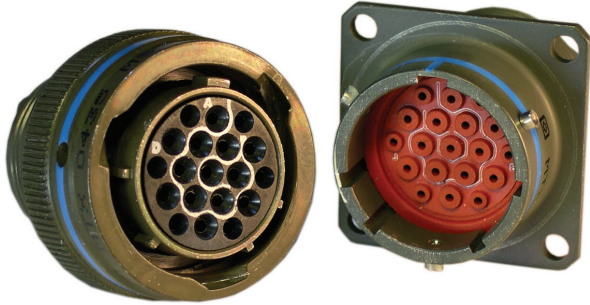


TE Connectivity DEUTSCH AFD Series MIL-DTL-26482 Series II Connectors



INTERMATEABLE WITH SOURIAU CONNECTORS AND ALL MIL-DTL-26482 SERIES II

TE DEUTSCH AFD series MIL-DTL-26482 series II connectors have a quick-mating, three-point bayonet coupling system. TE DEUTSCH AFD series connectors are designed for harsh environments and are excellent aerospace connectors. These TE DEUTSCH connectors are mil spec to MIL-26482 and have a high-quality contact retention system. The AFD series is intermateable with Souriau connectors and all MIL-DTL-26482 series II connectors. For full product details on the TE DEUTSCH AFD Series MIL-DTL-26482 series II connectors, please see the specifications below.

APPLICATIONS

- High-performance military aircraft
- Commercial aircraft
- Communications equipment
- Armored personnel carriers & tanks
- High temperature industrial equipment

FEATURES

- High-reliability
- Outstanding EMI-shielding protection
- Operates at extreme temperatures
- High-density connectors
- Broad range of military and commercial accessories
- MIL-DTL-26482 qualified

MATERIALS AND FINISHES

Shell	Aluminium alloy
Shell Plating	Electroless nickel and olive drab chromate over nickel
Contacts	Copper alloy
Contact Platings	50u" gold plated
Insulator	Rigid plastic dielectric
Seals	Silicone based elastomer

ELECTRICAL DATA

Operating Voltage/Test Voltage

SERVICE RATING	WORKING		TEST	
	SEA LEVEL VAC RMS	70000 FEET ALTITUDE VAC RMS	SEA LEVEL VAC RMS	70000 FEET ALTITUDE VAC RMS
I	600	300	1500	375
II	1000	450	2300	500

Current Rating

WIRE SIZE	CONTACT SIZE	MAX. CURRENT FOR TEST IN AMPS	POTENTIAL DROP MILLIVOLT AT 77F (25C)
24	20	3	<45
20	20	7.5	<55
20	16	7.5	<45
16	16	13	<50
14	12	17	<45
12	12	23	<50

MECHANICAL DATA

Wire Range Sizes	12-24AWG
Insulation Resistance	5000 Megaohms minimum at 77°F (25°C) 500 Megaohm minimum at 392°F (200°C) Class L and 347°F (175°C) Class W
Mating Life	500 cycle minimum, 250 cycle minimum for shielded plug
Salt Spray	Class L & W 48 hours unmated; 452 hours mated per MIL-STD-1344 method, 1001 per MIL-DTL-26482
Heat	Class L +392°F (200°C), Class W 347°F (175°C) for 1000 hours to MIL-STD-1344 method 1005.1
Chemical Resistance	Tested unmated according to MIL-DTL-26482 44.6.28 for hydraulic fluid, lubricating oil, deicing fluids, jet fuels, solvents and coolants
Vibration	10 to 2000Hz (20g's) 10 microseconds maximum discontinuity. To MIL-STD-1344 method 2005 per MIL-DTL-26482
Shock	150g's 6 microseconds duration, three major axes. 10 microsecond maximum discontinuity

MECHANICAL DATA (CONT.)

Contact Type	Crimp, coax, shielded, printed circuit board, thermocouple, and fiber optic
Number of Circuits	3 to 61
Polarization	Five keyway, three point bayonet with optional rotational polarization
Approvals/Agency Listing	MIL-DTL-26482

Wire Sealing Range

CONTACT SIZE	WIRE SEALING RANGE MIN. INCH (MM)	WIRE SEALING RANGE MAX. INCH (MM)
20	.040 (1.02)	.083 (2.11)
16	.053 (1.35)	.103 (2.62)
12	.097 (2.46)	.158 (4.01)

Contact Retention

CONTACT SIZE	RETENTION AXIAL LOAD LBS.	SEPARATION FORCE MINIMUM (INITIAL) OUNCES
20	.040 (1.02)	.083 (2.11)
16	.053 (1.35)	.103 (2.62)
12	.097 (2.46)	.158 (4.01)

All dimensions in inches (millimeters in parenthesis)

HOW TO ORDER 26482 SERIES CONNECTORS - MILITARY

1	2	3	4	5	6
MS3470	L	24-61	P	W	-LC
SHELL STYLE	FINISH	LAYOUT	CONTACT	POLARIZATION	MODIFIER

(Military part number example)

STEP 1: SELECT SHELL STYLE, PLUG OR RECEPTACLE



*Not available in Size 8

STEP 2: SELECT FINISH

L = Electroless Nickel

W = Olive Drab Chromate over Cadmium over Nickel 500 Hour Salt Spray

STEP 3: SELECT LAYOUT

⇒ See page 36 for listing by # of contacts

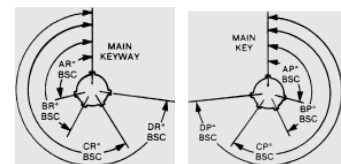
LAYOUT	SERVICE RATING	TOTAL	20	16	12	ROTATIONS			
						W	X	Y	Z
8-98	I	3	3			60	210		
8-33	I	3	3			90			
10-6	I	6	6			90			
12-3	II	3		3				180	
12-8	I	8	8			90	112	203	292
12-10	I	10	10			60	155	270	295
14-4	I	4			4				
14-5	II	5		5		40	92	184	273
14-12	I	12	8	4		43	90		
14-15	I	15	14	1		17	110	155	234
14-18	I	18	18			15	90	180	331
14-19	I	19	19			30	165	315	
16-8	II	8		8		54	152	180	331
16-26	I	26	26			60	105	275	338
18-8	I	8			8				
18-11	II	11		11		62	119	241	340
18-30	I	30	29	1		180	193	285	350
18-32	I	32	32			85	138	222	265
20-16	II	16		16		238	318	333	347
20-39	I	39	37	2		63	144	252	333
20-41	I	41	41			45	126	225	
22-12	I	12			12				
22-21	II	21		21		16	135	175	349
22-32	I	32	32			72	145	215	288
22-41	I	41	27	14		39	135	264	
22-55	I	55	55			30	142	226	314
24-19	II	19			19	30	165	315	
24-31	I	31		31		90	225		
24-61	I	61	61			90	180	270	324

STEP 4: SELECT CONTACT

- P** = Pin
- S** = Socket
- Note:** See Step 6 if you are not ordering contacts with part.
- A** = Less Pin Contacts
- B** = Less Socket Contact
- Note:** The "A" and "B" designators may be used when other than power contacts (PCB, Coax, Thermocouple, or Fiber Optic contacts)

STEP 5: SELECT POLARIZATION

(omit for normal)
W
X
Y
Z



Receptacle

Plug

STEP 6: SELECT MODIFIER

Omit for standard contacts
-LC = for use with standard contacts, but supplied without contacts, seal plugs or tools (PO must state Less Contacts)

Note: -LC is not marked on part

HOW TO ORDER 26482 SERIES CONNECTORS - COMMERCIAL

1	2	3	4	5	6
AFD50-	24-61	P	W	-6117	-LC
SHELL STYLE	LAYOUT	CONTACT	POLARIZATION	FINISH	MODIFIER

(Commercial part number example)

STEP 1: SELECT SHELL STYLE, PLUG OR RECEPTACLE



STEP 2: SELECT LAYOUT

⇒ See page 36 for listing by # of contacts

LAYOUT	SERVICE RATING	TOTAL	20	16	12	8 OR COAX	ROTATIONS			
							W	X	Y	Z
8-98	I	3	3				60	210		
8-33	I	3	3				90			
8-3A	I	3	3				60			
10-6	I	6	6				90			
12-3	II	3		3					180	
12-8	I	8	8				90	112	203	292
12-10	I	10	10				60	155	270	295
14-4	I	4			4					
14-5	II	5		5			40	92	184	273
14-12	I	12	8	4			43	90		
14-15	I	15	14	1			17	110	155	234
14-18	I	18	18				15	90	180	331
14-19	I	19	19				30	165	315	
16-8	II	8		8			54	152	180	331
16-26	I	26	26				60	105	275	338
18-8	I	8			8					
18-11	II	11		11			62	119	241	340
18-30	I	30	29	1			180	193	285	350
18-32	I	32	32				85	138	222	265
18-918		18	16			2				
20-16	II	16		16			238	318	333	347
20-39	I	39	37	2			63	144	252	333
20-41	I	41	41				45	126	225	
22-12	I	12			12					
22-21	II	21		21			16	135	175	349
22-32	I	32	32				72	145	215	288
22-41	I	41	27	14			39	135	264	
22-55	I	55	55				30	142	226	314
24-19	II	19			19		30	165	315	
24-31	I	31		31			90	225		
24-37	I	37		37			25	50	75	
24-53	I	53	51			2				
24-61	I	61	61				90	180	270	324
24-100		10				10	45	90	135	

STEP 3: SELECT CONTACT



P = Pin
S = Socket
Note: See Step 6 if you are not ordering contacts with part.
A = Less Pin Contacts
B = Less Socket Contact
Note: The "A" and "B" designators may be used when other than power contacts (PCB, Coax, Thermocouple, or Fiber Optic contacts)

STEP 4: SELECT POLARIZATION



(omit for normal)
W
X
Y
Z

STEP 5: SELECT FINISH



-1A = Aluminium Shell, nickel, no endbell
-6117 = Aluminium Shell, olive drab cadmium plated, no endbell
-6116 = Aluminium Shell, black anodized, no endbell
-059 = Aluminum Shell, nickel-plated with typical straight cable clamp
-Blank = Aluminum Shell, nickel-plated with grommet nut

STEP 6: SELECT MODIFIER



For other commercial modification, i.e., less tools, with pc contact or with endbell, call.

Omit for standard contacts
-LC = for use with standard contacts, but supplied without contacts, seal plugs or tools (PO must state Less Contacts)
Note: -LC is not marked on part

LAYOUTS BY SHELL SIZE

○ 20 ● 16 ◐ 12

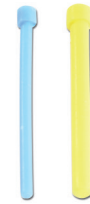
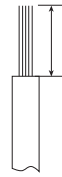
LAYOUT	8-33	8-98	10-6	12-3	12-8	12-10	14-4	14-5
# OF CONTACTS	3-#20	3-#20	6-#20	3-#16	8-#20	10-#20	4-#12	4-#16
SERVICE RATING	I	I	I	II	I	I	I	II

LAYOUT	14-12	14-15	14-18	14-19	16-8	16-26	18-8	18-11
# OF CONTACTS	8-#20, 4-#16	14-#20, 1-#16	18-#20	19-#20	8-#16	26-#20	8-#12	11-#16
SERVICE RATING	I	I	I	I	II	I	I	II

LAYOUT	18-30	18-32	20-16	20-39	20-41	22-12
# OF CONTACTS	29-#20, 1-#16	32-#20	16-#16	37-#20, 2-#16	41-#20	12-#12
SERVICE RATING	I	I	II	I	I	I

LAYOUT	22-21	22-41	22-55	24-19	24-31	24-61
# OF CONTACTS	21-#16	27-#20, 14-#16	55-#20	19-#12	31-#16	61-#20
SERVICE RATING	II	I	I	II	I	I

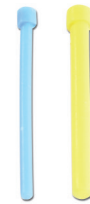
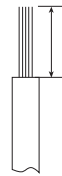
PINS



Insert head first, trim excess

CONTACT SIZE	WIRE CRIMP SIZE RANGE	PIN PART NUMBER	COLOR BANDS			WIRE STRIP LENGTHS		WIRE INSULATION SEALING RANGE				WIRE HOLE FILLER	WIRE HOLE FILLER COLOR
			1	2	3	IN.	MM	MIN. IN.	MIN. MM	MAX. IN.	MAX. MM		
20	20,22,24	M39029/4-110	Brown	Brown	Black	Brown	Brown	0.04	1.02	0.083	2.11	MS27488-20-2	Red
16	16,18,20	M39029/4-111	Brown	Brown	Brown	Brown	Brown	0.053	1.35	0.103	2.62	MS27488-16-2	Blue
12	12 & 14	M39029/4-113	Brown	Brown	Orange	Brown	Brown	0.097	2.46	0.158	4.01	MS27488-12-2	Yellow
8	Contact us for details.												

SOCKETS

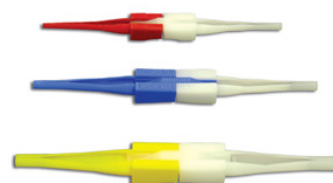


Insert head first, trim excess

CONTACT SIZE	WIRE CRIMP SIZE RANGE	SOCKET PART NUMBER	COLOR BANDS			WIRE STRIP LENGTHS		WIRE INSULATION SEALING RANGE				WIRE HOLE FILLER	WIRE HOLE FILLER COLOR
			1	2	3	IN.	MM	MIN. IN.	MIN. MM	MAX. IN.	MAX. MM		
20	20,22,24	M39029/5-115	Brown	Brown	Green	0.1875	4.77	0.04	1.02	0.083	2.11	MS27488-20-2	Red
16	16,18,20	M39029/5-116	Brown	Brown	Blue	0.2812	7.14	0.053	1.35	0.103	2.62	MS27488-16-2	Blue
12	12 & 14	M39029/5-118	Brown	Brown	Grey	0.2812	7.14	0.097	2.46	0.158	4.01	MS27488-12-2	Yellow
8	Contact us for details.												

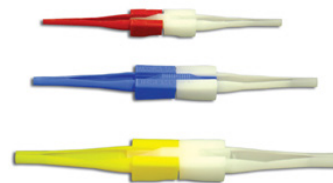
CONTACT TOOLS

PINS



CONTACT SIZE	HAND CRIMP TOOL	TURRET HEAD (LOCATOR)	TURRET HEAD (LOCATOR) COLOR	POWER CRIMP TOOL	POWER TOOL LOCATOR	METAL		PLASTIC		
						INSERTION TOW	EXTRACTION TOOL	INSERTION/ EXTRACTION TOOL	INSERTION TIP COLOR	EXTRACTION TIP COLOR
20	M22520/1-01	M22520/1-02	Red	WA27F	M22520/1-02	DAK83-20B	DRK83-20B	M81969/14-11	Red	White
16	M22520/1-01	M22520/1-02	Blue	WA27F	M22520/1-02	DAK83-16B	DRK83-16B	M81969/14-03	Blue	White
12	M22520/1-01	M22520/1-02	Yellow	WA27F	M22520/1-02	DAK83-12B	DRK83-12B	M81969/14-04	Yellow	White
8	Contact us for details.									

SOCKETS

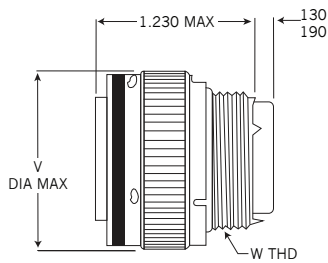


CONTACT SIZE	HAND CRIMP TOOL	TURRET HEAD (LOCATOR)	TURRET HEAD (LOCATOR) COLOR	POWER CRIMP TOOL	POWER TOOL LOCATOR	METAL		PLASTIC		
						INSERTION TOW	EXTRACTION TOOL	INSERTION/ EXTRACTION TOOL	INSERTION TIP COLOR	EXTRACTION TIP COLOR
20	M22520/1-01	M22520/1-02	Red	WA27F	M22520/1-02	DAK83-20B	DRK83-20B	M81969/14-11	Red	White
16	M22520/1-01	M22520/1-02	Blue	WA27F	M22520/1-02	DAK83-16B	DRK83-16B	M81969/14-03	Blue	White
12	M22520/1-01	M22520/1-02	Yellow	WA27F	M22520/1-02	DAK83-12B	DRK83-12B	M81969/14-04	Yellow	White
8	Contact us for details.									

All dimensions in inches (millimeters in parenthesis)

PLUGS

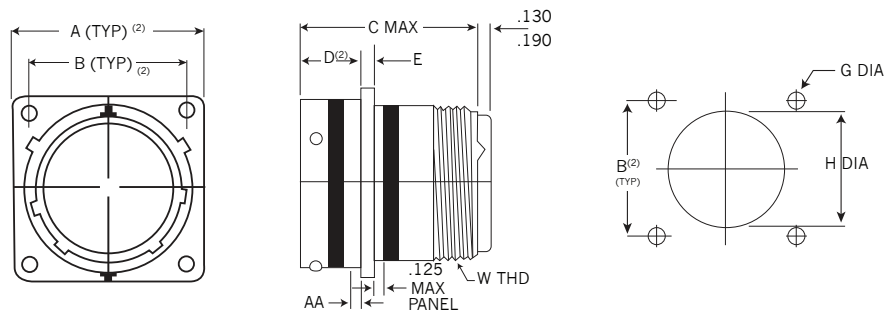
MS3476/ AFD56 & MS3475/ AFD57



SHELL SIZE	V DIA. MAX.	W THREAD CLASS 2A
8	0.782 (19.86)	.5000-20 UNF
10	0.926 (23.52)	.6250-24 UNEF
12	1.043 (26.49)	.7500-20 UNEF
14	1.183 (30.04)	.8750-20 UNEF
16	1.305 (33.14)	1.000-20 UNEF
18	1.391 (35.33)	1.0625-18 UNEF
20	1.531 (38.88)	1.1875-18 UNEF
22	1.656 (42.06)	1.3125-18 UNEF
24	1.777 (45.13)	1.4375-18 UNEF

FLANGE MOUNT

MS3470/ AFD50 & MS3472/ AFD58

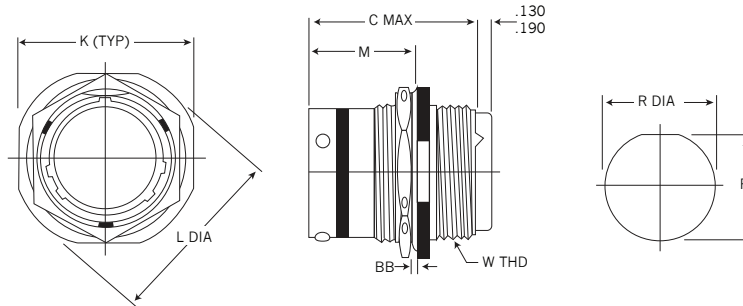


SHELL SIZE	AA MAX. PANEL THICKNESS		A MAX.		B +/- .005 (+/- 1.27)		C MAX.	D		E +/- .016 (+/- .406)	W THREAD CLASS 2A
	MS3470/ AFD50	MS3474/ AFD58	MS3470/ AFD50	MS3470/ AFD50	MS3470/ AFD50	MS3474/ AFD58		MS3470/ AFD50	MS3474/ AFD58		
8	.087 (2.21)	.118 (3.00)	.828 (21.0)	1.065 (27.1)	.594 (15.1)	.734 (18.6)	1.215 (30.86)	.462/.431 (11.74/10.95)	.493/.462 (12.52/11.73)	.062 (1.6)	.5000-20 UNF
10	.087 (2.21)	.118 (3.00)	.954 (24.2)	1.141 (29.0)	.719 (18.3)	.812 (20.6)	1.215 (30.86)	.462/.431 (11.74/10.95)	.493/.462 (12.52/11.73)	.062 (1.6)	.6250-24 UNEF
12	.087 (2.21)	.118 (3.00)	1.047 (26.6)	1.266 (32.2)	.812 (20.6)	.938 (23.8)	1.215 (30.86)	.462/.431 (11.74/10.95)	.493/.462 (12.52/11.73)	.062 (1.6)	.7500-20 UNEF
14	.087 (2.21)	.118 (3.00)	1.141 (29.0)	1.360 (34.5)	.906 (23.0)	1.031 (26.2)	1.215 (30.86)	.462/.431 (11.74/10.95)	.493/.462 (12.52/11.73)	.062 (1.6)	.8750-20 UNEF
16	.087 (2.21)	.118 (3.00)	1.234 (31.3)	1.453 (36.9)	.969 (24.6)	1.125 (28.6)	1.215 (30.86)	.462/.431 (11.74/10.95)	.493/.462 (12.52/11.73)	.062 (1.6)	1.000-20 UNEF
18	.087 (2.21)	.118 (3.00)	1.328 (33.7)	1.532 (38.9)	1.062 (27.0)	1.203 (30.6)	1.215 (30.86)	.462/.431 (11.74/10.95)	.493/.462 (12.52/11.73)	.062 (1.6)	1.0625-18 UNEF
20	.212 (5.38)	.212 (5.38)	1.453 (36.9)	1.688 (42.9)	1.156 (29.4)	1.297 (32.9)	1.275 (32.39)	.587/.556 (14.91/14.12)	.587/.556 (14.91/14.12)	.094 (2.4)	1.1875-18 UNEF
22	.212 (5.38)	.212 (5.38)	1.578 (40.1)	1.766 (44.9)	1.250 (31.8)	1.375 (34.9)	1.275 (32.39)	.587/.556 (14.91/14.12)	.587/.556 (14.91/14.12)	.094 (2.4)	1.3125-18 UNEF
24	.212 (5.38)	.212 (5.38)	1.703 (43.3)	1.891 (48.0)	1.375 (34.9)	1.500 (38.1)	1.275 (32.39)	.587/.556 (14.91/14.12)	.587/.556 (14.91/14.12)	.094 (2.4)	1.4375-18 UNEF

All dimensions in inches (millimeters in parenthesis)

JAM NUT RECEPTACLE

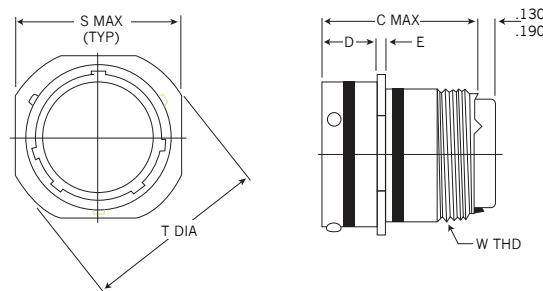
MS3474/ AFD74



SHELL SIZE	BB MAX. PANEL	K +/- .016 (+/- .394)	L +/- .016 (+/- .394)	M +/- .008 (+/- .203)	C MAX.	W THREAD CLASS 2A
8	.187 (4.75)	.939 (23.84)	1.063 (26.99)	.699 (17.75)	1.215 (30.86)	.5000-20 UNF
10	.187 (4.75)	1.0625 (26.99)	1.188 (30.16)	.699 (17.75)	1.215 (30.86)	.6250-24 UNEF
12	.187 (4.75)	1.251 (31.76)	1.378 (34.94)	.699 (17.75)	1.215 (30.86)	.7500-20 UNEF
14	.187 (4.75)	1.378 (34.94)	1.501 (38.11)	.699 (17.75)	1.215 (30.86)	.8750-20 UNEF
16	.187 (4.75)	1.501 (38.11)	1.626 (41.29)	.699 (17.75)	1.215 (30.86)	1.000-20 UNEF
18	.187 (4.75)	1.626 (41.29)	1.751 (44.46)	.699 (17.75)	1.215 (30.86)	1.0625-18 UNEF
20	.250 (6.35)	1.813 (46.04)	1.939 (49.24)	.763 (19.38)	1.275 (32.39)	1.1875-18 UNEF
22	.250 (6.35)	1.939 (49.24)	2.063 (52.39)	.763 (19.38)	1.275 (32.39)	1.3125-18 UNEF
24	.219 (5.56)	2.063 (52.39)	2.188 (55.56)	.763 (19.38)	1.275 (32.39)	1.4375-18 UNEF

IN-LINE CABLE RECEPTACLE

MS3471/ AFD51



SHELL SIZE	S MAX.	T +/- .040 (+/- .508)	C MAX.	D	E +/- .016 (+/- .406)	W THREAD CLASS 2A
				MS3471/AFD51		
8	.828 (21.03)	.938 (23.83)	1.215 (30.86)	.462/.431 (11.74/10.95)	.062 (1.6)	.5000-20 UNF
10	.954 (24.23)	1.062 (26.97)	1.215 (30.86)	.462/.431 (11.74/10.95)	.062 (1.6)	.6250-24 UNEF
12	1.047 (26.59)	1.156 (29.36)	1.215 (30.86)	.462/.431 (11.74/10.95)	.062 (1.6)	.7500-20 UNEF
14	1.141 (28.98)	1.250 (31.75)	1.215 (30.86)	.462/.431 (11.74/10.95)	.062 (1.6)	.8750-20 UNEF
16	1.234 (31.34)	1.344 (34.14)	1.215 (30.86)	.462/.431 (11.74/10.95)	.062 (1.6)	1.000-20 UNEF
18	1.328 (33.73)	1.438 (36.53)	1.215 (30.86)	.462/.431 (11.74/10.95)	.062 (1.6)	1.0625-18 UNEF
20	1.453 (36.91)	1.562 (39.67)	1.275 (32.39)	.587/.556 (14.91/14.12)	.094 (2.4)	1.1875-18 UNEF
22	1.578 (40.08)	1.688 (42.88)	1.275 (32.39)	.587/.556 (14.91/14.12)	.094 (2.4)	1.3125-18 UNEF
24	1.703 (43.26)	1.812 (46.02)	1.275 (32.39)	.587/.556 (14.91/14.12)	.094 (2.4)	1.4375-18 UNEF

All dimensions in inches (millimeters in parenthesis)

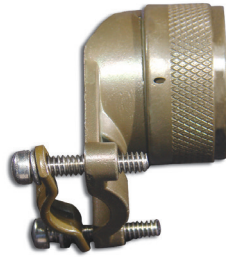
DUMMY RECEPTACLES, DUST CAPS & PLUG CAPS



SHELL SIZE	DUMMY RECEPTACLES OLIVE DRAB OVER CADMIUM PLATED	METAL DUSTCAP		
		FOR PLUGS	FOR RECEPTACLE	
			FLANGED WITH SASH CHAIN	JAM NUT WITH SASH CHAIN AND RING
8	MS3115-8	MS3180-8C*	MS3181-8C*	MS3181-8N*
10	MS3115-10	MS3180-10C*	MS3181-10C*	MS3181-10N*
12	MS3115-12	MS3180-12C*	MS3181-12C*	MS3181-12N*
14	MS3115-14	MS3180-14C*	MS3181-14C*	MS3181-14N*
16	MS3115-16	MS3180-16C*	MS3181-16C*	MS3181-16N*
18	MS3115-18	MS3180-18C*	MS3181-18C*	MS3181-18N*
20	MS3115-20	MS3180-20C*	MS3181-20C*	MS3181-20N*
22	MS3115-22	MS3180-22C*	MS3181-22C*	MS3181-22N*
24	MS3115-24	MS3180-24C*	MS3181-24C*	MS3181-24N*

*Default Plating = Olive Drab over Cadmium
A = Anodized

STANDARD CABLE CLAMPS

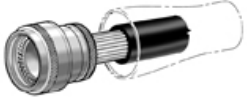









SHELL SIZE	STRAIGHT CLAMP		90°		CABLE ENTRY	
	LOW COST	SELF-LOCKING	LOW COST	SELF-LOCKING	MAX	MIN
8	M85049/52-1-8*	M85049/52S8*	M85049/51-1-8*	M85049/51S8*	.204 (5.18)	.125 (3.18)
10	M85049/52-1-10*	M85049/52S10*	M85049/51-1-10*	M85049/51S10*	.286 (7.26)	.187 (4.75)
12	M85049/52-1-12*	M85049/52S12*	M85049/51-1-12*	M85049/51S12*	.416 (10.57)	.291 (7.39)
14	M85049/52-1-14*	M85049/52S14*	M85049/51-1-14*	M85049/51S14*	.476 (12.09)	.351 (8.92)
16	M85049/52-1-16*	M85049/52S16*	M85049/51-1-16*	M85049/51S16*	.625 (15.88)	.501 (12.72)
18	M85049/52-1-18*	M85049/52S18*	M85049/51-1-18*	M85049/51S18*	.706 (17.93)	.518 (13.16)
20	M85049/52-1-20*	M85049/52S20*	M85049/51-1-20*	M85049/51S20*	.831 (21.11)	.581 (14.76)
22	M85049/52-1-22*	M85049/52S22*	M85049/51-1-22*	M85049/51S22*	.956 (24.28)	.644 (16.36)
24	M85049/52-1-24*	M85049/52S24*	M85049/51-1-24*	M85049/51S24*	1.081 (27.46)	.706 (17.93)

*Select plating code to match connector plating
N = Electroless nickel
W = Olive drab chromate over cadmium over electroless nickel (500-hour salt spray)

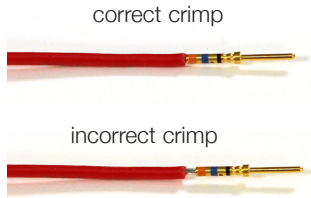
All dimensions in inches (millimeters in parenthesis)

STANDARD CABLE CLAMPS

	DESCRIPTION	PART NUMBER PREFIX	STRAIGHT	90°	45°
	Heat Shrink Boot Adapter	M85049/60	X		
	Environmental	M85049/7			X
		M85049/9		X	
		M85049/11	X		
	EMI/RFI Non- Environmental	M85049/23			X
		M85049/24		X	
		M85049/25	X		
	EMI/RFI Environmental	M85049/6			X
		M85049/8		X	
		M85049/10	X		
	EMI/RFI Crimp Ring	M85049/26	X		
	EMI/RFI Banding	M85049/82	X		
		M85049/83			X
		M85049/84		X	
	Cable Tie	M85049/55		X	
		M85049/53	X		
		M85049/54			X
	Wire Seal Compression Nuts "E"	M85049/31	X		

NOTE: If military-standard versions won't work for your applications, please contact us with your requirements.

WIRE STRIPPING AND CONTACT CRIMPING



STEP 1: Strip wires. See above for correct strip length for contact. Insert wire into rear of contact. Wire insulation must push against rear of contact. Wire must be visible through inspection hole.

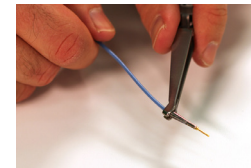
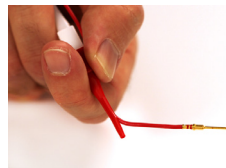
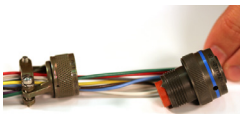
STEP 2: Use M22520/1-01 crimp tool with proper crimp locator M22520/1-02.

CONTACT SIZE	COLOR
20	Red
16	Blue
12	Yellow

STEP 3: Insert contact and wire into tool jaws. To crimp, squeeze handles together fully until ratchet releases and allows handles to expand; otherwise, contact cannot be extracted from tool jaws. Maintain slight insertion pressure on wire while crimping contact to wire.*

*IMPORTANT NOTE: Microsection the contact to verify crimp quality.

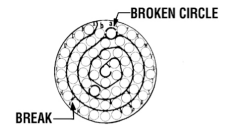
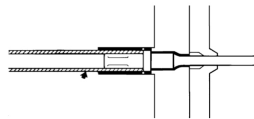
CONTACT INSERTION



STEP 1: Remove backshell and put wired contacts through cable clamp opening.

STEP 2: Use colored end of CIET tool for insertion. Place wire into tool at large opening. To facilitate contact insertion, a minimum six inches of free wire is recommended.

STEP 3: Slide tool on wire while holding thumb against wire at opening. Wire will slip into tool.



STEP 4: With tool pressed against shoulder of contact, starting at the center cavity, insert wired contact and tool into properly-identified cavity at rear of plug with firm, even pressure. Do not use excessive pressure.

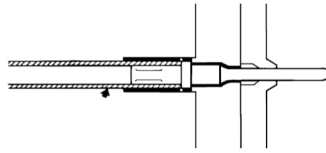
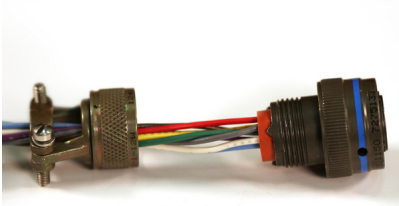
STEP 5: When contact bottoms, a slight click can be heard as tines of metal retaining clip snap into place behind contact shoulder.

STEP 6: Check face of plug or receptacle for proper contact installation. In socket inserts with a large number of contacts, cavities are identified in a spiral pattern. A projecting line from the spiral indicates omission of a letter; a broken circle around a cavity indicates transition between capitals, lower case and double letters.



STEP 7: Withdraw tool from rear of plug. To be sure that contact is locked, pull back lightly on wire. Then remove tool from wire and proceed with other contacts.

STEP 8: After all contacts are inserted, fill unwired cavities with sealing plugs (insert head first and leave end protruding for ease of removal), assemble backshell on rear of connector.



STEP 1: Remove backshell and slide along wires to allow access. To extract a contact, use white end of CIET tool. Place wire into tool at large opening. Slide back tool on wire while holding thumb against wire at opening. Wire will slip into tool.

STEP 2: Push tool into rear of plug until it bottoms. At this point, tool releases tines on retaining clip so that contact can be extracted.

STEP 3: While maintaining slight insertion force on tool, firmly hold wire against serrated shoulder at center of tool and extract both wired contact and tool from plug.

*IMPORTANT NOTE: Microsection the contact to verify crimp quality.