

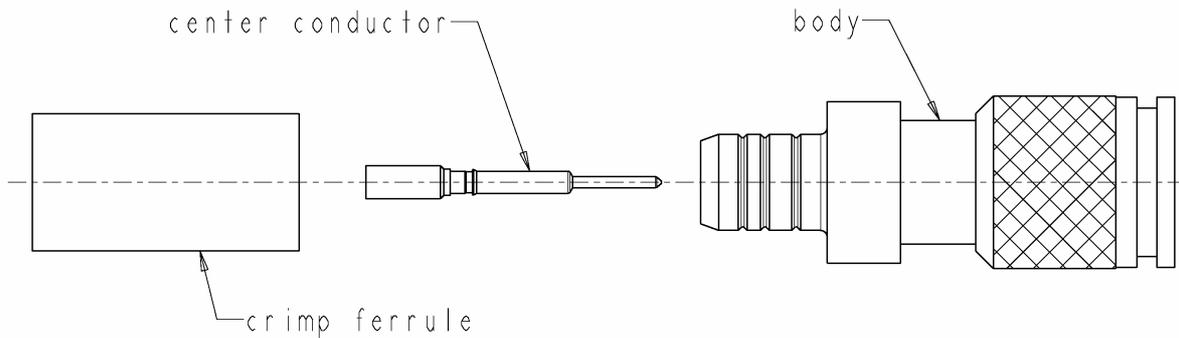
1. INTRODUCTION

This specification covers the requirements for application of Tyco Electronics DIN 1.0 / 2.3 (75Ω) straight cable jack and plug connectors. The cable is connected by crimping the cable braid to the plug or jack body and also the inner conductor is crimped with 8 indent tool.

The component drawings may differ from the parts supplied.

2. DATA TABLE

PART NUMBER	CABLE	OUTER CONTACT CRIMP TOOL	CENTER CONTACT 8 indent CRIMP TOOL	DIM. TABLE FOR CABLE PREPARATION	INTERMED. LAYER
619226-1	Belden 1855A or Gepeco VDM230	734595-1 hex 4.47	986651-1 pos. 4 Use positioner K41	3.1.1.1	Yes



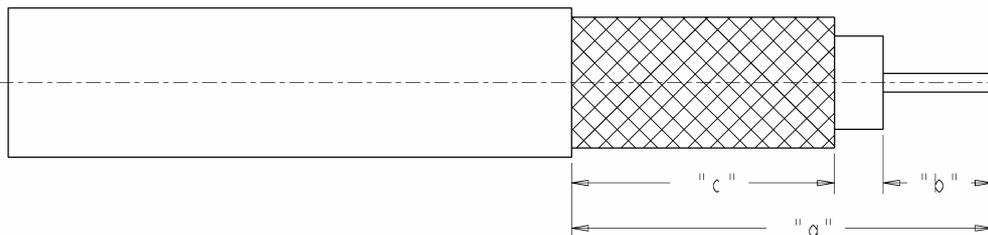
3. INSTRUCTIONS

3.1 Prepare cable

- Prepare the cable according to the dimension table 3.1.1.
- It's recommended not to remove the foil; if that causes problems with high voltage performance you can remove the foil up to the braid but leave the foil beneath the braid.
- Slide crimp ferrule over

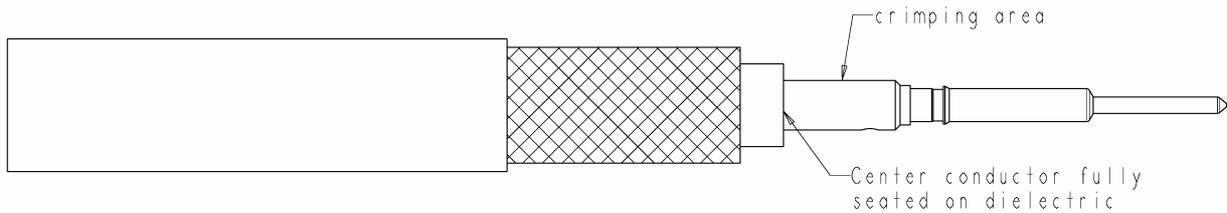
3.1.1 Dimension table (recommended dimensions)

DIMENSION	"a"	"b"	"c"
3.1.1.1	10 _{+0/-0.2}	3 _{±0.2}	6 _{+0/-0.5}



3.2 Crimp on center conductor

- Slide center contact over cable center conductor.
- Make sure that the center conductor butts on the cable dielectric.
- Crimp center conductor as close as possible to the dielectric of the cable; using the appropriate crimp mentioned in the data table section 2 page 1.



3.3 Contact assembly

- Flare braid and insert contact into the crimp of the body. The contact must bottom on the internal dielectric of the connector.
- Slide the crimp ferrule over the braid until it bottoms against the body. Crimp the ferrule using the appropriate crimp dies mentioned in the data table section 2 page 1.

