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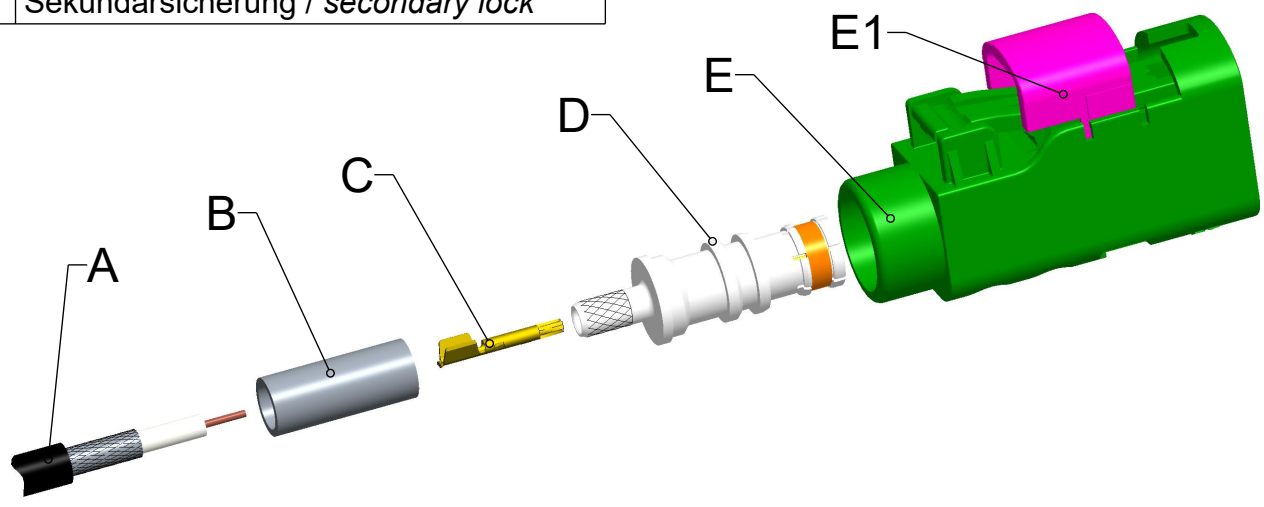
PD_FB_01

-METRIC-

ISO-Projektion
 Methode 1

1 2 3 4

A	Kabel / cable
B	Crimphülse / crimping sleeve
C	Innenleiter / center contact
D	Steckerkörper / plug body
E	Kunststoffgehäuse / plastic housing
E1	Sekundärsicherung / secondary lock



Teile Nummer <i>part number</i>	Kabelgruppe <i>cable group</i>	Werkzeug 1 <i>tool 1</i>	Werkzeug 2 <i>tool 2</i>
59K130-102XX-Y	02 / RG 174 02 / RG 316 02 / DACAR 462 02 / DACAR 107-2	11W161-800	11W150-302
59K130-103XX-Y	03 / RG 179 B/U-d 03 / 1.5DS-QFB (TA)	11W161-800	11W15B-503
59K130-106XX-Y	06 / RG 58	11W161-806	11W150-108
59K130-1BSXX-Y	BS / Shikoku 1.5DS-QEHBE M SH-131 BS / Shikoku 1.5DS-QEHB SH-030	11WB016-A01	11WM012
59K130-1BYXX-Y	BY / TFC 4.0mm double braid	11WB034	11W15W-5BA
59K130-1D6XX-Y	D6 / DACAR 077	11W161-801	11W150-108
59K130-1D8XX-Y	D8 / B-75-1.7-2.7	11W161-801	11W150-302
59K130-1E4XX-Y	E4 / DACAR 037 E4 / Draka FL09YBCYW 1.1/2.9 DKB E4 / CommScope AMC-58 Low Loss EZ E4 / G & G 69337	11W161-8E4	11W150-108
59K130-1E7XX-Y	E7 / B-61-1.87-2.9	11W161-800	11W150-302
59K130-1M4XX-Y	M4 / RTK 031	11W161-8M4	11W150-104
59K130-1S8XX-Y	S8 / 3C - 2V	11W161-800	11W150-108

Rosenberger

general tolerance
 ISO 2768
 mH

assembly instr.:

 panel piercing:

scale: 2:1 (1:1)
 series: ---

crimp insert: ---
 cable: ---

vertraulich / confidential

drawn		date		name	
u00	18-0698	C_Ostermaier	09.05.2018	check.	04.03.2005 F_Neureiter
t00	16-v728	R_Gnodtke	11.07.2017	appr.	15.05.2018 F_Repp
s00	16-1305	J_Hegenauer	02.08.2016		21.12.2018 P_Blassfeld
r00	16-0457	M_Kolbe	22.03.2016		
q00	15-1459	M_Kolbe	14.03.2016		
p00	14-0039	N_Naus	09.01.2014		
rev.	change-no	name	date		

title: **Montageanleitung
 assembly instruction**

drawing-no.: **MA_59V059**

sheet: **1**
 of: **7**

remarks: .

1 2 3 4

1 2 3 4

(1) Hülse "B" auf Kabel "A" schieben.
 Slide ferrule "B" onto cable "A"

(2) Kabel nach Zeichnung/ Tabelle abisolieren.
 Strip cable according to drawing/ table.

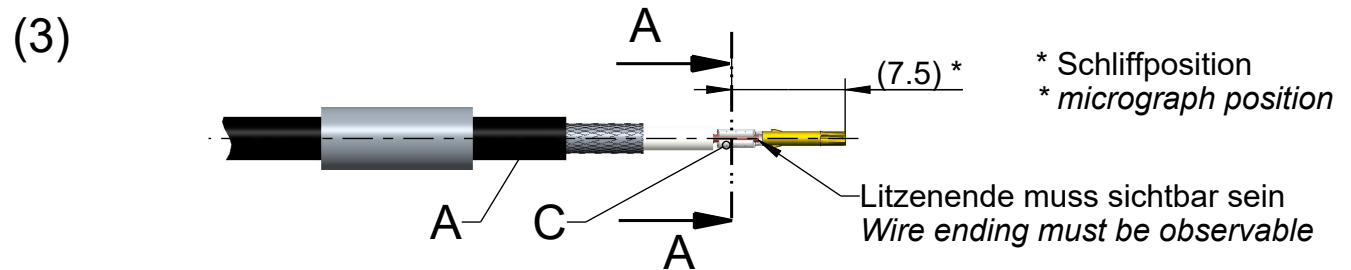
Teile Nummer <i>part number</i>	Kabelgruppe <i>cable group</i>	X	Y	Z
59K130-102XX-Y	02 / RG 174 02 / RG 316 02 / DACAR 462 02 / DACAR 107-2	9.7±0.2	4.6±0.2	3±0.2
59K130-103XX-Y	03 / RG 179 B/U-d 03 / 1.5DS-QFB (TA)	9.7±0.2	4.6±0.2	3±0.2
59K130-106XX-Y	06 / RG 58	11.2±0.2	4.6±0.2	3±0.2
59K130-1BSXX-Y	BS / Shikoku 1.5DS-QEHBE M SH-131 BS / Shikoku 1.5DS-QEHB SH-030	9.7±0.2	4.6±0.2	3±0.2
59K130-1BYXX-Y	BY / TFC 4.0mm double braid	9.7±0.2	4.6±0.2	3±0.2
59K130-1D6XX-Y	D6 / DACAR 077	9.7±0.2	4.6±0.2	3±0.2
59K130-1D8XX-Y	D8 / B-75-1.7-2.7	9.7±0.2	4.6±0.2	3±0.2
59K130-1E4XX-Y	E4 / DACAR 037 E4 / Draka FL09YBCYW 1.1/2.9 DKB E4 / CommScope AMC-58 Low Loss EZ E4 / G & G 69337	11.2±0.2	4.6±0.2	2.6±0.2
59K130-1E7XX-Y	E7 / B-61-1.87-2.9	9.7±0.2	4.6±0.2	3±0.2
59K130-1M4XX-Y	M4 / RTK 031	9.7±0.2	4.6±0.2	3±0.2
59K130-1S8XX-Y	S8 / 3C - 2V	9.7±0.2	4.6±0.2	3±0.2

Rosenberger	<i>general tolerance</i>	ISO 2768	<i>assembly instr.:</i>	scale: 3:1 (1:1)	<i>crimp insert:</i> ---
	mH		panel piercing: ---	series: ---	cable: ---
vertraulich / confidential			<i>date</i>	Montageanleitung assembly instruction	
<i>drawn</i>	04.03.2005	<i>name</i>	F_Neureiter		
<i>check</i>	15.05.2018		F_Repp		
<i>appr.</i>	21.12.2018		P_Blassfeld		
<i>date</i>					
u00	18-0698	C_Ostermaier	09.05.2018	<i>title:</i>	drawing-no.: MA_59V059
t00	16-v728	R_Gnodtke	11.07.2017		
s00	16-1305	J_Hegenauer	02.08.2016		of: 7
r00	16-0457	M_Kolbe	22.03.2016		
q00	15-1459	M_Kolbe	14.03.2016		
p00	14-0039	N_Naus	09.01.2014		
rev.	change-no	name	date	<i>remarks:</i>	

1 2 3 4

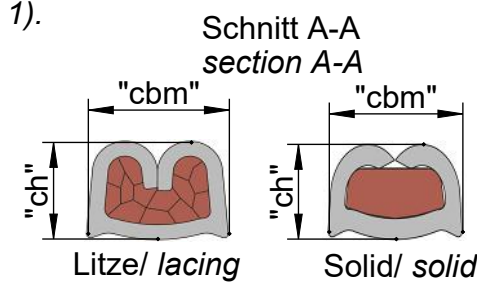
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1 2 3 4



Spule mit Innenleiter "C" in das Werkzeug einlegen. Blankes Ende des Kabels "A" in die Crimpzone des Innenleiters einlegen und Innenleiter "B" auf das Kabel crimpen (Werkzeug 1).
Load reel with center contacts "C" on the tool. Insert the blank end of the cable "A" into the crimp zone of the contact and crimp it onto the cable (tool 1).

Der "B-Crimp" ist nach DIN IEC 60352-2:2014-04 oder OEM Werksnorm auszuführen.
"B-crimp" according to DIN IEC 60352-2:2014-04 or OEM group standard.



Kabelgruppe cable group	Crimpmaße / crimp dimensions		Auszugskraft tensile strength
	Crimpbreite "cbm" crimp width "cbm"	Crimphöhe "ch" crimp height "ch"	
02 / RG 174 02 / RG 316 02 / DACAR 462 02 / DACAR 107-2	(1.15± 0.05) **	0.78± 0.03	>20N
03 / RG 179 B/U-d 03 / 1.5DS-QFB (TA)	(1.15± 0.05) **	0.78± 0.03	>20N
06 / RG 58	(1.32± 0.05) **	0.95± 0.03	>60N
BS / Shikoku 1.5DS-QEHBE M SH-131 BS / Shikoku 1.5DS-QEHB SH-030	(1.15± 0.05) **	0.78± 0.03	>20N
BY / TFC 4.0mm double braid	(1.35± 0.05) **	0.99± 0.03	>60N
D6 / DACAR 077	(1.15± 0.05) **	0.78± 0.03	>6N
D8 / B-75-1.7-2.7	(1.15± 0.05) **	0.78± 0.03	>12N
E4 / DACAR 037 E4 / Draka FL09YBCYW 1.1/2.9 DKB E4 / CommScope AMC-58 Low Loss EZ E4 / G & G 69337	(1.50± 0.05) **	1.1± 0.03	>60N
E7 / B-61-1.87-2.9	(1.15± 0.05) **	0.78± 0.03	>20N
M4 / RTK 031	Handtool	(1.34± 0.05) **	>60N
	Crimpapplicator	(1.34± 0.05) **	>60N
S8 / 3C - 2V	(1.15± 0.05) **	0.78± 0.03	>20N

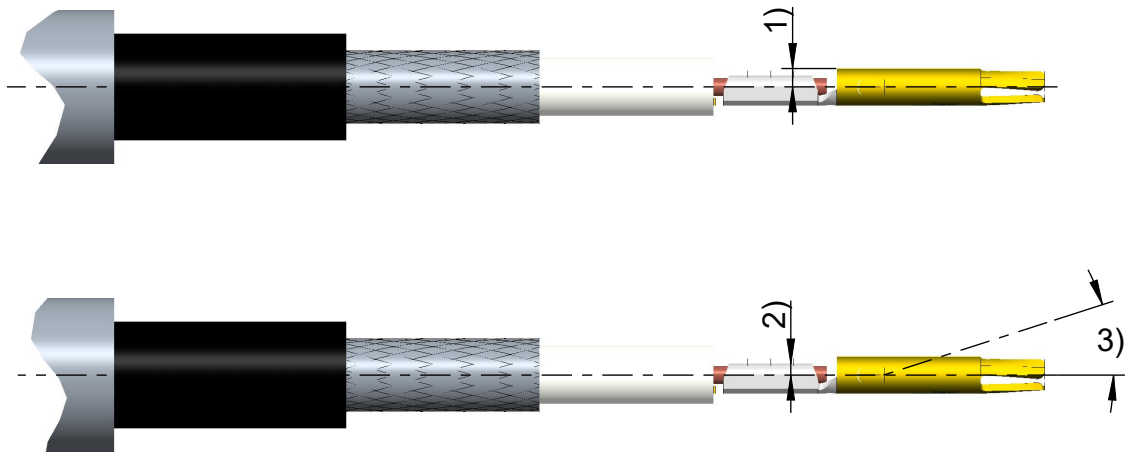
Die Steckerfunktion darf durch überstehende Einzeldrähte nicht beeinträchtigt werden!
The plug function may not be impaired by supernatant single wires! ** werkzeuggebunden
 ** tool related

Rosenberger		general tolerance ISO 2768 mH	assembly instr.: --- panel piercing: ---	scale: 2:1 (1:1) series: --- ---	crimp insert: --- cable: --- ---	
vertraulich / confidential				Montageanleitung assembly instruction		
		date	name			
u00	18-0698	C_Ostermaier	09.05.2018	drawn	04.03.2005	F_Neureiter
t00	16-v728	R_Gnodtke	11.07.2017	check	15.05.2018	F_Repp
s00	16-1305	J_Hegenauer	02.08.2016	appr.	21.12.2018	P_Blassfeld
r00	16-0457	M_Kolbe	22.03.2016			
q00	15-1459	M_Kolbe	14.03.2016			
p00	14-0039	N_Naus	09.01.2014			
rev.	change-no	name	date	drawing-no.: MA_59V059		
				sheet: 3		
				of: 7		
remarks: .						

PD_FB_01
-METRIC-
ISO-Projektion
Methode 1

1 2 3 4

(4)



Verarbeitungsanforderungen zur weiteren Montage in den Steckerkörper "D":

- 1) Die Einzelleitungen dürfen nicht überstehen.
- 2) Der Achsversatz des Crimps zum Kabel darf max. 0,3mm betragen.
- 3) Die maximale Auslenkung des Innenleiters ist abhängig von dem Konfektionsprozess. Es muss durch ordnungsgemäßes Einführen des Innenleiters sichergestellt werden, dass die Montage in den Außenleiter zuverlässig und kollisionsfrei durchgeführt werden kann.

Processing requirements for assembling into the plug body "D":

- 1) *Single wires must not overlap*
- 2) *The offset regarding to cable is allowed to be max. 0,3mm.*
- 3) *The maximum deflection of the inner conductor is dependent on the assembly process. It must be ensured by correct insertion of the inner conductor, that the assembling process into the outer conductor can be performed reliably and without collision.*

Rosenberger

general tolerance
 ISO 2768
 mH

assembly instr.:

 panel piercing:

scale: 5:1 (1:1)
 series: ---

crimp insert: ---
 cable: ---

vertraulich / confidential

		date	name
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s00	16-1305	02.08.2016	J_Hegenauer
r00	16-0457	22.03.2016	M_Kolbe
q00	15-1459	14.03.2016	M_Kolbe
p00	14-0039	09.01.2014	N_Naus
rev.	change-no	name	date

	date	name
drawn	04.03.2005	F_Neureiter
check.	15.05.2018	F_Repp
appr.	21.12.2018	P_Blassfeld

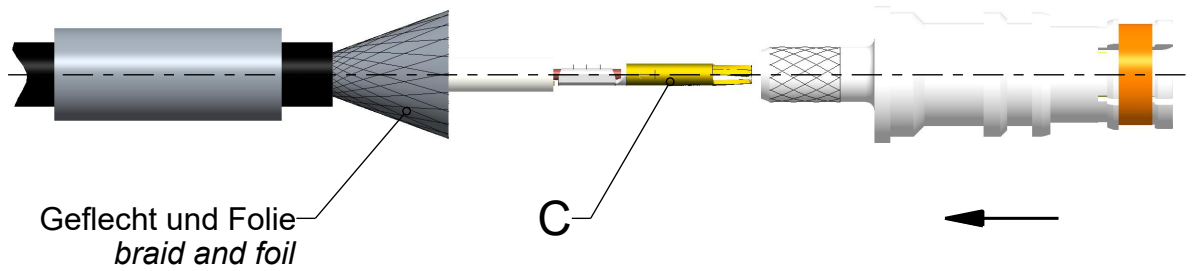
title: **Montageanleitung
 assembly instruction**

drawing-no.: **MA_59V059**

sheet:
 4
 of: 7

1 2 3 4

(5)



Geflecht und Folie
braid and foil

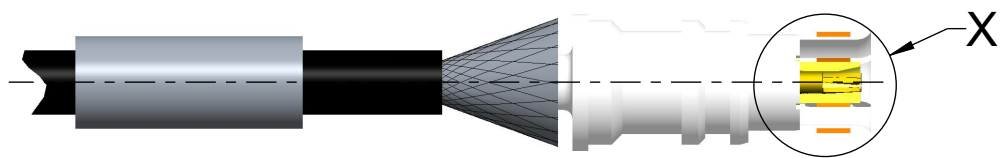
Geflecht und Folie aufweiten.
 Der Innenleiter "C" darf dabei nicht verbogen werden.

*Splay out the braid and the foil.
 Don't bend the center contact "C" during expanding!*

Alternativ/ alternative:
 Geflecht aufweiten und Folie entfernen.
 Der Innenleiter "C" darf dabei nicht verbogen werden.

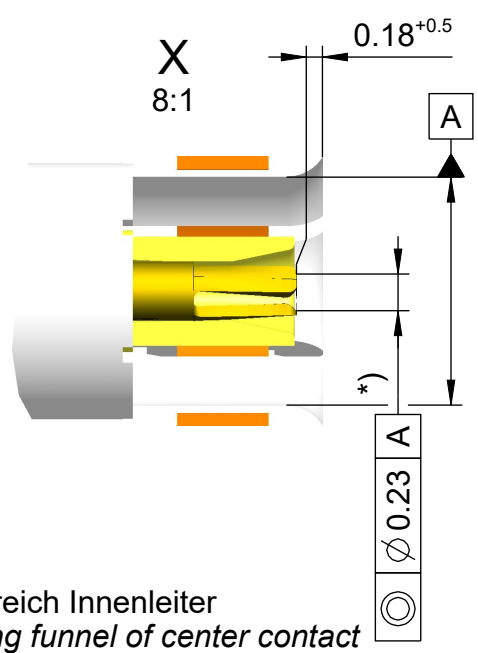
*Splay out the braid and cut and remove the foil.
 Don't bend the center contact "C" during expanding!*

(6)



Vorbereitetes Kabel in den Steckerkörper "D" einschieben bis der Innenleiter spürbar einrastet und das Kontaktstückmaß $0.18^{+0.5}$ erreicht ist. Rotation um die Längsachse ist zu vermeiden, wechselseitiges Rotieren ist nicht erlaubt. Verrastung durch leichten Zug am Kabel (max. 5N) testen. (Einschubkraft 20N max.; Haltekraft 10N min.)

Push the prepared cable into the connector body "D" until the center contact engages perceptible and the interface dimension $0.18^{+0.5}$ is attained. Rotation around the long axis should be avoided, alternating rotation is prohibited. Test the captivation by slightly pulling the cable (5N max.) (insertion force 20N max.; retaining force 10N min.)

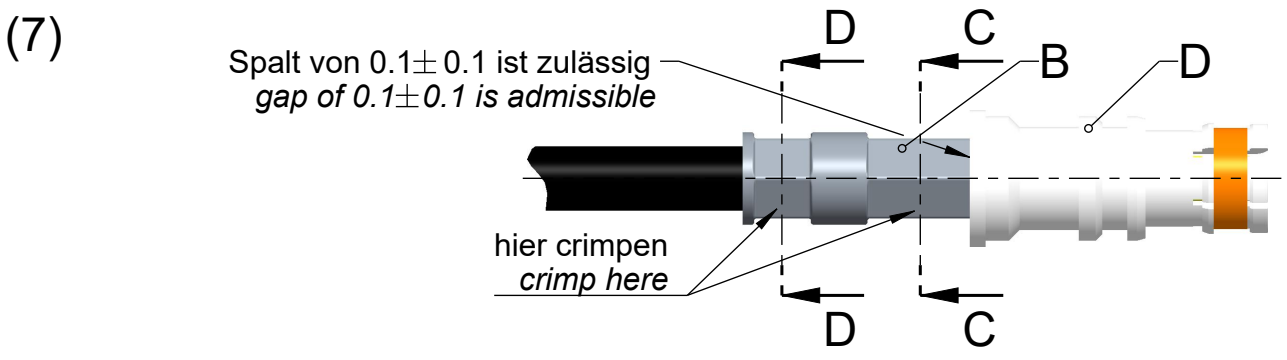


*) Fangbereich Innenleiter
 *) Capturing funnel of center contact

Rosenberger		general tolerance		assembly instr.: ---		scale: 3:1 (1:1)		crimp insert: ---	
		ISO 2768 mH		panel piercing: ---		series: ---		cable: ---	
vertraulich / confidential				date		name		title: Montageanleitung assembly instruction	
u00 18-0698		C_Ostermaier		09.05.2018		F_Neureiter			
t00 16-v728		R_Gnodtke		11.07.2017		F_Repp			
s00 16-1305		J_Hegenauer		02.08.2016					
r00 16-0457		M_Kolbe		22.03.2016					
q00 15-1459		M_Kolbe		14.03.2016				drawing-no.: MA_59V059	
p00 14-0039		N_Naus		09.01.2014					
rev. change-no		name		date		remarks: .		sheet: 5 of: 7	

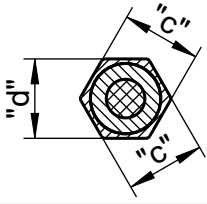
1 2 3 4

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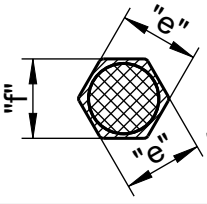


Crimphülse "B" über das Geflecht bis an den Steckerkörper "D" heranschieben und möglichst nahe am Steckerkörper crimpen (Werkzeug 2). Das Kontakttrückstandsmaß $0.18^{+0.5}$ muss weiterhin erfüllt werden.

Slide crimping sleeve "B" over the braid up to the connector body "D" as close to the connector body as possible and crimp it (tool 2). The interface dimension $0.18^{+0.5}$ still has to be accomplished.



Schnitt C-C
section C-C



Schnitt D-D
section D-D

** Werkzeuggebunden
** tool related

Kabelgruppe cable group	Crimpmaße / crimp dimensions				Auszugskraft tensile strength
	C-C Crimpmaße C-C crimp dimensions		D-D Crimpmaße D-D crimp dimensions		
	"c"	"d"	"e"	"f"	
02 / RG 174 02 / RG 316 02 / DACAR 462 02 / DACAR 107-2	$(3.3 \pm 0.05)^{**}$	3.3 ± 0.05	$(3.5 \pm 0.05)^{**}$	3.5 ± 0.05	>110N
03 / RG 179 B/U-d 03 / 1.5DS-QFB (TA)	$(3.3 \pm 0.05)^{**}$	3.3 ± 0.05	$(3.3 \pm 0.05)^{**}$	3.3 ± 0.05	>110N
06 / RG 58	$(5.5 \pm 0.1)^{**}$	5.5 ± 0.1	N.A.	N.A.	>110N
BS / Shikoku 1.5DS-QEHBE M SH-131 BS / Shikoku 1.5DS-QEHB SH-030	$(3.63 \pm 0.05)^{**}$	3.63 ± 0.05	N.A.	N.A.	>110N
BY / TFC 4.0mm double braid	$(5.35 \pm 0.1)^{**}$	5.35 ± 0.1	$(5.35 \pm 0.1)^{**}$	5.35 ± 0.1	>110N
D6 / DACAR 077	$(5.5 \pm 0.1)^{**}$	5.5 ± 0.1	N.A.	N.A.	>110N
D8 / B-75-1.7-2.7	$(3.3 \pm 0.05)^{**}$	3.3 ± 0.05	$(3.5 \pm 0.05)^{**}$	3.5 ± 0.05	>110N
E4 / DACAR 037 E4 / Draka FL09YBCYW 1.1/2.9 DKB E4 / CommScope AMC-58 Low Loss EZ E4 / G & G 69337	$(5.5 \pm 0.1)^{**}$	5.5 ± 0.1	N.A.	N.A.	>110N
E7 / B-61-1.87-2.9	$(3.3 \pm 0.05)^{**}$	3.3 ± 0.05	$(3.5 \pm 0.05)^{**}$	3.5 ± 0.05	>110N
M4 / RTK 031	$(4.3 \pm 0.05)^{**}$	4.3 ± 0.05	N.A.	N.A.	>110N
S8 / 3C - 2V	$(5.5 \pm 0.1)^{**}$	5.5 ± 0.1	N.A.	N.A.	>110N

Rosenberger

general tolerance
ISO 2768
mH

assembly instr.:

panel piercing:

scale: 3:1 (1:1)
series: ---

crimp insert: ---
cable: ---

vertraulich / confidential

rev.	change-no	name	date
u00	18-0698	C_Ostermaier	09.05.2018
t00	16-v728	R_Gnodtke	11.07.2017
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date	name
04.03.2005	F_Neureiter
15.05.2018	F_Repp
21.12.2018	P_Blassfeld

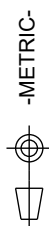
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assembly instruction**

drawing-no.: **MA_59V059**

sheet: 6
of: 7

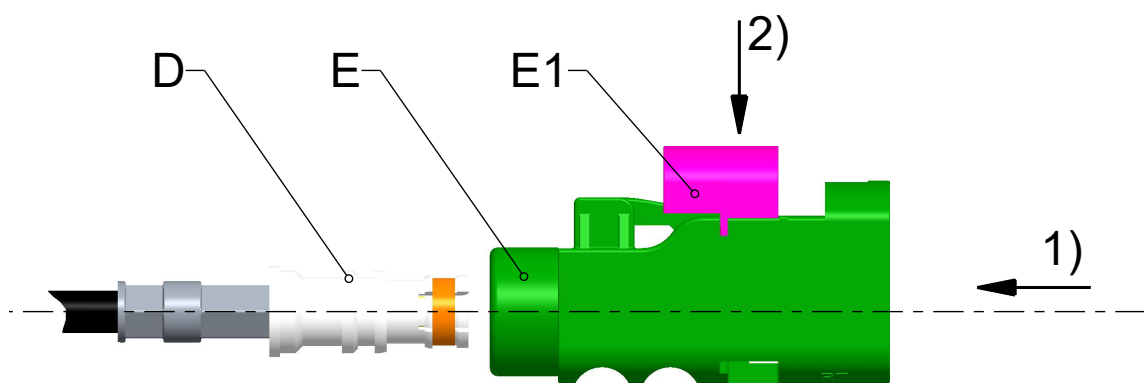
remarks: .

ISO-Projektion
Methode 1



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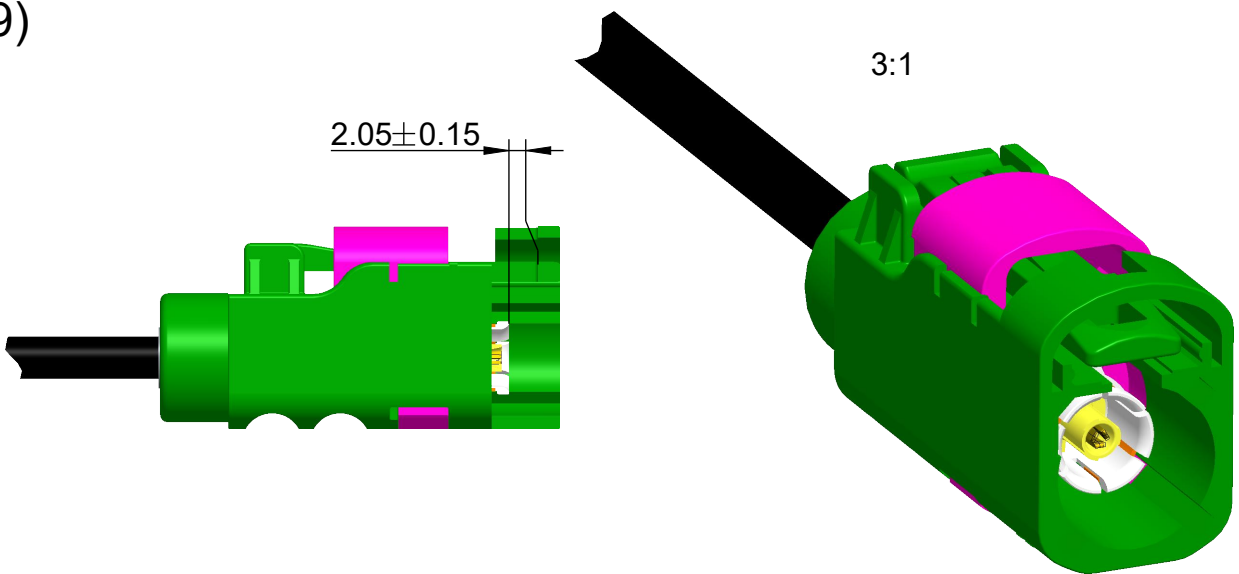
(8)



- 1) Steckerkörper "D" mit angecrimpten Kabel in Gehäuse "E" einführen bis Kontakt spürbar einrastet und das Kontaktrückstandsmaß 2.05 ± 0.15 erreicht ist.
- 2) Sekundärsicherung "E1" vollständig bis zur spürbaren Verrastung eindrücken.

1) Push in the connector body "D" with cable into the plastic housing "E" until the insert engages perceptible and the interface dimension 2.05 ± 0.15 is attained.
 2) Push secondary lock "E1" completely until stop.

(9)



Darstellung zeigt montierten Zustand.
 Drawing shows connector fully assembled.

Rosenberger

general tolerance
 ISO 2768
 mH

assembly instr.:

 panel piercing:

scale: 2:1 (1:1)
 series: ---
 crimp insert: ---
 cable: ---

vertraulich / confidential

rev.	change-no	name	date
u00	18-0698	C_Ostermaier	09.05.2018
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date	name
04.03.2005	F_Neureiter
15.05.2018	F_Repp
21.12.2018	P_Blassfeld

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 assembly instruction**

drawing-no.: **MA_59V059**

sheet: 7
 of: 7

remarks: .

ISO-Projektion Methode 1
 -METRIC-
 PD_FB_01