



DEUTSCH ECD

ENGINEERED CONNECTING DEVICES

DATA BUS CONTACTS MIL-C-39029/90 & MIL-C-39029/91 TYPE

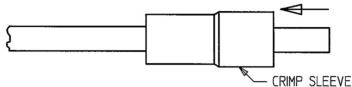
DEUTSCH PART NUMBERS 6162-315-0877 & 6162-316-0877

TERMINATION INSTRUCTIONS

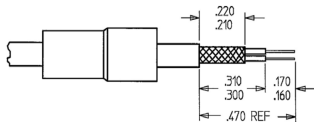
STEP 1. INSPECT CONTAINER FOR THE FOLLOWING PARTS:

ITEM	QTY	DESCRIPTION
1	2	CTS-S22/22 SOCKET CONTACT
2	1	SUPPORT SLEEVE
3	1	CRIMP SLEEVE
4	1	CONTACT BODY

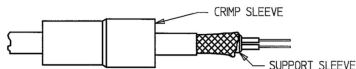
STEP 2. SLIDE CRIMP SLEEVE, THREADED END LAST, OVER CABLE TO BE TERMINATED, AT LEAST 6 TO 10 INCHES.



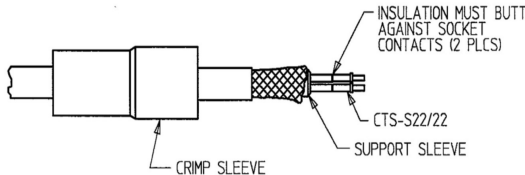
STEP 3. STRIP CABLE TO DIMENSIONS SHOWN, AFTER FOLDING OUTER SHIELD OVER OUTER JACKET, CUT OFF AND REMOVE TAPE LAYER. REFOLD OUTER SHIELD BACK OVER INNER SHIELD, MAKING ONE THICK SHIELD.



STEP 4. INSTALL SUPPORT SLEEVE OVER INNER CONDUCTORS AND UNDER BOTH INNER AND OUTER SHIELDINGS. TRIM ANY EXCESS SHIELDINGS STRANDS EXTENDING BEYOND SLEEVE.



STEP 5. INSTALL AND CRIMP EACH CTS-S22/22 SOCKET CONTACT TO EACH OF THE TWO STRIPPED WIRES WITH M22520/7-01 CRIMP TOOL AND M22520/7-11 POSITIONER. USE APPROPRIATE SETTING FOR WIRE AWG.



STEP 6. PLUG BOTH CTS-S22/22 CONTACTS SIMULTANEOUSLY INTO THE CONTACT BODY, MAKING CERTAIN THEY ARE BOTH LOCKED INTERNALLY BY THE DIELECTRIC RETENTION SYSTEM. (STANDARD MIL-I-81969/14-01 INSERTION/EXTRACTION TOOL OR EQUIVALENT MAY BE USED FOR EXTRACTION. INSERTION CAN BE DONE BY HAND.)

STEP 7. SLIDE THE CRIMP SLEEVE UP AND THREAD FULLY ONTO CONTACT BODY. CRIMP THE SMALLER DIAMETER OF THE SLEEVE WITH A M22520/5-01 CRIMP TOOL AND A M22520/5-200 (DANIELS Y631) HEX SET, CAVITY A.

STEP 8. CRIMP THE LARGER DIAMETER OF THE CRIMP SLEEVE USING A M22520/5-01 CRIMP TOOL AND M22520/5-15 (DANIELS Y207) HEX DIE SET, CAVITY A, TO LOCK THE THREADS. CONTACT IS NOW READY TO USE.