

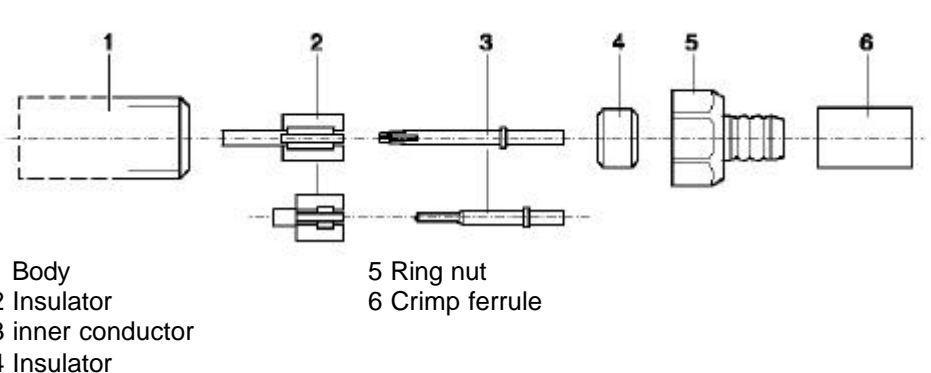
**1. INTRODUCTION**

This specification covers the requirements for application of Tyco Electronics DIN 1.6 / 5.6 mS (75? ) 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 the specification may differ from the parts supplied.

**2. DRAWINGS**

PART NUMBER	CABLE	CRIMPING TOOL	INTERMED. LAYER	DIM TABLE	TOOLS: OPEN-END WRENCH
0-1393672-2	02Y12YC(mS)C6Y 0.45/2.0	0-1393524-5 hex 4.5	No	3.1.1	8, 10
0-1393672-3	02Y(St)CY 0.45/2.0	0-1393524-5 hex 4.5	Yes	3.1.2	8, 10
0-1393672-6	02Y(St)CY 0.45/2.0	0-1393524-5 hex 4.5	Yes	3.1.2	8, 10
0-1393680-1	R1-T 2.0LI 75k	0-1393524-5 hex 4.5	Yes	3.1.2	8, 10
0-1393680-2	RG 179	0-1393524-4 hex 3.2	No	3.1.1	8, 10
0-1393680-3	2YCCY 0.4/2.5 2YC(mS)CY 0.4/2.5	0-1393524-5 hex 5.4	Yes	3.1.2	8, 10
0-1393680-4	02Y(mS)CY 0.5/3.0	0-1393524-8 hex 6.8	Yes	3.1.2	8, 10
0-1393680-5	2YCY 0.7/4.4	0-1393524-8 hex 6.8	No	3.1.1	8, 10
0-1393680-9	02Y(St)CY 0.45/2.0	0-1393524-5 hex 4.5	Yes	3.1.2	8, 10
1-1393680-0	02Y(St)CY 0.45/2.0	0-1393524-5 hex 4.5	Yes	3.1.2	8, 10
2-1393680-2	RG 179	0-1393524-4 hex 3.2	No	3.1.1	8, 10
2-1393680-3	RG 179	0-1393524-4 hex 3.2	No	3.1.1	8, 10
2-1393680-4	02Y12YC(mS)C6Y 0.45/2.0	0-1393524-5 hex 4.5	No	3.1.1	8, 10
2-1393680-5	05YCC(St)6Y 0.4/1.6	0-1393524-4 hex 3.6	Yes	3.1.2	8, 10
2-1393680-6	02Y(St)CY 0.45/2.0	0-1393524-5 hex 4.5	Yes	3.1.2	8, 10
2-1393680-9	RG 179	0-1393524-4 hex 3.2	No	3.1.1	8, 10
4-1393680-5	02Y(St)CY 0.45/2.0	0-1393524-5 hex 4.5	Yes	3.1.2	8, 10
1460132-1	02YS (St) CHH 0.25/1.2 HF 75 0.25/1.15	0-1393524-4 hex 3.2	Yes	3.1.2	8, 10

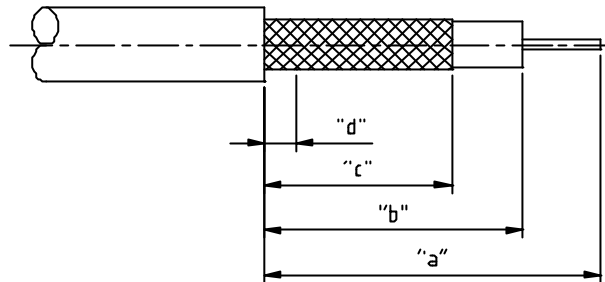


**3. INSTRUCTIONS**

**3.1 Prepare cable**

- Strip cable jacket to dimension "a" without damaging the screen braiding.
- Shorten dielectric to dimension "b" without damaging inner conductor.
- Trim screen(s) braiding to dimension "c" without damaging dielectric.
- In the case of double screened cables, slide back outer screen braiding and trim intermediate layers (magnetic screen and/or insulating foil) to dimension "d".

- Outer screen braiding must not be pulled apart.
- Dielectric must not be damaged.



Dimension	"a"	"b"	"c"	"d"
3.1.1	14 <sub>-0.3</sub>	8 <sub>-0.3</sub>	6 <sub>-0.3</sub>	
3.1.2	15 <sub>-0.3</sub>	9 <sub>-0.3</sub>	7 <sub>-0.3</sub>	1 <sub>-1</sub>

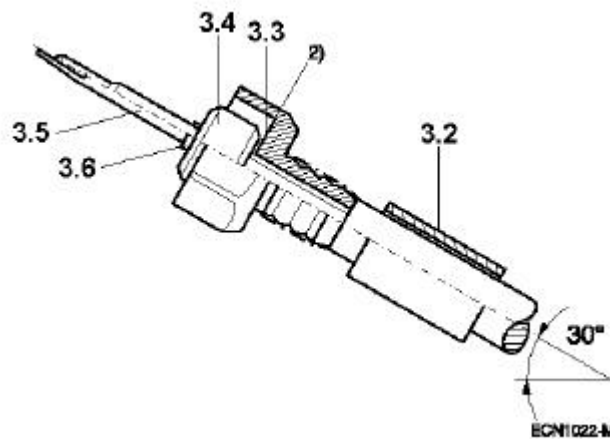
3.2 Push crimp ferrule onto cable

3.3 Push on ring nut; push gland between dielectric and screen braiding. The face end of the cable dielectric must be flush with or projecting slightly with respect to the face surface <sup>2)</sup> of the ring nut (see drawing).

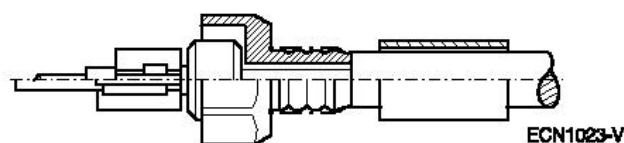
3.4 Push on insulator (4) up to stop

3.5 Push on inner conductor

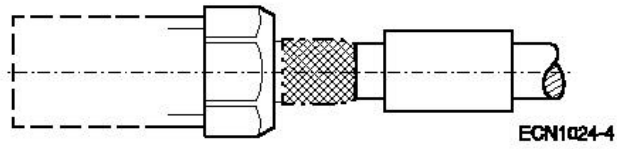
3.6 Hold inner conductor at an angle of 30°. Refer to soldering specification 114-71028.



3.7 Push insulator (2) onto inner conductor



3.8 Insert prepared cable in body. Hold body with tool (e.g. pliers) while holding cable (e.g. by hand) and then tightly screw on nut with wrench 10.



3.9 Push crimp ferrule onto screen braiding up to stop and crimp on in accordance with the list in par. 2.

