

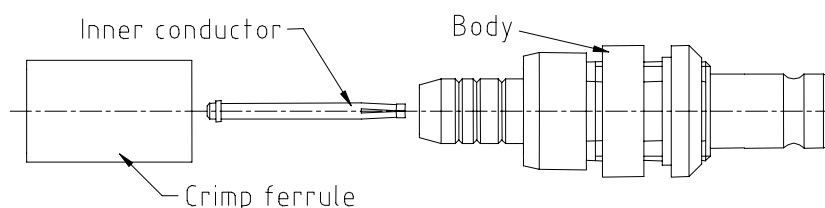
1. INTRODUCTION

This specification covers the requirements for application of Tyco Electronics DIN 1.0 / 2.3 (50Ω / 75Ω) straight cable jack and plug connectors. The cable is connected by crimping the cable braid to the plug or jack body, the inner conductor is soldered.

The component drawings in this specification may differ from the parts supplied.

2. DRAWINGS

PART NUMBER	CABLE	CRIMPING TOOL	DIM. TABLE	INTERMED. LAYER	CAL. Ø
0-1393670-1	RG 316	0-1393524-4 hex 3.2	3.1.2.2	No	1.04 _{-0.01}
1-1393670-6	2YCCY 0.4/2.5 2YC(mS)CY 0.4/2.5	0-1393524-5 hex 5.4	3.1.4.1	Yes	1.04 _{-0.01}
4-1393670-1	RG 316	0-1393524-4 hex 3.2	3.1.2.2	No	-
4-1393670-4	RG 316	0-1393524-4 hex 3.2	3.1.2.1	No	-
5-1393670-5	RG 179	0-1393524-4 hex 3.2	3.1.2.2	No	-
5-1393670-7	R1-T 2.0 LI-75K	0-1393524-5 hex 4.5	3.1.4.1	Yes	-
5-1393670-9	TR-SP127/128	0-1393524-5 hex 5.4	3.1.2.2	No	-
6-1393670-0	2YCCY 0.4/2.5 2YC(mS)CY 0.4/2.5	0-1393524-5 hex 5.4	3.1.4.2	Yes	-
6-1393670-1	2YCCY 0.4/2.5 2YC(mS)CY 0.4/2.5	0-1393524-5 hex 5.4	3.1.4.2	Yes	-
6-1393670-2	RG 179	0-1393524-4 hex 3.2	3.1.2.2	No	-
6-1393670-4	02Y(St)C4 0.45/0.2	0-1393524-5 hex 4.5	3.1.4.1	Yes	-
7-1393670-7	RG 179	0-1393524-4 hex 3.2	3.1.2.1	No	1 _{-0.01}
8-1393670-0	RG 179	0-1393524-4 hex 3.2	3.1.2.1	No	1 _{-0.01}
8-1393670-1	02Y(St)C4 0.45/0.2	0-1393524-5 hex 4.5	3.1.4.1	Yes	1 _{-0.01}
8-1393670-8	02Y(St)C4 0.45/0.2	0-1393524-5 hex 4.5	3.1.4.1	Yes	-
9-1393670-4	02Y(St)C4 0.45/0.2	0-1393524-5 hex 4.5	3.1.4.1	Yes	-
619086-1	02Y12Y(mS)C6Y 0.45/2.0	0-1393524-5 hex 4.5			
619353-1	RG 179D	hex 3.63	3.1.2.2	No	-



3. INSTRUCTIONS

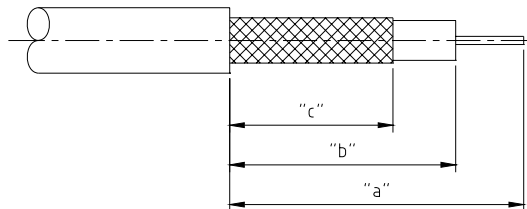
3.1 Prepare cable

3.1.1 Single screen braiding, without intermediate layers

- Strip cable jacket to dimension "a" without damaging the screen braiding.
- Shorten dielectric to dimension "b" without damaging inner conductor.
- Trim screen braiding to dimension "c" without damaging dielectric.

3.1.2 Dimension table (recommended dimensions)

Dimension	"a"	"b"	"c"
3.1.2.1	13.3	10.8 _{-0.3}	6 _{-0.5}
3.1.2.2	10.8	8.3 _{-0.3}	6 _{-0.5}

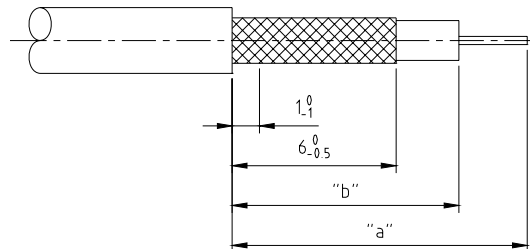


3.1.3 Single and double screen braiding, with intermediate layers

- Strip cable jacket to dimension "a" without damaging the screen braiding.
- Shorten dielectric to dimension "b" without damaging inner conductor.
- Trim both screens braiding to dimension 6_{-0.5} without damaging dielectric.
- Push back outer screen braiding and trim intermediate layers (magnetic screen and/or insulating foil) to dimension 1₋₁. outer screen braiding must not be pulled apart. Dielectric must not be damaged.

3.1.4 Dimension table (recommended dimensions)

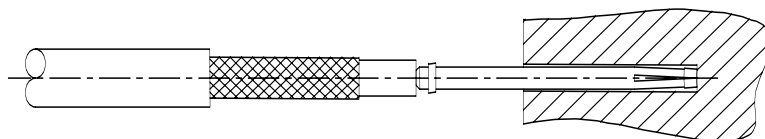
Dimension	"a"	"b"
3.1.4.1	10.8	8.3 _{-0.3}
3.1.4.2	10.5 _{-0.5}	7.7 _{-0.5}



3.2 Tin inner conductor if inner conductor is plated

3.3 Solder on inner conductor

- Insert inner conductor in a mounting bore (self-made) $\varnothing 1.1$.
- Insert solder wire in the inner conductor bore and cut off flush.
- Heat up soldering zone of the inner conductor and then insert cable in the liquid solder until it will go no further.



3.4 Remove excess solder.

3.5 Push crimp ferrule onto cable.

3.6 Crimping outer conductor

3.6.1 Preparation

- Calibrate insulating part with a pin \varnothing according to the table in par. 2.
- Insert prepared cable up to stop. Screen braiding must lie over flange. Inner conductor must sit firmly in insulating part.

3.6.2 Crimping

- Push crimp ferrule onto screen braiding up to stop and crimp on using a crimping tool in accordance with the table par. 2.

