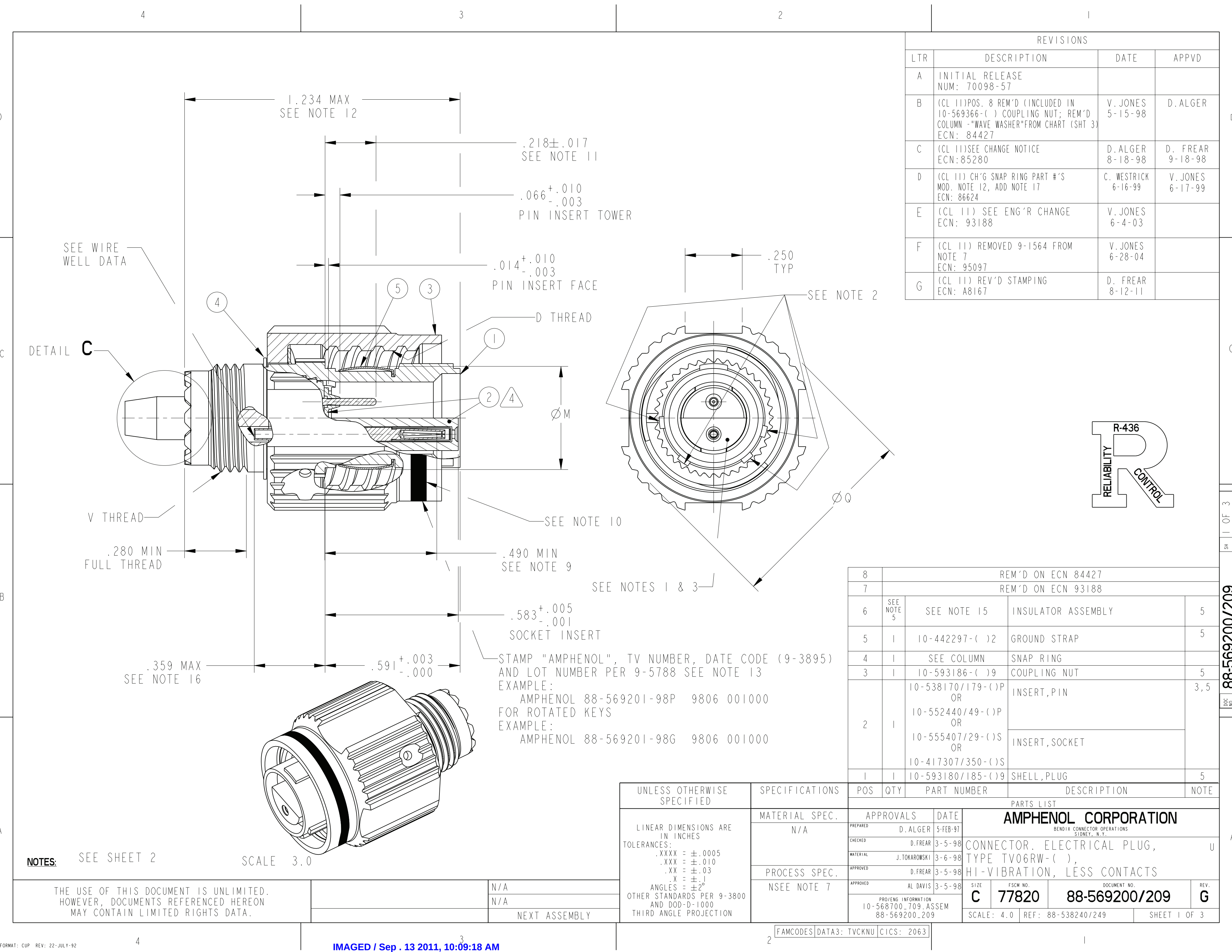
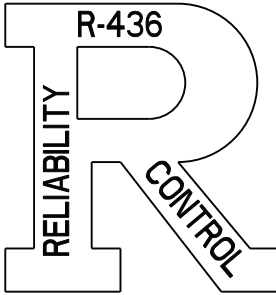




REVISIONS			
LTR	DESCRIPTION	DATE	APPVD
A	INITIAL RELEASE NUM: 70098-57		
B	(CL 11) POS. 8 REM'D (INCLUDED IN 10-569366-() COUPLING NUT; REM'D COLUMN -"WAVE WASHER"FROM CHART (SHT 3) ECN: 84427	V. JONES 5-15-98	D. ALGER
C	(CL 11) SEE CHANGE NOTICE ECN: 85280	D. ALGER 8-18-98	D. FREAR 9-18-98
D	(CL 11) CH'G SNAP RING PART #'S MOD. NOTE 12, ADD NOTE 17 ECN: 86624	C. WESTRICK 6-16-99	V. JONES 6-17-99
E	(CL 11) SEE ENG'R CHANGE ECN: 93188	V. JONES 6-4-03	
F	(CL 11) REMOVED 9-1564 FROM NOTE 7 ECN: 95097	V. JONES 6-28-04	
G	(CL 11) REV'D STAMPING ECN: A8167	D. FREAR 8-12-11	



8	REM'D ON ECN 84427			
7	REM'D ON ECN 93188			
6	SEE NOTE 5	SEE NOTE 15	INSULATOR ASSEMBLY	5
5	1	10-442297-() 2	GROUND STRAP	5
4	1	SEE COLUMN	SNAP RING	
3	1	10-593186-() 9	COUPLING NUT	5
2	1	10-538170/179-() P OR 10-552440/49-() P OR 10-555407/29-() S OR 10-417307/350-() S	INSERT, PIN	3, 5
			INSERT, SOCKET	
1	1	10-593180/185-() 9	SHELL, PLUG	5
POS	QTY	PART NUMBER	DESCRIPTION	NOTE
PARTS LIST				
UNLESS OTHERWISE SPECIFIED		APPROVALS		DATE
		PREPARED	D. ALGER	5-FEB-97
		CHECKED	D. FREAR	3-5-98
		MATERIAL	J. TOKAROWSKI	3-6-98
PROCESS SPEC.		APPROVED	D. FREAR	3-5-98
		APPROVED	AL DAVIS	3-5-98
NSEE NOTE 7		PRO/ENG INFORMATION 10-568700_709.ASSEM 88-569200_209		
		SIZE	FSCM NO.	DOCUMENT NO.
		C	77820	88-569200/209
		SCALE: 4.0	REF: 88-538240/249	SHEET 1 OF 3
		REV. G		

UNLESS OTHERWISE SPECIFIED	SPECIFICATIONS
LINEAR DIMENSIONS ARE IN INCHES TOLERANCES: .XXXX = ±.0005 .XXX = ±.010 .XX = ±.03 .X = ±.1 ANGLES = ±2° OTHER STANDARDS PER 9-3800 AND DOD-D-1000 THIRD ANGLE PROJECTION	MATERIAL SPEC.
	N/A
	PROCESS SPEC.
	NSEE NOTE 7

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		N/A
		NEXT ASSEMBLY

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WIRE WELL DATA							
COAXIAL DATA SEE NOTE 1	CONTACT SIZE	22M	22D	22	20	16	12
	WELL DIA	.028±.001	.0345±.0010	.0365±.0010	.047±.001	.067±.001	.100±.002
	WELL DEPTH	.141 ^{+.016} _{-.000}	.141 ^{+.016} _{-.000}	.141 ^{+.016} _{-.000}	.209 ^{+.020} _{-.000}	.209 ^{+.020} _{-.000}	.209 ^{+.020} _{-.000}

12. FOR 25-11 INSERT ARRANGEMENT, INDICATED DIMENSION IS 1.447 MAX. THIS IS ALLOWED FOR SIZE 10 CONTACT ARRANGEMENTS BY MIL-C-38999J, FIGURE 10, NOTE 7.

11. FOR SIZE 8 COAX DIMENSION IS .438±.025. SEE NOTE 15.

10. BLUE BAND DENOTES REAR RELEASE CONTACT RETENTION SYSTEM.

9. DISTANCE FROM SHOULDER OF SHELL TO THE POINT AT WHICH A GAGE PIN HAVING THE SAME BASIC DIAMETER AS THE MATING CONTACT AND A SQUARE FACE, ENGAGES SOCKET CONTACT SPRING.

8. FOR MATING CONNECTOR, SEE 88-538200/209 AND OTHERS.

7. PROCESS SPEC:
ASSY 9-5047-4, 9-4407-13, 9-7374-1(PARA. 4.3 DOES NOT APPLY)
TEST 9-5726
9-2437-25, 9-5788, 9-3200-2, 9-7543, 9-3895
SPECIAL CONTROL 9-6000-5, PROCESS CONTROL 9-4796

6. PACKAGE PER PRODUCTION PROCESS SHEET.

5. SEE SEPARATE PARTS LIST FOR COMPONENT PART NUMBERS AND QUANTITIES.

4. DRAWING ILLUSTRATES FINAL ASSEMBLY. FOR FINAL INSTALLATION, CONTACTS MUST BE ASSEMBLED INTO ALL INSERT HOLES. ALL UNUSED GROMMET HOLES MUST BE FILLED WITH THE APPROPRIATE SIZE SEALING PLUG, 10-405996. CONTACTS ARE NOT PART OF THIS ASSEMBLY AND MUST BE PURCHASED SEPARATELY.

3. INSERT ASSEMBLY IS NOT REMOVABLE.

2. ALTERNATE ROTATIONS ARE OBTAINED BY ROTATING INDICATED KEYS. SIX POSITIONS ARE AVAILABLE. SEE 9-2437-25.

1. FOR CONTACT ARRANGEMENT PATTERN, SEE DRAWINGS L-15206-() THRU L-15250-(). ALTERNATE POSITIONS THEREON DO NOT APPLY.

17. DELETED ON ECN: 93188, REVISION E.

16. FOR 25-11 INSERT ARRANGEMENT, INDICATED DIMENSION IS .527 MAX.

15. INSULATOR ASSY. TO BE SUPPLIED WHEN GROMMET DESIGN REQUIRES ONE (ALL COAX,SOME TWINAX).
EXAMPLE: 21-AB (TWINAX ARRANGEMENT)
REQUIRES TWINAX INSULATOR P/N 21-33321-005
21-75 (COAX ARRANGEMENT)
REQUIRES COAX INSULATOR P/N 10-452952
25-20 (TWINAX ARRANGEMENT) NO INSULATOR

14. UNITS ILLUSTRATED MEET THE APPLICABLE REQUIREMENTS OF MIL-DTL-38999.

13. SEE WORK ORDER FOR PERMISSIBLE ADDITIONAL OR ALTERNATE STAMPING.

1.656 MAX

6

DETAIL C

ENLARGED

FOR SIZE 8 COAXIAL CONTACT ONLY

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SIZE	FSCM NO.	DOCUMENT NO.	REV.
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88-569200/209

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R-436
RELIABILITY
CONTROL

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PART NUMBER	TV NUMBER REF	SNAP RING	D THREAD MODIFIED PER 9-3200-2		Ø M OVER TINES	Ø Q MAX	V THREAD PER 9-7543
			SIZE CLASS 2B	MODIFIED MINOR DIA			
88-569200-()	06RW- 7-() (474)(LC)	NOT AVAILABLE					
1-()	06RW- 9-() (474)(LC)	10-593189-9	.6250-0.1P-0.3L-TS	.5892-.5842	.449	.859	M12 X 1-6g 0.100R
2-()	06RW-11-() (474)(LC)	-59	.7500-0.1P-0.3L-TS	.7142-.7092	.577	.969	M15 X 1-6g 0.100R
3-()	06RW-13-() (474)(LC)	-71	.8750-0.1P-0.3L-TS	.8392-.8342	.694	1.144	M18 X 1-6g 0.100R
4-()	06RW-15-() (474)(LC)	-87	1.0000-0.1P-0.3L-TS	.9642-.9592	.819	1.266	M22 X 1-6g 0.100R
5-()	06RW-17-() (474)(LC)	-98	1.1875-0.1P-0.3L-TS	1.1394-1.1344	.944	1.391	M25 X 1-6g 0.100R
6-()	06RW-19-() (474)(LC)	-109	1.2500-0.1P-0.3L-TS	1.2020-1.1970	1.049	1.500	M28 X 1-6g 0.100R
7-()	06RW-21-() (474)(LC)	-121	1.3750-0.1P-0.3L-TS	1.3270-1.3220	1.174	1.625	M31 X 1-6g 0.100R
8-()	06RW-23-() (474)(LC)	-134	1.5000-0.1P-0.3L-TS	1.4520-1.4470	1.299	1.750	M34 X 1-6g 0.100R
9-()	06RW-25-() (474)(LC)	10-593190-24	1.6250-0.1P-0.3L-TS	1.5770-1.5720	1.424	1.875	M37 X 1-6g 0.100R

TO COMPLETE, ADD INSERT ARRANGEMENT
SUFFIX PER 9-2437-25

NOTES: SEE SHEET 2

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SIZE
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77820

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