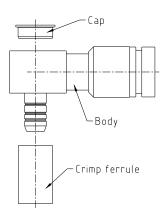## 1.   INTRODUCTION

This specification covers the requirements for application of Tyco Electronics DIN 1.0 / 2.3 (50Ω / 75Ω) 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 this specification may differ from the parts supplied.

2.   DRAWINGS

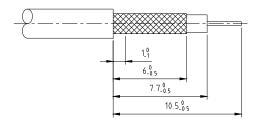| PART NUMBER	CABLE	CRIMPING TOOL	DIM. TABLE FOR CABLE PREPARATION	IINTERMED. LAYER
2-1393670-6	RG 179 RG 316	0-1393524-4 hex 3.2	3.1.1	No
3-1393670-2	RG 179 RG 316	0-1393524-4 hex 3.2	3.1.1	No
7-1393670-0	02Y(St)CY 0.45/2.0	0-1393524-5 hex 4.5	3.1.1	Yes
9-1393670-1	ST214	58425-1 hex 6.5	3.1.1	Yes
9-1393670-2	02Y(St)CY 0.45/2.0	0-1393524-5 hex 4.5	3.1.1	Yes
5-1419149-0	TR-SP127-128	0-1393524-5 hex 5.4	3.1.1	No
0-0619228-1	RG316	0-1393524-4 hex 3.2	3.1.1	No

3.   INSTRUCTIONS

3.1 Prepare cable

- Strip cable jacket to dimension $10.5_{-0.5}$ without damaging the screen braiding.
- Shorten dielectric to dimension $7.7_{-0.5}$ without damaging inner conductor.
- Trim screen braiding to dimension $6_{-0.5}$ without damaging dielectric.
- If there is an intermediate layer (see table) : push back outer screen braiding and trim intermediate layers to dimension 1_{-1}. Outer screen braiding must not be pulled apart. Dielectric must not be damaged.
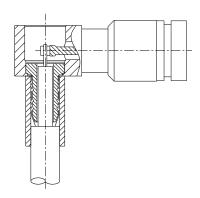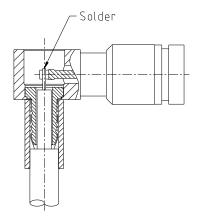
3.1.1 Dimension table for cable preparation (recommended dimensions)

1_{-1}^{0}

$6_{-0.5}^{0}$

$7.7_{-0.5}^{0}$

$10.5_{-0.5}^{0}$

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 using the crimp tool mentioned in the table (page 1)

3.6 Solder inner conductor

Solder

3.7 Insert cap