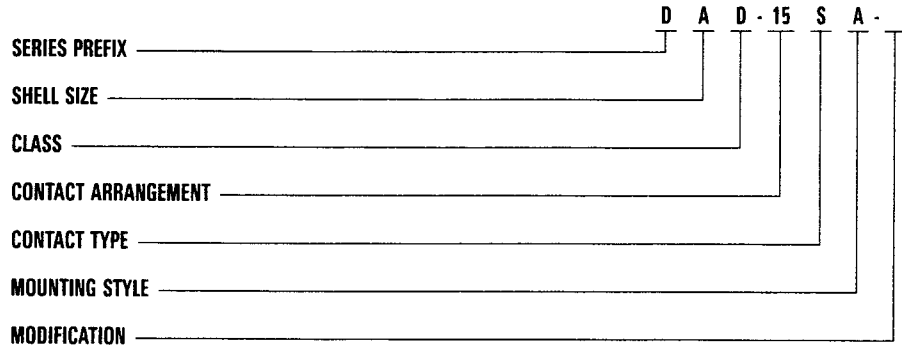


## How to Order

### Solder Cup Terminals



**SERIES PREFIX**  
ITT Cannon Designation

**SHELL SIZE**  
A, B, C, D, E

**CLASS**  
D – Environmental

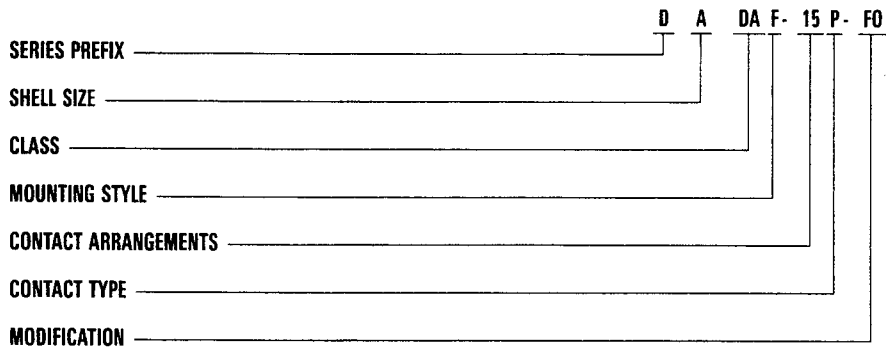
**CONTACT ARRANGEMENT**  
9, 15, 25, 37, 50

**CONTACT TYPE**  
P – Pin  
S – Socket

**MOUNTING STYLE**  
A – Standard mounting holes  
B – Float mounts supplied

**MODIFICATION**  
Consult factory

### Snap-In Crimp Terminals



**SERIES PREFIX**  
ITT Cannon Designation

**SHELL SIZE**  
A, B, C, D, E

**CLASS**  
DA – Environmental, crimp type

**MOUNTING STYLE**  
No Designator – Standard mounting  
F – Float mounts supplied

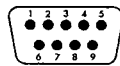
**CONTACT ARRANGEMENTS**  
9, 15, 25, 37, 50

**CONTACT TYPE**  
P – Pin  
S – Socket

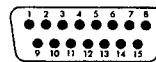
**MODIFICATION**  
FO – Connector supplied less contacts, for other modifications consult factory

## Contact Arrangements

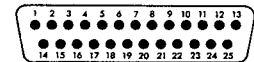
### Face View Pin Insert



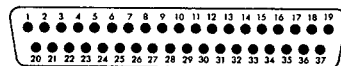
E  
9  
#20



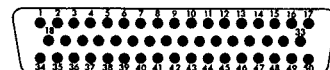
A  
15  
#20



B  
25  
#20



C  
37  
#20



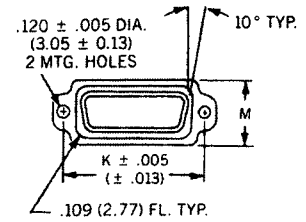
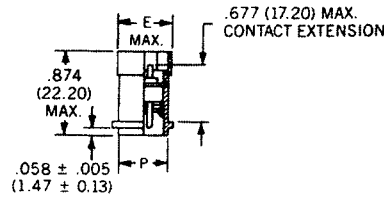
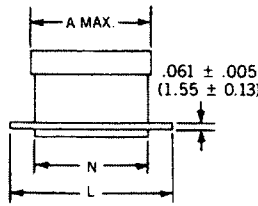
D  
50  
#20

Shell Size  
Contact Arrangement  
Contact Size

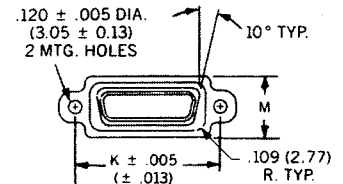
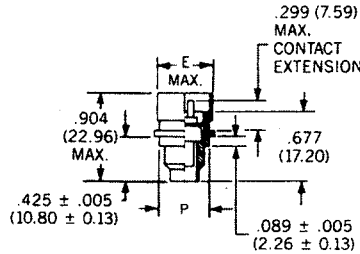
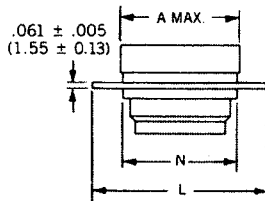
Shell Size  
Contact Arrangement  
Contact Size

Shell Dimensions, Standard Mount

Receptacle

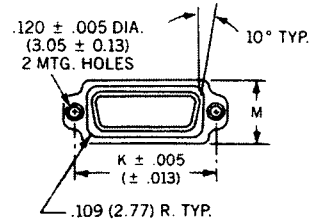
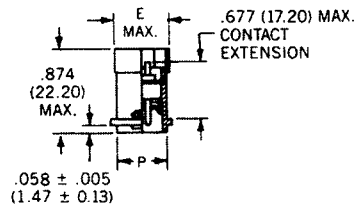
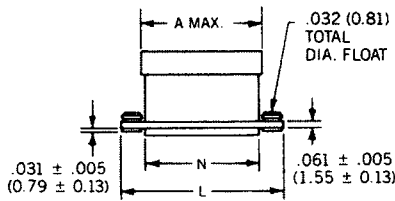


Plug

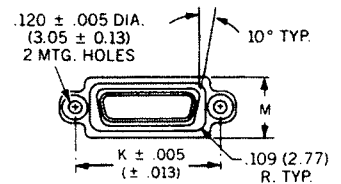
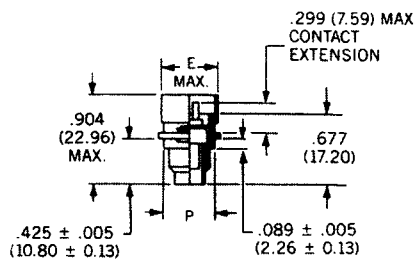
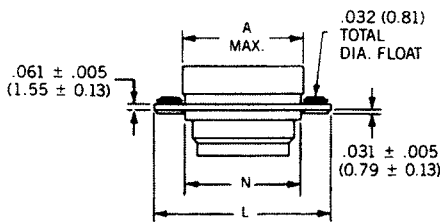


Float Mount Dimensions

Receptacle



Plug



NOTE: All D\*D Environmental plugs and receptacles are provided with dust caps and removable potting cups.

Shell Size	A Max.	E Max.	±.005 (0.13) K	±.010 (0.25) L	±.010 (0.25) M	±.010 (0.25) N	±.010 (0.25) P
DED-9P	.915 (23.24)	.596 (15.14)	1.125 (28.58)	1.442 (36.63)	.614 (15.60)	.825 (20.86)	.483 (12.27)
DED-9S	.915 (23.24)	.596 (15.14)	1.125 (28.58)	1.442 (36.63)	.614 (15.60)	.825 (20.86)	.483 (12.27)
DAD-15P	1.233 (31.32)	.596 (15.14)	1.437 (36.50)	1.755 (44.58)	.614 (15.60)	1.143 (29.03)	.483 (12.27)
DAD-15S	1.233 (31.32)	.596 (15.14)	1.437 (36.50)	1.755 (44.58)	.614 (15.60)	1.143 (29.03)	.483 (12.27)
DBD-25P	1.786 (45.36)	.596 (15.14)	1.993 (50.62)	2.295 (58.29)	.614 (15.60)	1.683 (42.75)	.483 (12.27)
DBD-25S	1.786 (45.36)	.596 (15.14)	1.993 (50.62)	2.295 (58.29)	.614 (15.60)	1.683 (42.75)	.483 (12.27)
DCD-37P	2.458 (62.43)	.567 (14.40)	2.625 (66.68)	2.937 (74.60)	.614 (15.60)	2.343 (59.51)	.483 (12.27)
DCD-37S	2.458 (62.43)	.567 (14.40)	2.625 (66.68)	2.937 (74.60)	.614 (15.60)	2.343 (59.51)	.483 (12.27)
DDD-50P	2.390 (60.71)	.680 (17.27)	2.531 (64.29)	2.859 (72.62)	.735 (18.67)	2.251 (57.18)	.596 (15.14)
DDD-50S	2.390 (60.71)	.680 (17.27)	2.531 (64.29)	2.859 (72.62)	.735 (18.67)	2.251 (57.18)	.596 (15.14)

All tolerances are ±.010 (0.24) unless noted otherwise.

Mounting Dimensions

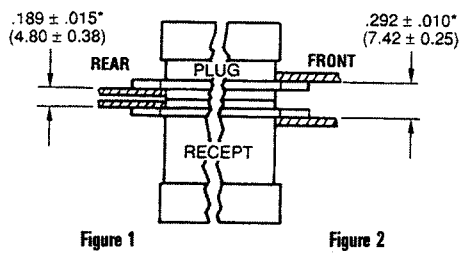


Figure 1

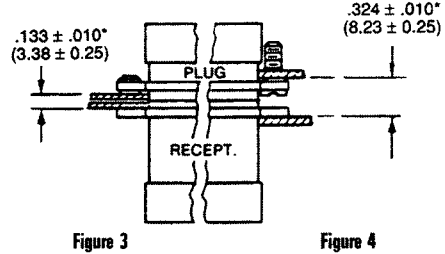


Figure 3

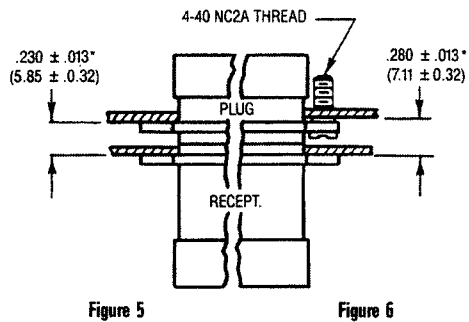


Figure 5

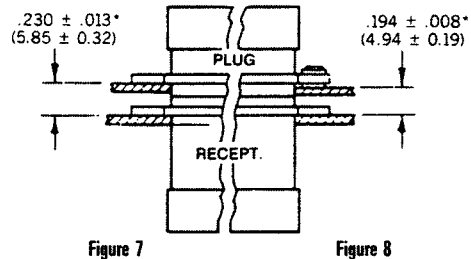


Figure 7

**NOTE:** Max panel thickness is .125 (3.17) for non-floating rear panel mounting.

1. With both connectors rear mounted, use #4-40 flat head screws flush with the panel (Fig. 1).
2. With both connectors front mounted, use #4-40 binder or pan head screws (Fig. 2).
3. With both connectors rear mounted (float rivets on plug assembly side), use #4-40 flat head screws, flush with the panels (Fig. 3).
4. With both connectors front mounted (plug assembly has float mounting screw), use #4-40 binder or pan head screws for receptacle assembly (Fig. 4).

5. With plug assembly front mounted and receptacle assembly rear mounted, use hardware from Figures 5 and 6.

6. With plug assembly front mounted and receptacle assembly rear mounted (plug assembly has float mounting screw), use hardware from Figure 1 for receptacle assembly.

\*Dimensions between panels represent the recommended limit to be used in the design of the connector mounting method.

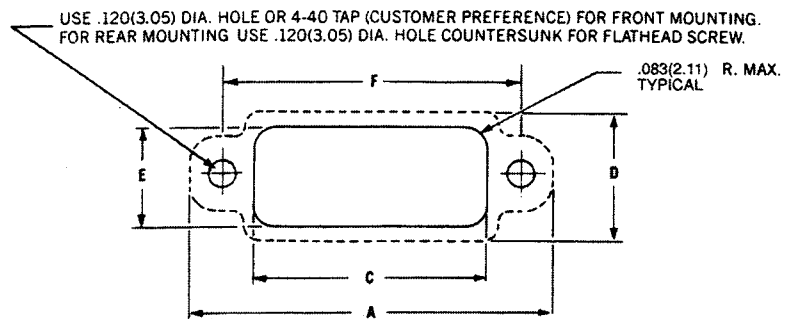
7. With plug assembly rear mounted and receptacle assembly front mounted, use hardware from Figures 1 and 2.

8. With plug assembly rear mounted (float rivets) and receptacle assembly front mounted, use hardware from Figures 2 and 3.

9. Electrical contact engagement when mounted per Figure 1 is .046(1.17) min. / .070(1.78) max.

**NOTE:** Float rivets are for rear mounting only and float screw for front mounting only. (Specify when ordering.)

Panel Cutouts



Shell Size	A ±.010 (0.25)	C Min.	D ±.010 (0.25)	E Min.	F ±.006 (0.15)
DED-9	1.442 (36.63)	.839 (21.31)	.614 (15.60)	.497 (12.62)	1.125 (28.58)
DAO-15	1.755 (44.58)	1.157 (29.39)	.614 (15.60)	.497 (12.62)	1.437 (36.50)
DBD-25	2.295 (58.29)	1.697 (43.10)	.614 (15.60)	.497 (12.62)	1.993 (50.62)
DCD-37	2.937 (74.60)	2.357 (59.87)	.614 (15.60)	.497 (12.62)	2.625 (66.68)
DDD-50	2.859 (72.62)	2.265 (57.53)	.735 (18.67)	.610 (15.49)	2.531 (64.29)

Add .032 (0.81) to dimensions C and E for float mounting.  
Note: Panel cutout does not allow for potting cup clearance.

Contact Crimping Information

Crimp Type Contacts

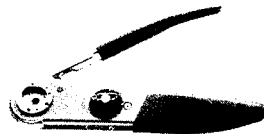
Contact Size	Wire Size Accom.	Standard Finish		Military Finish	
		Pin	Socket	Pin	Socket
20	20, 22, 24	330-5291-015	031-1007-000	330-5291-079	031-1007-042



Insertion/Extraction Tools

CIET-20HD

Contact Size	AWG	Plastic Insertion/Extraction		Plastic Extraction	
		Part No.	Description	Part No.	Description
20	20, 22, 24	980-2000-426	CIET-20HD	323-7010-000	CET-20-11



M22520/1-01

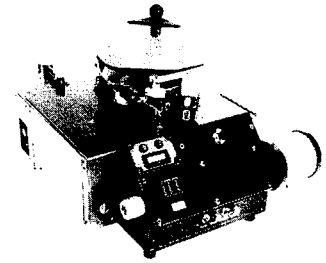


M22520/2-01

Hand Crimp Tools

Contact Size	AWG	Crimp Tool		Locator	
		Part No.	Description	Part No.	Description
20	20, 22, 24	995-0001-584	M22520/2-01	995-0001-604	M22520/2-08
		995-0001-585	M22520/1-01	995-0001-244	TH25

Semi-Automatic Crimp Machines



CBT-646

The CBT-646, Vibra-Bowl Crimper is a pneumatically powered, electronically controlled machine. It is designed to semi-automatically crimp closed barrel, machined contacts, as used in the aerospace and commercial industries. The machine will accommodate wire sizes 30 thru 12 AWG. The CBT-646 is actuated automatically upon insertion of a pre-stripped stranded or single conductor wire. The CBT-646 meets all Mil. Spec. requirements for crimping closed barrel contacts.

Machine Crimp Rate: 1300 + per hour

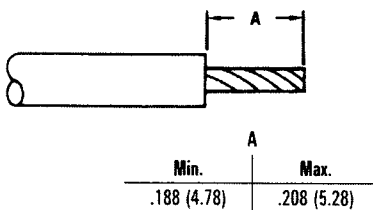
Power Requirements:

- Electrical = 115 Vac, 60 Hz, 5A
- Pneumatic = 85 psi, 2 cu. ft. per min.

Products: Most ITT Cannon Commercial and Aerospace closed-barrel contacts, wire sizes 30 thru 12 AWG. See connector line for part numbers.

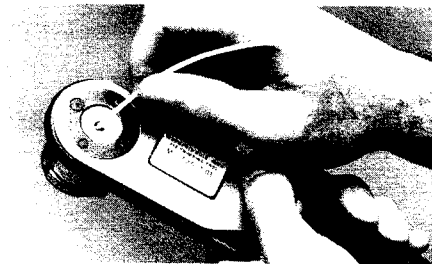
Assembly Instructions

Wire Stripping - Machined Contacts



1. Cut wires to length. Strip insulation per above illustration. Check for broken or frayed wires.

Contact Crimping



2. Insert contact and wire into proper crimp tool (and locator, if required). Crimp contact to wire. Inspect crimp.

Contact Insertion

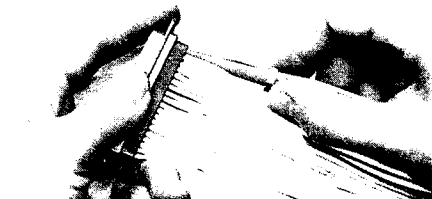


3. Center wired contact in groove of insertion tool with tool tip butting contact shoulder. Insert contact into cavity until a positive stop is felt. Inspect insertion.

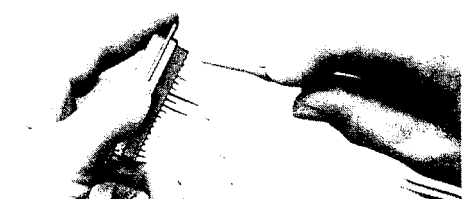
Contact Extraction



4. To be sure contact is locked securely, pull back lightly on wire. Repeat for balance of contacts working row by row across the insulator.



5. Place wire into extraction tool tip.



6. Insert tool tip into contact cavity until tip bottoms against contact shoulder, releasing lines. Hold wire against tool with finger and remove tool and contact. Repeat for balance of contacts.

**ITT Cannon**

For technical assistance, price or delivery information, call your local technical sales office or distributor.

Dimensions are shown in inches (millimeters).  
Dimensions subject to change.