



# DEUTSCH ECD

## ENGINEERED CONNECTING DEVICES

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

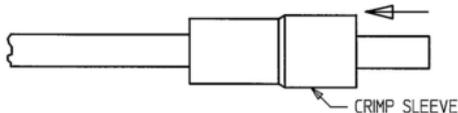
DEUTSCH PART NUMBERS 6162-315-0877 & 6162-316-0877

### TERMINATION INSTRUCTIONS

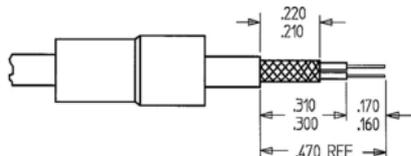
**STEP 1.** INSPECT CONTAINER FOR THE FOLLOWING PARTS:

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

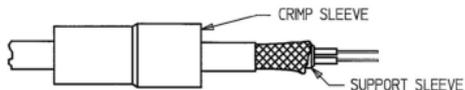
**STEP 2.** SLIDE CRIMP SLEEVE, THREADED END LAST, OVER CABLE TO BE TERMINATED, AT LEAST 6 TO 10 INCHES.



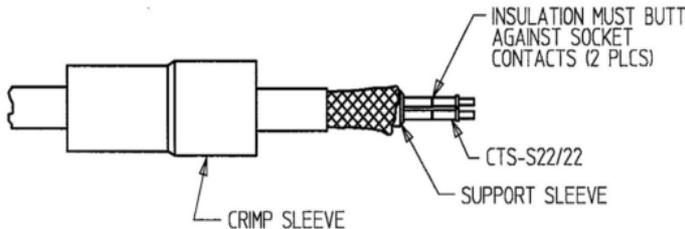
**STEP 3.** STRIP CABLE TO DIMENSIONS SHOWN, AFTER FOLDING OUTER SHIELD OVER OUTER JACKET, CUT OFF AND REMOVE TAPE LAYER. REFOLD OUTER SHIELD BACK OVER INNER SHIELD, MAKING ONE THICK SHIELD.



**STEP 4.** INSTALL SUPPORT SLEEVE OVER INNER CONDUCTORS AND UNDER BOTH INNER AND OUTER SHIELDINGS 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.