



DEUTSCH ECD

ENGINEERED CONNECTING DEVICES

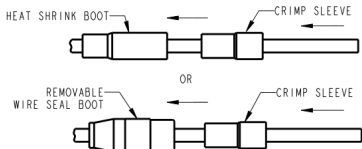
DATA BUS CONTACTS MIL-C-39029/90 & MIL-C-39029/91 TYPE

DEUTSCH PART NUMBERS 6162-283-0877 & 6162-284-0877

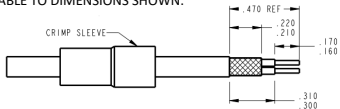
STEP 1. INSPECT CONTAINER FOR THE FOLLOWING PARTS:

ITEM	QTY	DESCRIPTION
1	2	CTS-S22/22 SOCKET CONTACT
2	1	SUPPORT SLEEVE
3	1	CRIMP SLEEVE
4	1	CONTACT BODY
5	1	HEAT SHRINK BOOT

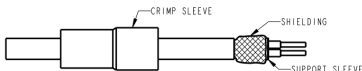
STEP 2. INSTALL HEAT SHRINK BOOT (SUPPLIED WITH CONTACT) OR REMOVABLE BOOT (SUPPLIED WITH CONNECTOR) ,SMALL END FIRST, OVER CABLE TO BE TERMINATED. INSTALL CRIMP SLEEVE, THREADED END LAST. MOVE BOTH PIECES BACK OUT OF THE WAY 6 TO 10 INCHES.



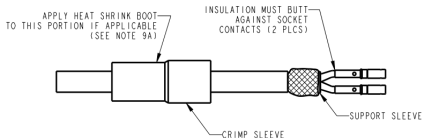
STEP 3. STRIP CABLE TO DIMENSIONS SHOWN.



STEP 4. INSTALL SUPPORT SLEEVE OVER INNER CONDUCTORS AND UNDER BOTH 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. BEND WIRES AWAY FROM EACH OTHER FOR EASE OF CRIMPING.



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 M22520/5-105 (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.

STEP 9A. SLIDE HEAT SHRINK BOOT OVER SMALLER DIAMETER OF THE CRIMPED PORTION OF CONTACT AND APPLY HEAT TO SHRINK BOOT ONTO CONTACT AND CABLE.

STEP 9B. AFTER THE ASSEMBLED CONTACT HAS BEEN INSTALLED INTO THE CONNECTOR, MOVE THE REMOVABLE WIRE SEAL BOOT FORWARD INTO THE GROMMET UNTIL FIRMLY SEATED.