

DIN 1.0 / 2.3 (50Ω / 75Ω) Connectors

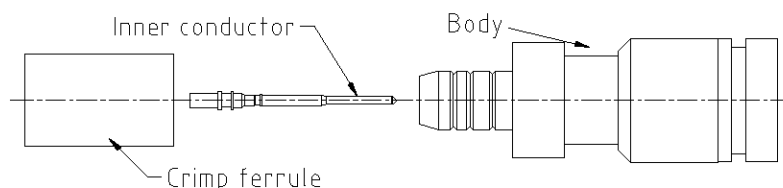
1. INTRODUCTION

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 crimped.

The component drawings may differ from the parts supplied.

2. DRAWINGS

| PART NUMBER | CABLE | CRIMPING TOOL | DIM. TABLE FOR CABLE PREPARATION | INTERMED. LAYER |
|-------------|--------|-----------------|-------------------------------------|--------------------|
| 6-1393670-5 | ST 212 | 58552-1 hex 3.8 | 3.1.2 | No |
| 6-1393670-6 | ST 212 | 58552-1 hex 3.8 | 3.1.2 | No |
| 6-1393670-7 | ST 214 | 58425-1 hex 6.5 | 3.1.2 | Yes |
| 8-1393670-9 | ST 212 | 58552-1 hex 3.8 | 3.1.2 | No |
| 9-1393670-0 | ST 214 | 58425-1 hex 6.5 | 3.1.2 | Yes |
| 9-1393670-5 | ST 212 | 58552-1 hex 3.8 | 3.1.2 | No |



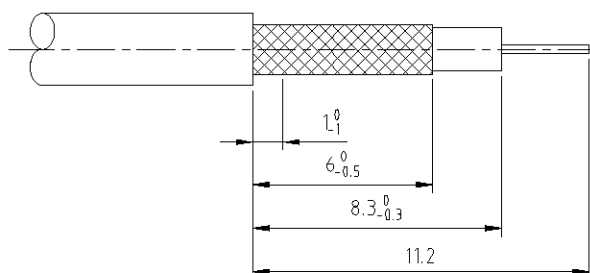
3. INSTRUCTIONS

3.1 Prepare cable

3.1.1 Single screen braiding

- Strip cable jacket to dimension 11.2 without damaging the screen braiding.
- Shorten dielectric to dimension 8.3_{-0.3}⁰ without damaging inner conductor.
- Trim screen braiding to dimension 6.0_{-0.5}⁰ without damaging dielectric.
- If there is an intermediate layer (see table): push back outer screen braiding and trim intermediate layer to dimension 1.1. Outer screen braiding must not be pulled apart. Dielectric must not be damaged.

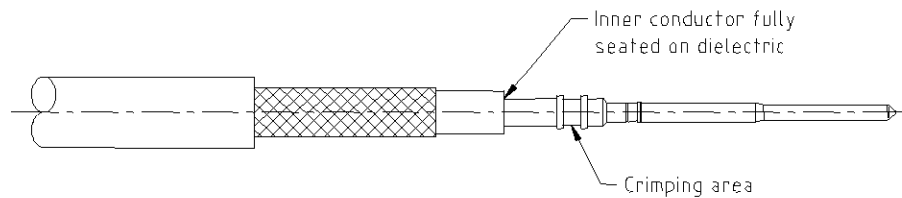
3.1.2 Dimension table (recommended dimensions)



3.2 Tin inner conductor

3.3 Crimp inner conductor

- Mount the inner conductor on the cable inner conductor.
- Make sure that the inner conductor remains fully seated on the cable dielectric.
- Crimp the inner conductor with crimp dies square 0.7.



3.4 Push crimp ferrule into cable.

3.5 Crimping preparation

- The following must be observed for 75Ω Connectors: when assembling the plug do not widen insulating part.
- Before assembling the jack calibrate bore in the insulating part with a pin of $\varnothing 1_{-0.01}$.

3.6 Crimping

- Push crimp ferrule onto screen braiding up to stop and crimp on using the crimp tool mentioned in the table (page 1)

