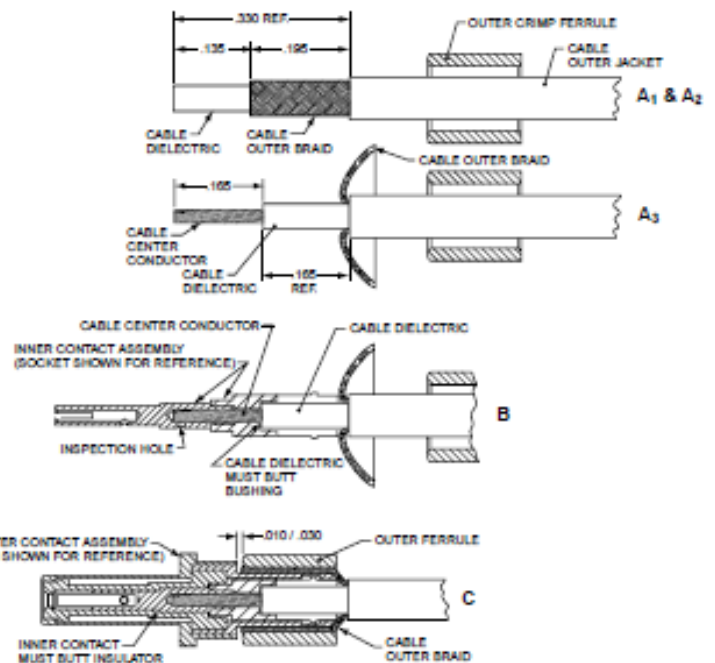
- A. 1. Slide outer crimp ferrule over cable outer jacket as shown.
2. Strip cable outer braid as illustrated. Ends must be cut cleanly and at right angles to the axial plane of the cable. The cable must not be deformed while making cuts.
3. Flare outer braid, then strip cable dielectric as shown.
- 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.

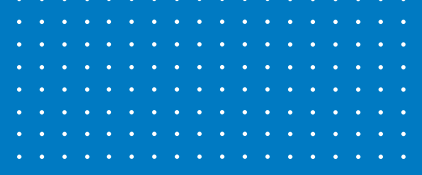
CONTACT INSERTION INTO CONNECTOR

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.

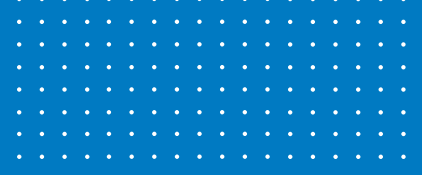




QUADRAX CONTACTS FOR SUBMINIATURE

TYPICAL CONTACTS INSTALLATION INSTRUCTIONS FOR QUADRAX CONTACTS

Picture	Process	Check	Tools
	<p>Strip the jacket</p> <p>Slide the piggy back grommet and crimping ferule</p>	<p>Do not damage the braid</p>	<p>Blade</p>
	<p>Open the braid over the crimping ferule</p>	<p>The braid shall cover equally the crimping ferule</p>	<p>Blade (To Trim Excess Braid)</p>
	<p>Strip the inner conductors</p>	<p>Do not damage the inner conductors</p>	<p>Blade</p>
	<p>Crimp the inner contacts</p>	<p>The inner conductor shall be visible thru the inspection hole</p>	<p>M22520/2-01 with positionner M22520/2-37</p>
	<p>Install the rear insulator and respect the circular location for each individual contact</p>	<p>The contact location shall respect circular location</p>	
	<p>Slide the front insulator over the contact by the front</p>	<p>The keyway orientation shall meet the key way in outer contact</p>	
	<p>Crimp the outer contact</p>		<p>M22520/5-01 with M22520/5-45(A)</p>



TYPICAL CONTACTS INSTALLATION INSTRUCTIONS FOR TWINAX CONTACTS

PICTURE	PROCESS	CHECK	TOOLS
	<p>Strip the jacket</p> <p>Slide the piggy back grommet and crimping ferule</p>	<p>Do not damage the braid</p>	<p>Blade</p>
	<p>Open the braid over the crimping ferule</p>	<p>The braid shall cover equally the crimping ferule</p>	
	<p>Strip the inner conductors</p>	<p>Do not damage the inner conductors</p>	<p>Blade</p>
	<p>Insert the white jacket inner conductor into the inner contact and crimp</p>	<p>The inner conductor shall be visible thru the inspection hole</p>	<p>M22520/2-01 with positionner</p>
	<p>Insert the crimp inner contact into the center hole and insert the blue inner conductor in the intermediate contact crimp the intermediate contact</p>	<p>The inner conductor shall be visible thru the inspection hole</p>	<p>M22520/5-01 with correct die</p>
	<p>Push the sub assembly into the outer contact when nice installed, cut the additional braid</p>	<p>Do not damage the crimping ferule</p>	<p>Blade</p>
	<p>Crimp the outer contact</p>		<p>M22520/5-01 with correct die</p>