

DEUTSCH ECD

SIZE 16 SHIELDED PIN CONTACT MIL-C-39029/76 TYPE
DEUTSCH PART NUMBER 6162-229-1677 THRU 6162-232-1677

TERMINATION INSTRUCTIONS

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

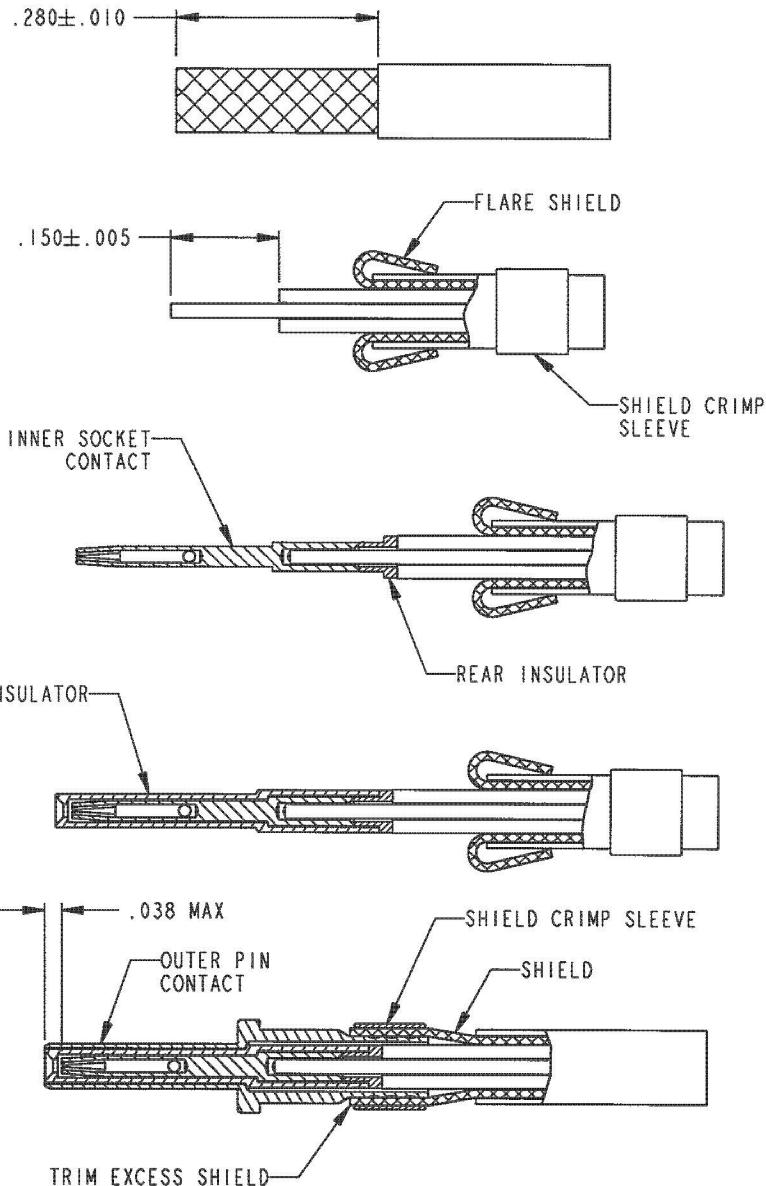
SLIDE SHIELD CRIMP SLEEVE OVER CABLE END. (NOTE:
IF SHIELD CRIMP SLEEVE WILL NOT SLIDE BACK OVER
CABLE INSULATION. INCREASE STRIP LENGTH TO $.400 \pm .010$).

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.

SLIDE OUTER PIN CONTACT OVER INSULATOR UNTIL IT IS
BOTTOMED. (NOTE: DIMENSIONS GIVEN IN FIGURE). COMB
SHIELD BACK OVER OUTER PIN CONTACT AND POSITION
THE SHIELD CRIMP SLEEVE OVER THE SHIELD APPROXIMATELY
MIDWAY ALONG OUTER PIN 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° AND
CRIMP A SECOND TIME.



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