



DEUTSCH ECD

ENGINEERED CONNECTING DEVICES

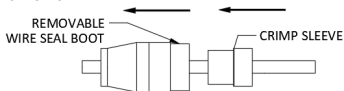
DATA BUS CONTACTS MIL-C-39029/90 & MIL-C-39029/91 TYPE

DEUTSCH PART NUMBERS 6162-289-0877 & 6162-290-0877

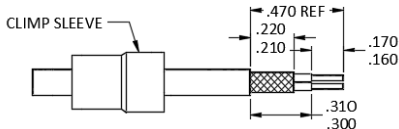
STEP 1. INSPECT CONTAINER FOR THE FOLLOWING PARTS:

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

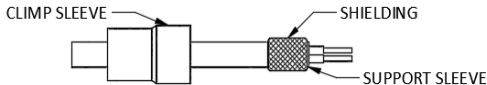
STEP 2. INSTALL WIRE SEALING BOOT, SMALL END FIRST, OVER CABLE TO BE TERMINATED, INSTALL CRIMP SLEEVE, THREADED END LAST. MOVE BOTH PIECES BACK OUT OF THE WAY 6 TO 10 INCHES.



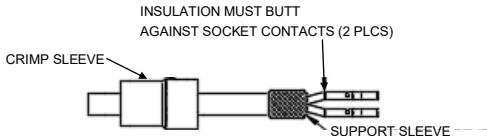
STEP 3. STRIP CABLE TO DIMENSIONS SHOWN, AFTER FOLDING OUTER SHIELD OVER OUTER JACKET, CUT OFF AND REMOVE TAPE LAYER. REFOLD OUTER SHIELD BACK OVER INNER SHIELD, MAKING ONE THICK SHIELD.



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. 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 M22520/5-200 (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.

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