

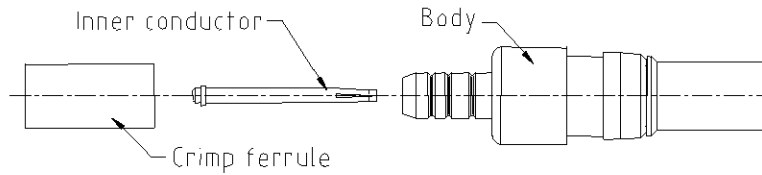
1. INTRODUCTION

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

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

2. DRAWINGS

Part Number	Cable	Crimping Tool
3-1393668-0	RG 179	0-1393524-4 hex 3.2
3-1393668-1	RG 179	0-1393524-4 hex 3.2
3-1393668-4	RG 179	0-1393524-4 hex 3.2

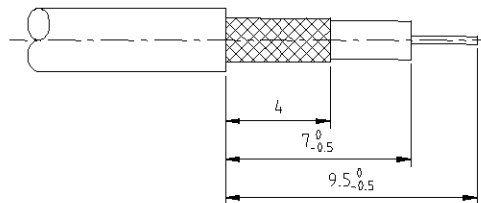


3. INSTRUCTIONS

3.1 Prepare cable

- Strip cable jacket to dimension 9.5⁺⁰_{-0.5} without damaging the screen braiding.
- Shorten dielectric to dimension 7⁺⁰_{-0.5} without damaging inner conductor.
- Trim screen braiding to dimension 4 without damaging dielectric.

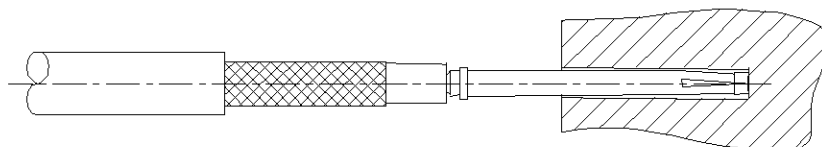
3.1.1 Dimension table for cable preparation



3.2 Tin inner conductor

3.3 Solder inner conductor

- Insert inner conductor in a mounting bore (self made) Ø1.1.
- Insert solder wire in the inner conductor and cut off flush.
- Heat up soldering zone of the inner conductor and then insert cable in the liquid solder up to stop.



3.4 Remove excess solder

3.5 Push crimp ferrule onto cable

3.6 Crimping preparation

- Calibrate bore in the insulating part with a pin of $\varnothing 1.04_{-0.01}$.
- Insert prepared cable up to stop. Screen braiding must lie over flange. Inner conductor must sit firmly in insulating part.

Warning:

- 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 $\varnothing 1_{-0.01}$.

3.7 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.

