

# DEUTSCH ECD

SIZE 16 SHIELDED LONG SOCKET CONTACT MIL-C-39029/77 TYPE  
DEUTSCH PART NUMBER 6162-213-1677 THRU 6162-216-1677

## TERMINATION INSTRUCTIONS

CUT CABLE TO DESIRED LENGTH, CUTTING THE CABLE CLEANLY AND SQUARELY.

SLIDE SHIELD CRIMP SLEEVE OVER CABLE END. (NOTE: IF SHIELD CRIMP SLEEVE WILL NOT SLIDE BACK OVER CABLE INSULATION, INCREASE STRIP LENGTH TO  $.740 \pm .010$ .)

STRIP WIRE TO DIMENSIONS SHOWN, MAKING SURE THE CUTS ARE CLEAN AND SQUARE. HOT WIRE STRIPPING IS RECOMMENDED.

SLIDE REAR INSULATOR OVER INNER CONDUCTOR, LARGE DIAMETER FIRST. SLIDE INNER CONTACT, CRIMP BARREL OVER THE END OF THE INNER CONDUCTOR. CHECK TO SEE IF THE WIRE CAN BE SEEN THROUGH THE INSPECTION HOLE AND THAT THE INNER CONDUCTOR INSULATION IS BUTTED SQUARELY AGAINST THE REAR INSULATOR; AND THE REAR INSULATOR IS BUTTED SQUARELY AGAINST THE CRIMP BARREL. CRIMP INNER CONTACT USING A BASIC M22520/2-01 CRIMPING TOOL WITH M22520/2-35 POSITIONER.

SLIDE THE INSULATOR OVER THE INNER CONTACT UNTIL IT IS BOTTOMED.

WHILE FOLDING THE SHIELD BACK, BE CAREFUL TO RETAIN AS MUCH OF THE BRAID AS POSSIBLE.

SLIDE OUTER SOCKET CONTACT OVER INSULATOR UNTIL IT IS BOTTOMED. (NOTE: DIMENSIONS GIVEN IN FIGURE). FOLD SHIELD BACK OVER OUTER SOCKET CONTACT AND POSITION THE SHIELD CRIMP SLEEVE OVER THE SHIELD APPROXIMATELY MIDWAY ALONG OUTER SOCKET CONTACT CRIMP BARREL KEEPING THE CONTACTS SEATED PROPERLY. CRIMP THE SLEEVE USING A BASIC M22520/4-01 CRIMPING TOOL AND M22520/4-02 POSITIONER. ROTATE TOOL  $45^\circ$  AND CRIMP A SECOND TIME.

