

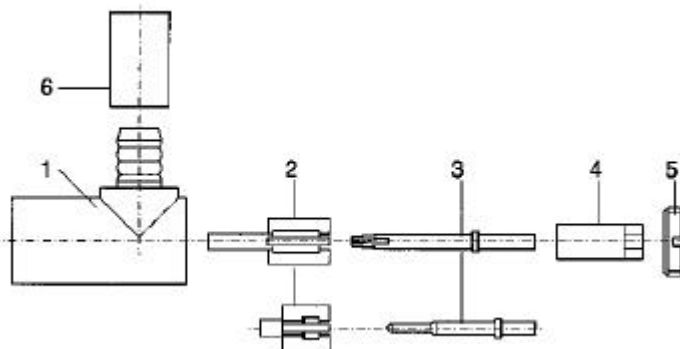
1. INTRODUCTION

This specification covers the requirements for application of Tyco Electronics DIN 1.6 / 5.6 mS (75°) 90° 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	DIM. TABLE	INTERMED. LAYER
1460042-1	02YS(St)CY 0.45/2.0	0-1393524-5 hex 4.5	3.1.2	Yes
1460128-1	02YS(St)CHH 0.25/1.2 HF 75 0.25/1.15	0-1393524-4 hex 3.2	3.1.2	Yes
0-1393672-5	02Y(St)CY 0.45/2.0	0-1393524-4 hex 4.5	3.1.2	Yes
1-1393680-1	TR-SP109	6-1419172-9 hex 7	3.1.1	No
1-1393680-2	TR-SP127/128	6-1419172-9 hex 5.4	3.1.1	No
1-1393680-3	2YCCY 0.4/2.5 2YC(mS)CY 0.4/2.5	0-1393524-5 hex 5.4	3.1.2	Yes
1-1393680-6	02Y12YC(mS) C6Y 0.45/2.0	0-1393524-5 hex 4.5	3.1.1	No
1-1393680-7	02Y12YC(mS) C6Y 0.45/2.0	0-1393524-5 hex 4.5	3.1.1	No
1-1393680-8	02Y(St)CY 0.45/2.0	0-1393524-5 hex 4.5	3.1.2	Yes
1-1393680-9	02Y(St)CY 0.45/2.0	0-1393524-5 hex 4.5	3.1.2	Yes
2-1393680-0	02Y(St)CY 0.45/2.0	0-1393524-5 hex 4.5	3.1.2	Yes
3-1393680-0	RG 179	0-1393524-4 hex 3.2	3.1.1	No
3-1393680-2	2YCCY 0.4/2.5 2YC(mS)CY 0.4/2.5	0-1393524-5 hex 5.4	3.1.2	Yes
3-1393680-5	02Y12YC(mS) C6Y 0.45/2.0	0-1393524-5 hex 4.5	3.1.1	No
3-1393680-7	02YS(St)CY 0.45/2.0	0-1393524-5 hex 4.5	3.1.2	Yes
3-1393680-8	02YS(St)CY 0.45/2.0	0-1393524-5 hex 4.5	3.1.2	Yes
4-1393680-4	02Y(St)CY 0.45/2.0	0-1393524-5 hex 4.5	3.1.2	Yes
4-1393682-3	06YCC(St)6Y 0.4/1.6	0-1393524-4 hex 3.6	3.1.2	Yes



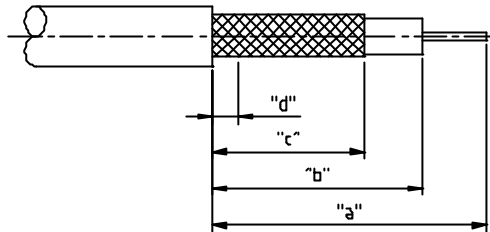
- 1 Body
- 2 Insulator
- 3 inner conductor
- 4 Insulator
- 5 Threaded cap
- 6 Crimp ferrule

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.

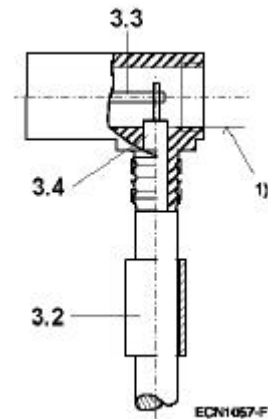


Dimension	"a"	"b"	"c"	"d"
3.1.1	13.5 _{0.3}	9.5 _{0.3}	6 _{0.3}	
3.1.2	14.5 _{0.3}	10.5 _{0.3}	7 _{0.3}	1 ₋₁

3.2 Push crimp ferrule onto cable

3.3 Insert insulator (2) and inner conductor in body

3.4 Insert cable in the body: 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 outer conductor surface ¹⁾ (see drawing)



3.5 Push crimp ferrule onto screen braiding up to stop and crimp on in accordance with table on par. 2

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

3.7 Insert insulator (4)

3.8 Screw in threaded cap and secure with lacquer

