

# DEUTSCH ECD

ENGINEERED CONNECTING DEVICES

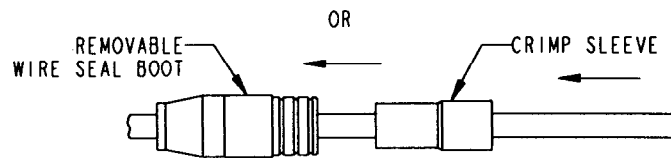
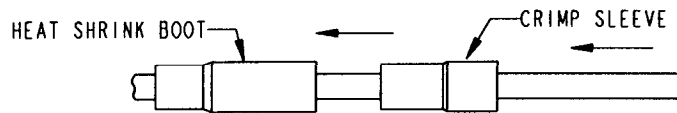
DATA BUS CONTACTS MIL-C-39029/90 & MIL-C-39029/91 TYPE

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

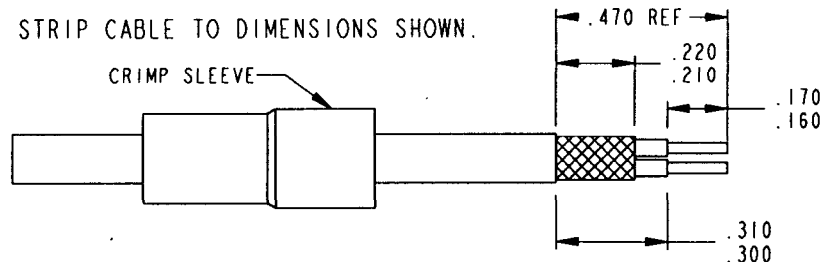
1. INSPECT CONTAINER FOR THE FOLLOWING PARTS:

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

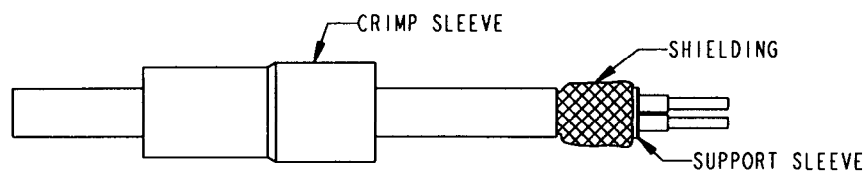
2. INSTALL HEAT SHRINK BOOT (SUPPLIED WITH CONTACT) OR REMOVABLE BOOT (SUPPLIED WITH CONNECTOR), SMALL END FIRST, OVER CABLE TO BE TERMINATED. INSTALL CRIMP SLEEVE, THREADED END LAST. MOVE BOTH PIECES BACK OUT OF THE WAY 6 TO 10 INCHES.



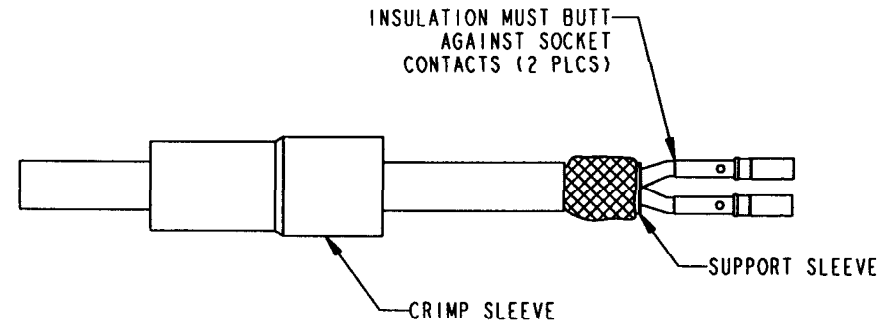
3. STRIP CABLE TO DIMENSIONS SHOWN.



4. INSTALL SUPPORT SLEEVE OVER INNER CONDUCTORS AND UNDER SHIELDING. TRIM ANY EXCESS SHIELDING STRANDS EXTENDING BEYOND SLEEVE.



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.



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-1-81969/14-01 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 A M22520/5-200 (DANIELS Y631) 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 (DANIELS Y207) HEX DIE SET, CAVITY A, TO LOCK THE THREADS. CONTACT IS NOW READY TO USE.

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

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

