

DEUTSCH

ENGINEERED CONNECTING DEVICES

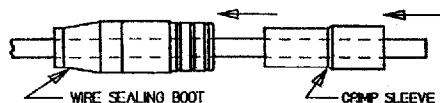
DATA BUS CONTACTS MIL-C-39029/90 & MIL-C-39029/91 TYPE

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

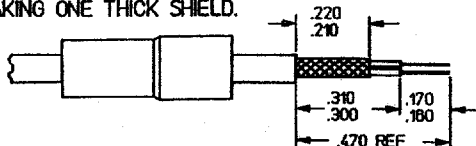
1. INSPECT CONTAINER FOR THE FOLLOWING PARTS:

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

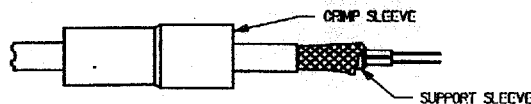
2. INSTALL WIRE SEALING BOOT, SMALL END FIRST, OVER CABLE TO BE TERMINATED. INSTALL CRIMP SLEEVE, THREADED END LAST. MOVE BOTH PIECES BACK OUT OF THE WAY 6 TO 10 INCHES.



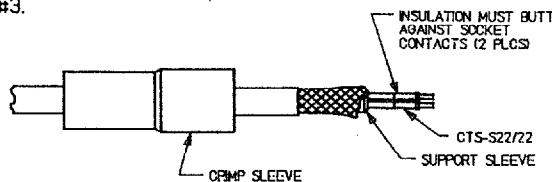
3. STRIP CABLE TO DIMENSIONS SHOWN. AFTER FOLDING OUT SHIELD OVER OUTER JACKET, CUT OFF AND REMOVE TAPE LAYER. REFOLD OUTER SHIELD BACK OVER INNER SHIELD, MAKING ONE THICK SHIELD.



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



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 ON SETTING #3.



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.)
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 M22520/5-20C HEX DIE SET, CAVITY A.
8. CRIMP THE LARGER DIAMETER OF THE CRIMP SLEEVE USING A M22520/5-01 CRIMP TOOL AND M22520/5-15 HEX DIE SET, CAVITY A, TO LOCK THE THREADS. CONTACT IS NOW READY TO USE.
9. THE WIRE SEALING BOOT MUST BE MOVED FORWARD INTO THE GROMMET AFTER THE ASSEMBLED CONTACT HAS BEEN INSTALLED INTO THE CONNECTOR.

FORM 997