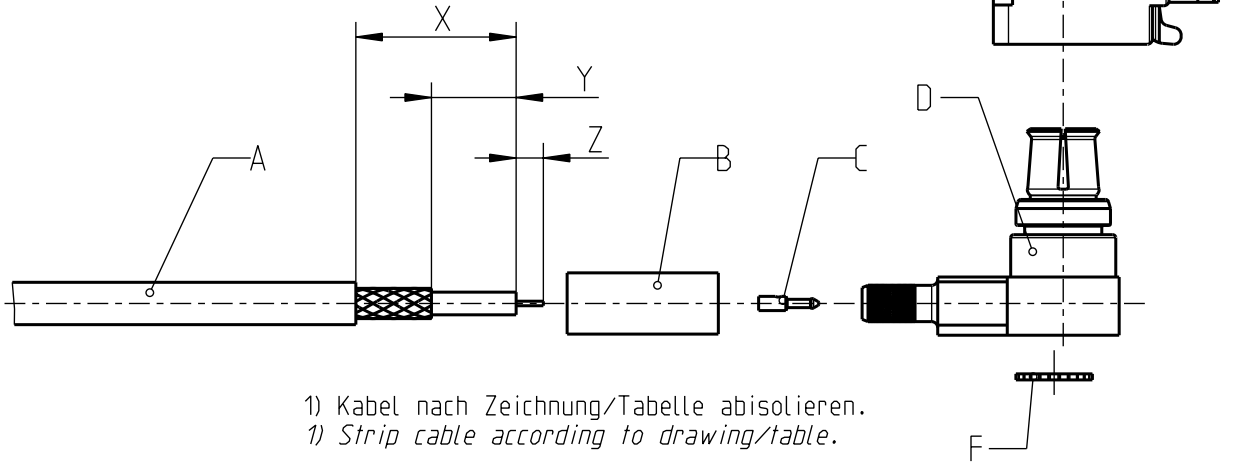


(1)

Montageschritte 2 bis 5 siehe naechste Seite.  
Assembly steps 2 to 5 see on the next page.



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

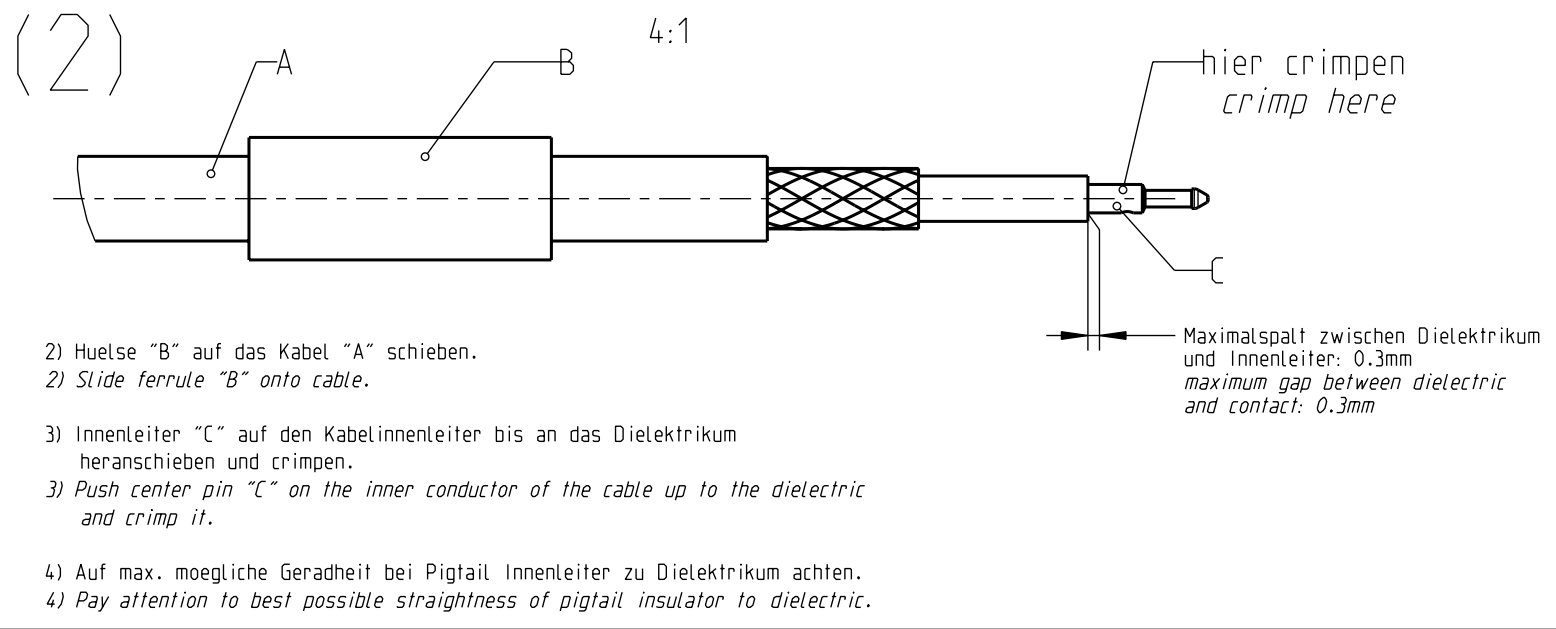
- \* Kodierung und Oberflaechen siehe Datenblatt.
- \* Surface and coding vide technical data sheet.
- \*\* Crimpbacke fuer Innenleiter
- \*\* Crimp die for center contact
- \*\*\* Crimpbacke fuer Aussenleiter
- \*\*\* Crimp die for outer contact

1\* Empfohlenes Werkzeugmass  
1\* recommended crimping tool dimension

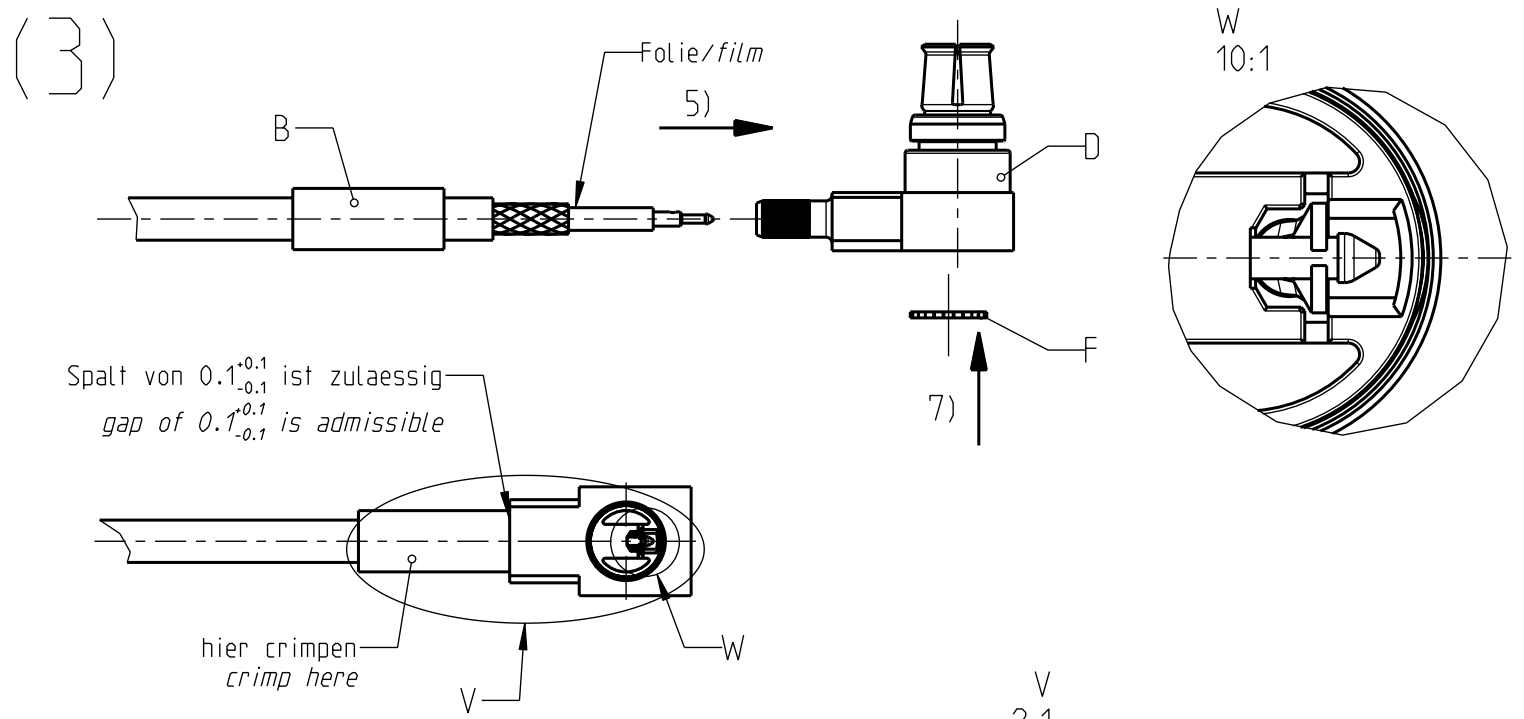
59K25H-1AGXX-Y*	RG 58 RG 174/ RG 316	13.1 <sup>+0.2</sup> <sub>-0.2</sub>	6.4 <sup>+0.2</sup> <sub>-0.2</sub>	1.7 <sup>+0.2</sup> <sub>-0.2</sub>	11W 150-402** 11W 150-508***	hex.:5.5 <sub>-0.05</sub>	□ 0.73 <sub>-0.03</sub>
59K25H-1E4XX-Y*	G & G 69337	13.1 <sup>+0.2</sup> <sub>-0.2</sub>	6.4 <sup>+0.2</sup> <sub>-0.2</sub>	1.7 <sup>+0.2</sup> <sub>-0.2</sub>	11W 15F-5E4	hex.:5.5 <sub>-0.05</sub>	□ 1.3 <sub>-0.03</sub>
59K25H-1E4XX-Y*	LEONI Dacar 037; Draka FLO9YBCYW 1.1/2.9 DKB	13.1 <sup>+0.2</sup> <sub>-0.2</sub>	6.4 <sup>+0.2</sup> <sub>-0.2</sub>	1.7 <sup>+0.2</sup> <sub>-0.2</sub>	11W 15F-5E4	hex.:5.5 <sub>-0.05</sub>	□ 1.3 <sub>-0.03</sub>
59K25H-110XX-Y*	RG62	7.5 <sup>+0.2</sup> <sub>-0.2</sub>	1 <sup>+0.2</sup> <sub>-0.2</sub>	1.7 <sup>+0.2</sup> <sub>-0.2</sub>	11W 150-509	hex.:6.5 <sub>-0.05</sub>	□ 1.1 <sub>-0.03</sub>
59K25K-1E4XX-Y*	LEONI Dacar 037; Draka FLO9YBCYW 1.1/2.9 DKB	12.2 <sup>+0.2</sup> <sub>-0.2</sub>	5.5 <sup>+0.2</sup> <sub>-0.2</sub>	1.7 <sup>+0.2</sup> <sub>-0.2</sub>	11W 15S-5E4	hex.:5.5 <sub>-0.05</sub>	□ 1.3 <sub>-0.03</sub>
59K25C-1M4XX-Y* 59K25H-1M4XX-Y*	RTK031	11.6 <sup>+0.2</sup> <sub>-0.2</sub>	6.4 <sup>+0.2</sup> <sub>-0.2</sub>	1.7 <sup>+0.2</sup> <sub>-0.2</sub>	11W 150-504	hex.:4.3 <sub>-0.05</sub>	□ 1.1 <sub>-0.03</sub>
59K25C-106XX-Y* 59K25H-106XX-Y*	RG58	13.1 <sup>+0.2</sup> <sub>-0.2</sub>	6.4 <sup>+0.2</sup> <sub>-0.2</sub>	1.7 <sup>+0.2</sup> <sub>-0.2</sub>	11W 150-508	hex.:5.5 <sub>-0.05</sub>	□ 1.1 <sub>-0.03</sub>
59K25H-103XX-Y*	RG 179 B/U-d 1.5 DS	11.2 <sup>+0.2</sup> <sub>-0.2</sub>	6.0 <sup>+0.2</sup> <sub>-0.2</sub>	1.7 <sup>+0.2</sup> <sub>-0.2</sub>	11W 150-402** 11W 15B-503***	hex.:3.3 <sub>-0.03</sub>	□ 0.73 <sub>-0.03</sub>
59K25C-102XX-Y* 59K25H-102XX-Y*	RG 174 RG 316	11.2 <sup>+0.2</sup> <sub>-0.2</sub>	6.0 <sup>+0.2</sup> <sub>-0.2</sub>	1.7 <sup>+0.2</sup> <sub>-0.2</sub>	11W 150-402	hex.:3.3 <sub>-0.03</sub>	□ 0.73 <sub>-0.03</sub>
59K25C-1K4XX-Y*	Z7S MD 227035	13.1 <sup>+0.2</sup> <sub>-0.2</sub>	6.4 <sup>+0.2</sup> <sub>-0.2</sub>	1.7 <sup>+0.2</sup> <sub>-0.2</sub>	11W 150-508	hex.:5.5 <sub>-0.05</sub>	□ 1.1 <sub>-0.03</sub>
Coax-Insert	Cabel	X	Y	Z	Crimpdie	Outerdim. 1*	Innerdim. 1*

<b>Rosenberger</b>		general tolerance	assembly instr.:	scale:	crimp insert:
		ISO 2768	---	2:1 ( )	---
		mH	panel piercing:	series:	cable:
			---	---	---
r00	14-1556	T_Koschel	27.10.2014	<b>Montageanleitung</b> <i>assembly instruction</i>	
q00	14-0039	N_Naus	09.01.2014		
p00	13-1291	M2_Mueller	14.11.2013		
o00	13-0637	M_Kotewitz	17.06.2013		
n00	13-s066	M_Kotewitz	22.05.2013		
m00	13-0335	R_Hochheim	27.03.2013		
l00	12-0289	A_Zaan	21.09.2012	drawing-no.: MA_59V065	
k00	12-0418	A_Kott	14.05.2012	sheet: 1	
rev.	change-no	name	date	of: 2	
remarks: .					

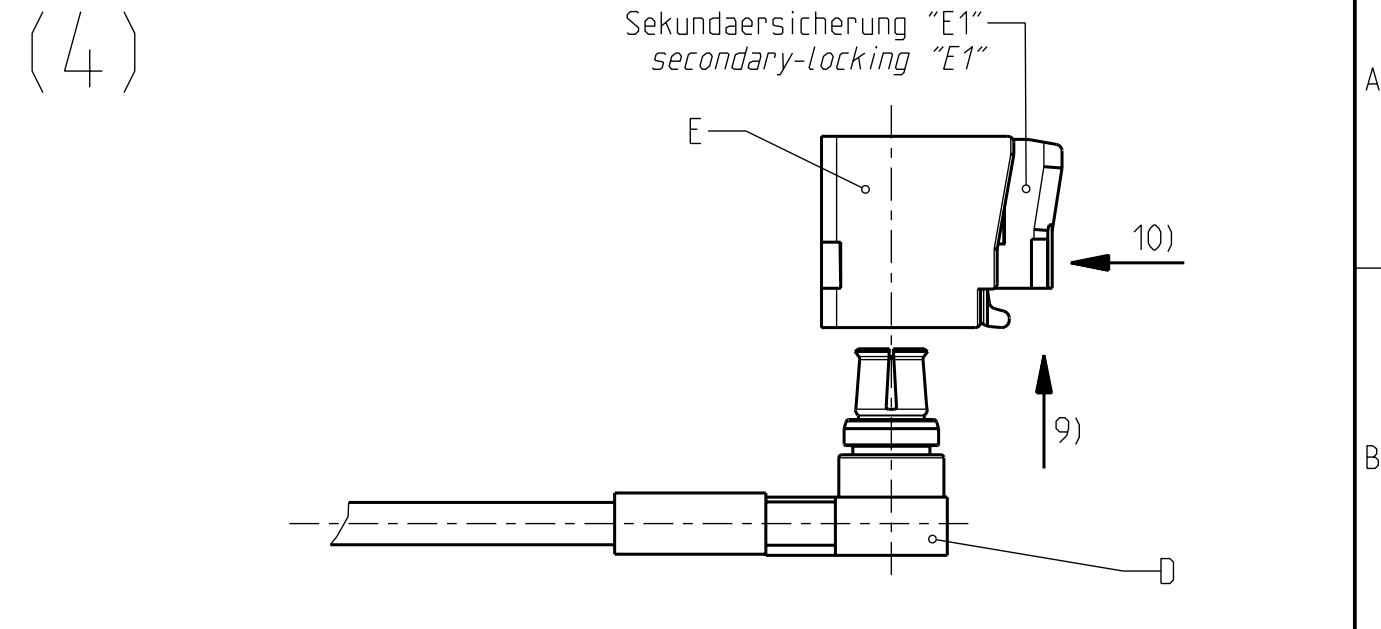
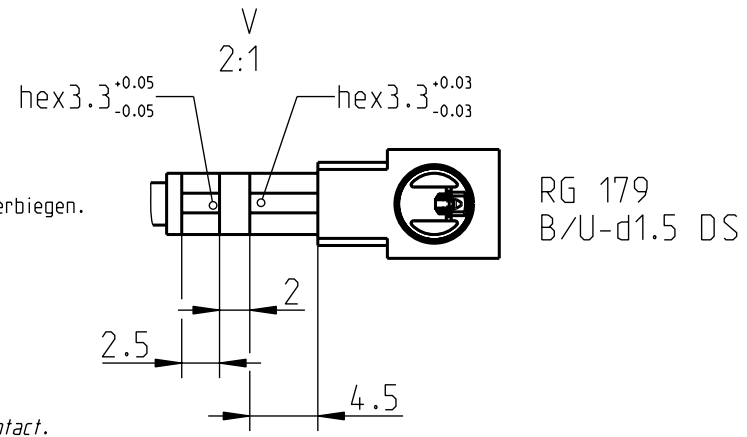
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 fuer diese technische Unterlage behalten wir uns alle Rechte vor (DIN 34)  
 Formblatt: TCC\_FB\_08\_DE\_A3\_Baugruppe  
 Plaid: 1:1\_Gesamt  
 Datei: A3\_06SAM17\_VZ-1.FRM  
 Version: 2.1  
 Dimensions in mm  
 ISO-Projektion Methode 1



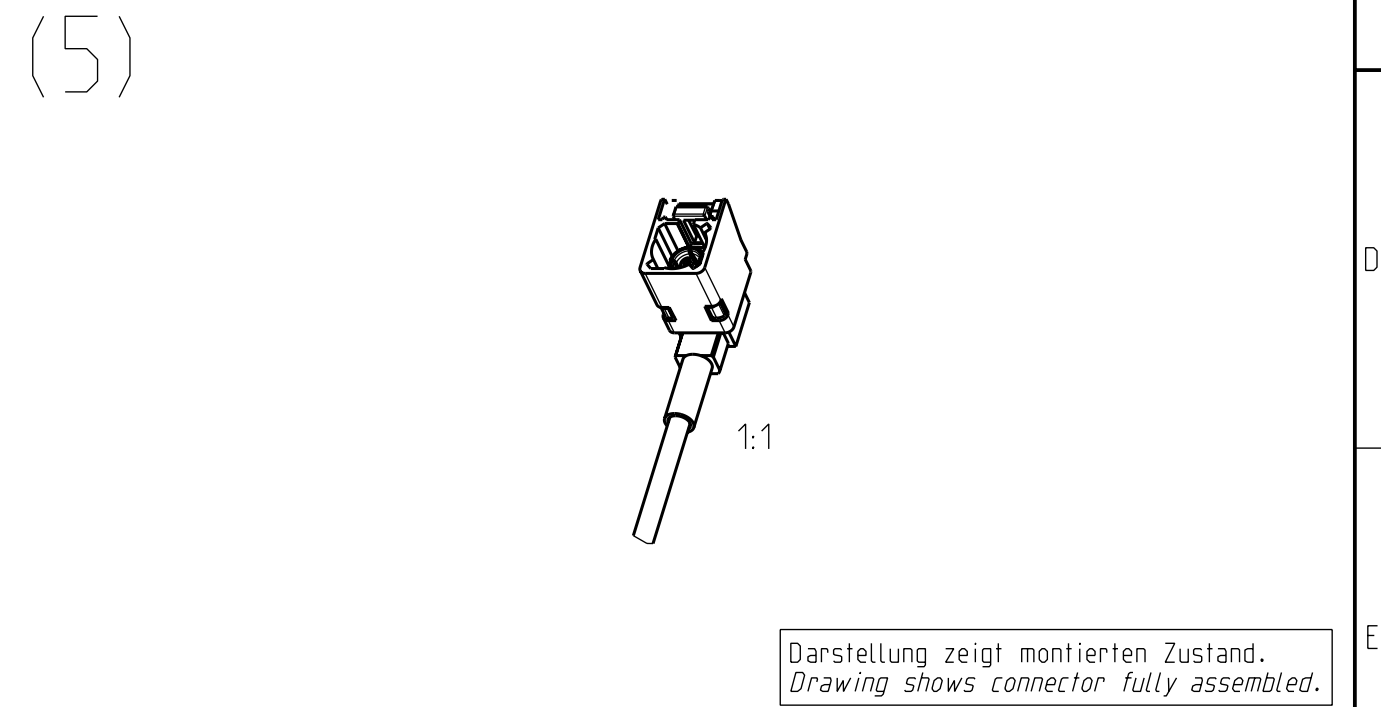
- 2) Hülse "B" auf das Kabel "A" schieben.  
2) Slide ferrule "B" onto cable.
- 3) Innenleiter "C" auf den Kabelinnenleiter bis an das Dielektrikum heranschieben und crimpen.  
3) Push center pin "C" on the inner conductor of the cable up to the dielectric and crimp it.
- 4) Auf max. moegliche Geradheit bei Pigtail Innenleiter zu Dielektrikum achten.  
4) Pay attention to best possible straightness of pigtail insulator to dielectric.



- 5) Geflecht aufweiten  
Bei Kabelgruppe E4: Pigtail Innenleiter "C" waehrend des Aufweiten nicht verbiegen.  
5) Splay out the braid  
At cable group E4: don't bend the pigtail contact "C" during expanding.
- 6) Kabelende in den Steckerkoerper "D" einschieben, bis Innenleiter spuerbar einrastet (Spitze des Kontaktes muss gut sichtbar ueber den Mittelkontakt hinausragen).  
6) Insert the cable into the connector body "D" until the centerpin engages perceptible (Top of the contact must visibly protrude through the centre contact.)
- 7) Crimphülse "B" ueber das Geflecht bis an den Steckerkoerper heranschieben und moeglichst nahe am Steckerkoerper festcrimpen.  
7) Slide ferrule "B" over the braid up to the connector body and as close to the connector body as possible.
- 8) Oeffnung mit Deckel "F" verschließen. (buendig mit Aussenleiter verpresst.)  
8) Press cover "F" into the rear opening of the connector body. (justified pressed in outer contact.)
- 9) Auflageflaeche fuer die Verpressung des Deckels.  
9) Base for to press the cap.



- 10) Steckerkoerper "D" mit angecrimpten Kabel in Gehaeuse "E" einfuehren, bis Kontakt spuerbar einrastet.  
10) Push in the connector body "D" with cable in the shell body "E" until the insert engages perceptibly.
- 11) Sekundaersicherung "E1" vollstaendig bis zur spuerbaren Verrastung eindruecken.  
11) Secondary-locking "E1" has to push-in completely until stop.



<b>Rosenberger</b>				general tolerance	assembly instr.:	scale: 2:1 ( )	crimp insert: ---
				ISO 2768 mH	---	series: ---	cable: ---
					panel piercing: ---	---	---
r00	14-1556	T_Koschel	27.10.2014	date	name	title: Montageanleitung assembly instruction	
q00	14-0039	N_Naus	09.01.2014	drawn	02.08.2005	T_OberschelP	
p00	13-1291	M2_Mueller	14.11.2013	check	27.10.2014	M_Singhammer	
o00	13-0637	M_Kotewitz	17.06.2013	appr.	27.10.2014	T_Bredbeck	
n00	13-s066	M_Kotewitz	22.05.2013				
m00	13-0335	R_Hochheim	27.03.2013				
l00	12-0289	A_Zaan	21.09.2012				
k00	12-0418	A_Kott	14.05.2012				
rev.	change-no	name	date				
						drawing-no.: MA_59V065	sheet: 2
						remarks: .	of: 2