

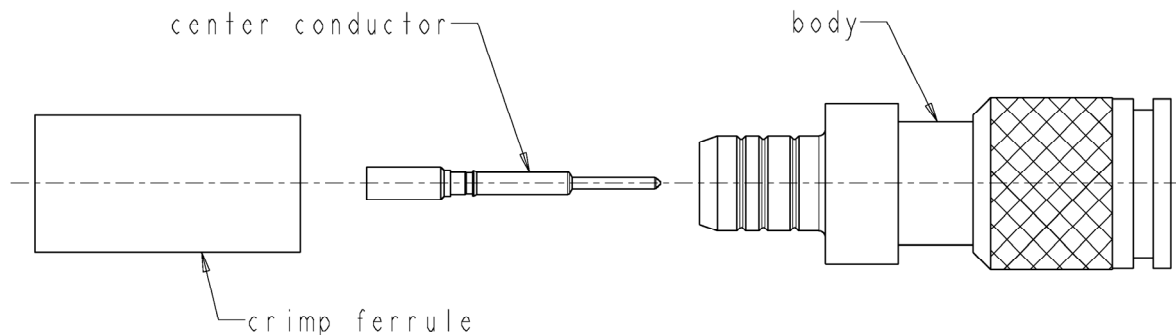
1. INTRODUCTION

This specification covers the requirements for application of Tyco Electronics DIN 1.0 / 2.3 (50Ω) 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.

The component drawings may differ from the parts supplied.

2. DATA TABLE

PART NUMBER	CABLE	OUTER CONTACT CRIMP Height	CENTER CONTACT CRIMP Height x Length	DIM. TABLE FOR CABLE PREPARATION	INTERMED. LAYER
619085-1	WP93385 L2	hex 5.41 _{±0.08} Crimp tool pn 354940-1 Die Set pn 58436-1	8 indent pos. 5 DANIELS tool pn 986651-1 or pn 601966-1 or pn 986651-1 Positioner K41	3.1.1.1	Yes
1460010-1 619224-1	LMR-240 FR	hex 6.8 _{±0.05} Crimp tool pn 734595-1	8 indent pos. 7 DANIELS tool pn 986651-1 or pn 601966-1 or pn 986651-1 Positioner K41	3.1.1.2	Yes
619223-1	WP93385 L2	hex 5.41 _{±0.08} Crimp tool pn 354940-1 Die Set pn 58436-1	8 indent pos. 5 DANIELS tool pn 986651-1 or pn 601966-1 or pn 986651-1 Positioner K41	3.1.1.3	Yes
1460016-3	RA7000	hex 5.18 _{±0.08} Crimp tool pn 354940-1 Die Set pn 58552-1	8 indent pos. 5 DANIELS tool pn 986651-1 or pn 601966-1 or pn 986651-1 Positioner K41	3.1.1.4	No
1274710-1	RG402	Soldered	Soldered	3.1.1.5	No



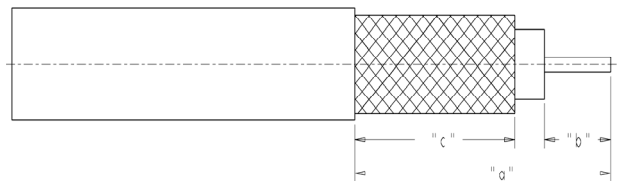
3. INSTRUCTIONS

3.1 Prepare cable

- Prepare the cable according to the dimension table.
- 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

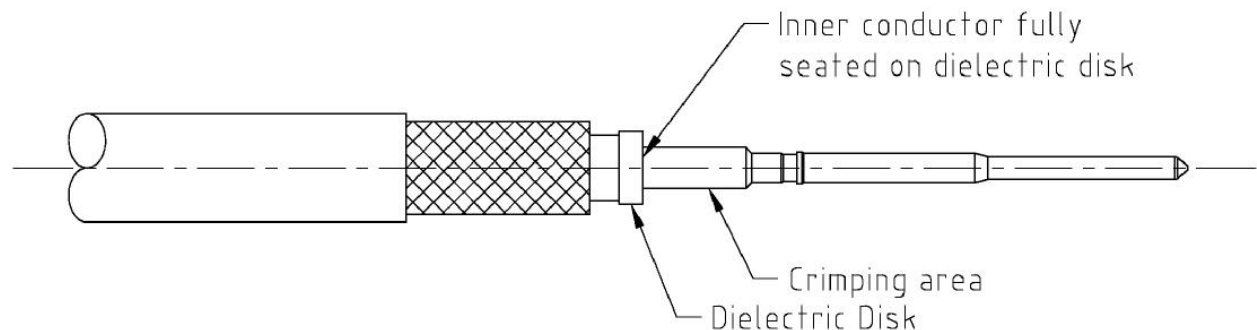
3.1.1 Dimension table (recommended dimensions)

DIMENSION	"a"	"b"	"c"
3.1.1.1	10.7 \pm 0.2	3.6 \pm 0.2	6 \pm 0.2
3.1.1.2	12.7 \pm 0.2	3.2 \pm 0.2	8.5 \pm 0.2
3.1.1.3	10.4 \pm 0.2	3.55 \pm 0.2	5.4 \pm 0.2
3.1.1.4	10.0 \pm 0.2	2.8 \pm 0.2	5.8 \pm 0.2
3.1.1.5	3 \pm 0.1	2 \pm 0.1	0



3.2 Crimp on center conductor

- For Cable LMR-240 FR push the center conductor until the spring inside the positioner is depressed.
- For Cable WP 93385 L2, slide the Dielectric disk (1460460-1) on the cable center conductor against the cable dielectric.
- Slide center contact over cable center conductor.
- Make sure that the center conductor butts on the dielectric disk.
- Crimp center conductor as close as possible to the dielectric disk; using the appropriate crimp dies 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.

