

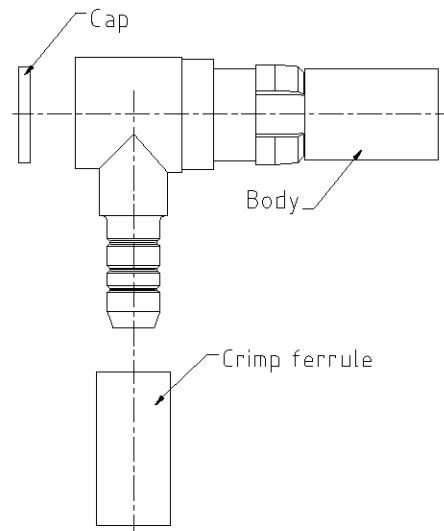
## 1. INTRODUCTION

This specification covers the requirements for application of Tyco Electronics DIN 1.0 / 2.3 (50Ω / 75Ω) 90° coaxial inserts connectors. The cable is connected by crimping the cable braid to the insert, the inner conductor is soldered.

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

## 2. DRAWINGS

Part Number	Cable	Crimping Tool
0-1393668-4	RG 316	0-1393524-4 hex 3.2
0-1393668-5	RG 316	0-1393524-4 hex 3.2
0-1393668-7	RD 316	0-1393524-4 hex 3.6
0-1393668-8	RG 316	0-1393524-4 hex 3.2
0-1393668-9	RG 316	0-1393524-4 hex 3.2
1-1393668-2	RG 316 RG 179	0-1393524-4 hex 3.2
2-1393668-4	RG 179	0-1393524-4 hex 3.2
2-1393668-8	RG 179	0-1393524-4 hex 3.2
3-1393668-3	RG 179	0-1393524-4 hex 3.2
3-1393668-6	RG 179	0-1393524-4 hex 3.2

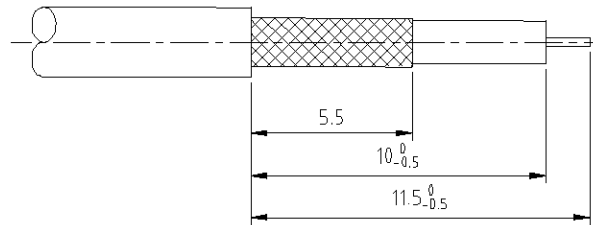


## 3. INSTRUCTIONS

### 3.1 Prepare cable

- Strip cable jacket to dimension 11.5<sub>-0.5</sub> without damaging the screen braiding.
- Shorten dielectric to dimension 10<sub>-0.5</sub> without damaging inner conductor.
- Trim screen braiding to dimension 5.5 without damaging dielectric.

3.1.1 Dimension table



3.2 Tin inner conductor

3.3 Push crimp ferrule onto cable

3.4 Crimping preparation

- Insert prepared cable up to stop. Screen braiding must lie over flange.

3.5 Crimping

- Push crimp ferrule onto screen braiding up to stop and crimp on in accordance with the drawing table using crimping tool PN 0-1393524-4

3.6 Tin solder inner conductor

3.7 Insert cap (can also be soldered all around) and press in with fixture 6-1393504-8. Cap is held by the collar.

