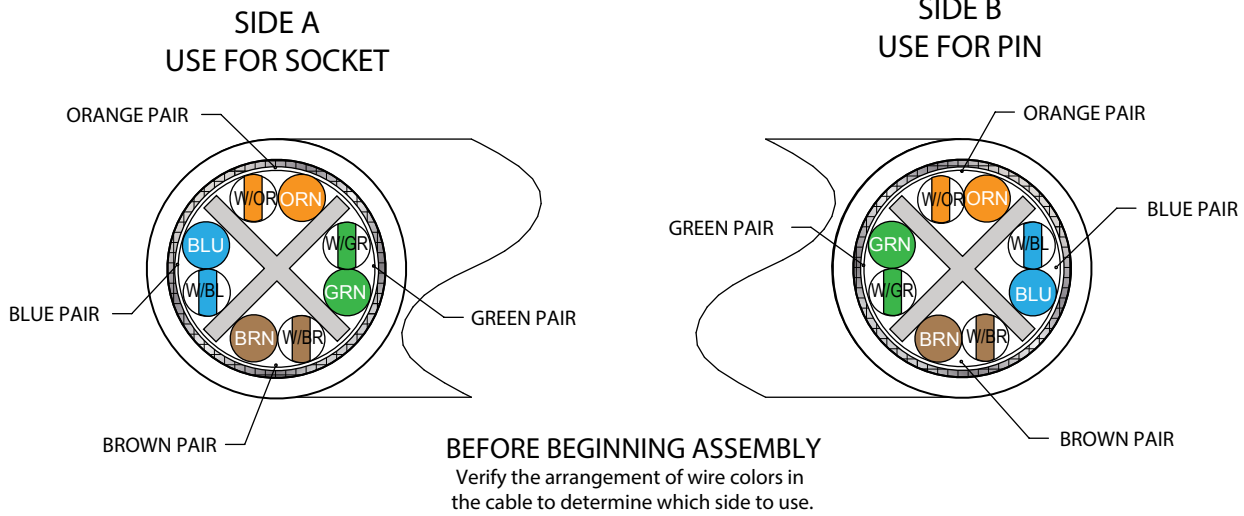


**MIL-DTL-38999 Series III Type Environmental Connectors
AI85082 Speed Master™ Assembly Instructions**

HIGH-SPEED CONNECTORS



STEP 1

- A. Place O-ring onto thread ferrule so that it is seated behind the thread. (Figure 1)
- B. Slide retention ferrule with O-ring onto cable.

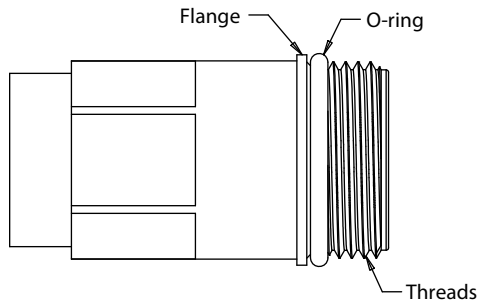


FIGURE 1

STEP 2

- A. Slide shield ferrule onto cable.
- B. Use proper tool to remove cable outer jacket to approximately .75 Inch.
- C. Comb braid out straight, and trim it to approximately .3 Inches. Fold braid back afterward.
- D. Trim outer tape, cable splice, and filler if any as close to the folded back braid shield as possible. (Figure 2)
- E. Use appropriate tool to strip the individual wires to .130 Inches max.

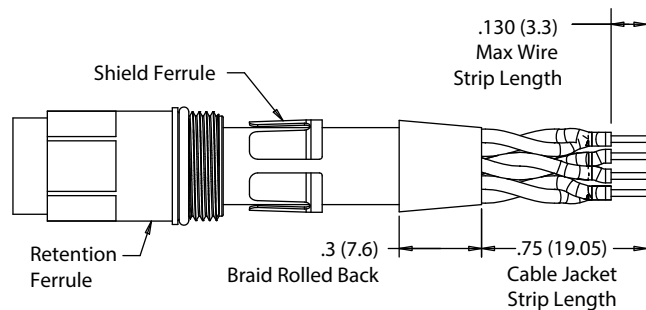


FIGURE 2

MIL-DTL-38999 Series III Type Environmental Connectors AI85082 Speed Master™ Assembly Instructions

HIGH-SPEED CONNECTORS

STEP 3

Maintain twist of pairs as best as possible. If needed – undo half a twist, do not over twist

- A. Crimp contacts onto each individual wire using Daniels crimp tool M22520/2-01 (Glenair P/N 809-015) and Daniels positioner K41 (Glenair P/N 80-019) for sockets, and positioner K42 (Glenair P/N 809-018) for pins.
- B. Insert each pair of wires into the appropriate quadrant on the isolator according to figure 3 for socket modules, and figure 4 for pin modules.

NOTES:

- C. Crossing of pairs is not recommended. (cables should only be terminated as pin to socket).
- D. Assembly instructions use socket module (858-100) for illustrations. Pin module (858-101) is assembled in the same fashion.

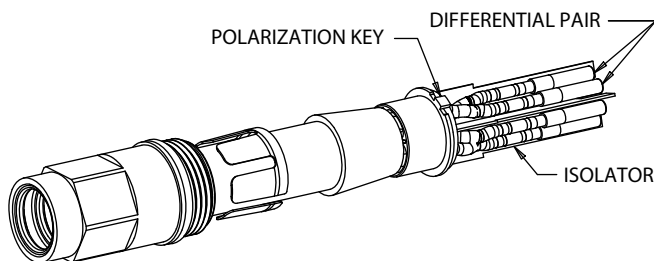


FIGURE 3

SOCKET MODULE PIN-OUT FROM FRONT

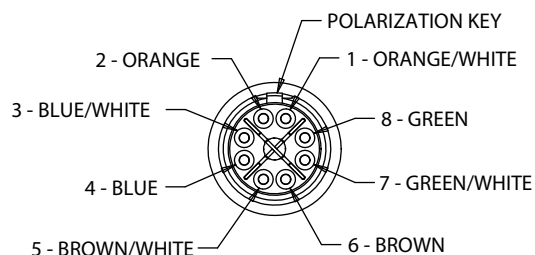
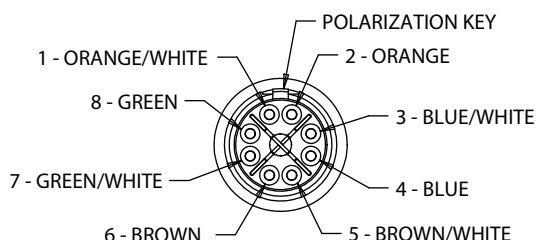


FIGURE 4

PIN MODULE PIN-OUT FROM FRONT



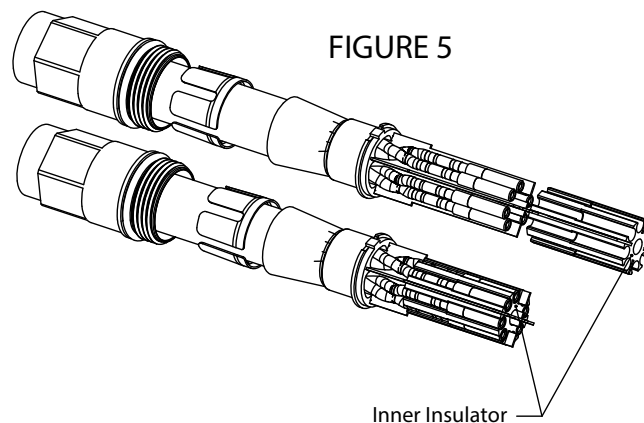
STEP 4

- A. Push the cable all the way into the isolator so the wire pairs can be spread out easily
- B. Move the wires/contacts out of the way and insert the inner insulator on the isolator. Slide the inner insulator all the way onto the isolator.
- C. Snap each pair into the appropriate position on the inner insulator. Refer to figure 2 for sockets and figure 3 for pins.

Notes:

Be sure to maintain twist of each pair as close to the insulator as possible to improve signal. Do not over twist

FIGURE 5



**MIL-DTL-38999 Series III Type Environmental Connectors
AI85082 Speed Master™ Assembly Instructions**

HIGH-SPEED CONNECTORS

STEP 5

- A. Slide outer insulator onto module assembly. Be sure to align the slots/fins and polarization keys. (Figure 6 and 7)
- B. Fold braid shield forward onto termination zone. (Figure 7)
- C. Slide thread ferrule over shield ferrule and move both to the main shoulder. (Figure 8)
- D. Trim excessive braid to behind main shoulder. (Figure 8)

FIGURE 6

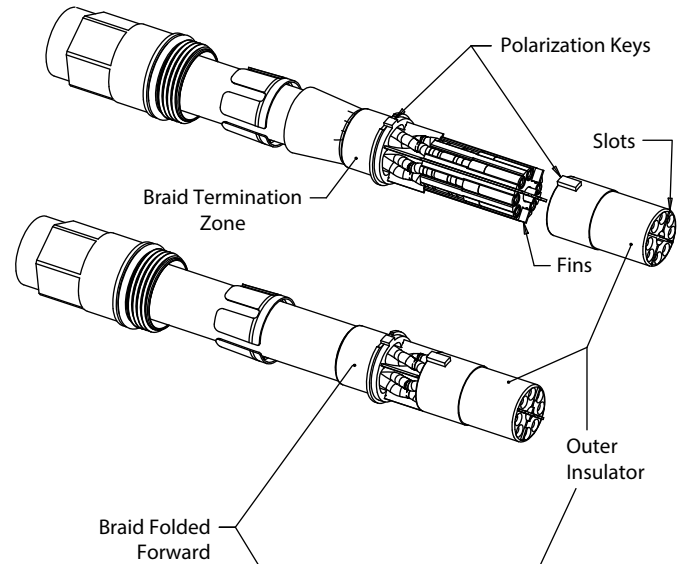
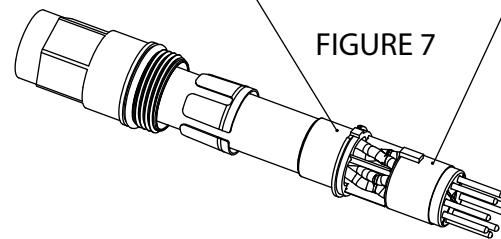
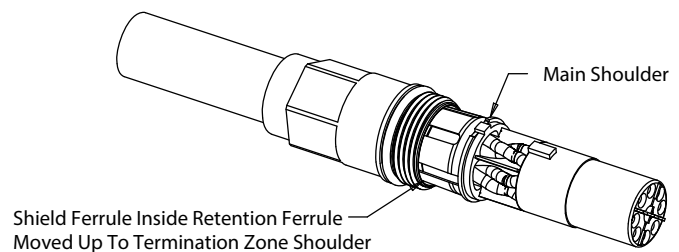


FIGURE 7



Pin Module (858-101) Shown For Reference

FIGURE 8



**MIL-DTL-38999 Series III Type Environmental Connectors
AI85082 Speed Master™ Assembly Instructions**

INSTALLATION

- A. Slide completed module into the insert cavity, making sure to align the module polarization keys with the cavity keyway. (Figure 1)
- B. Using the retention ferrule tool (Glenair P/N 607-011), and a 3/8": wrench, tighten the retention ferrule to a torque of 5 in-lb. (Figure 2)
- C. Install remaining modules in the same manner (figure 3)

Notes:

Figures 1-3 show installation into a 4 cavity female rear panel mount. For other shell types and arrangements contact factory.

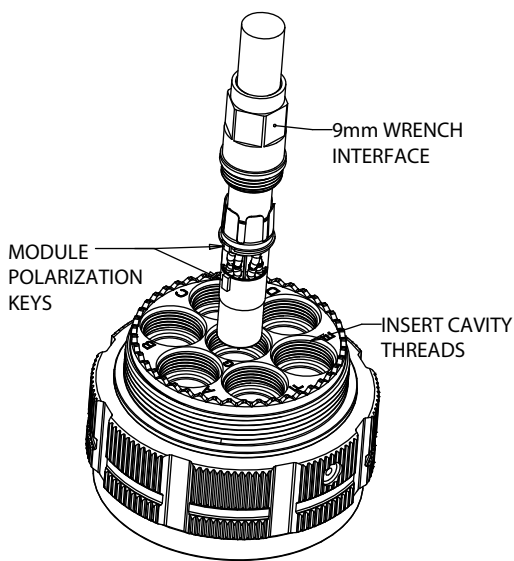


FIGURE 1

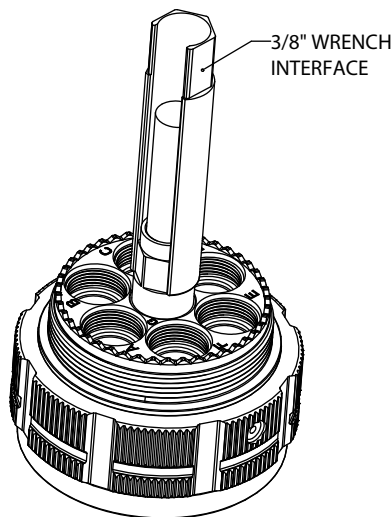


FIGURE 2

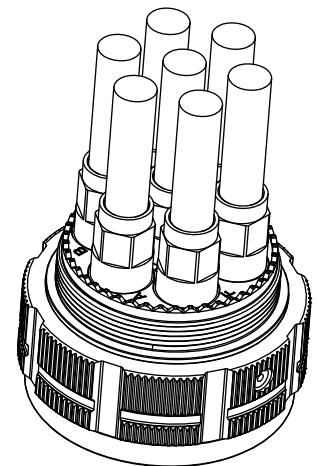


FIGURE 3

HIGH-SPEED CONNECTORS