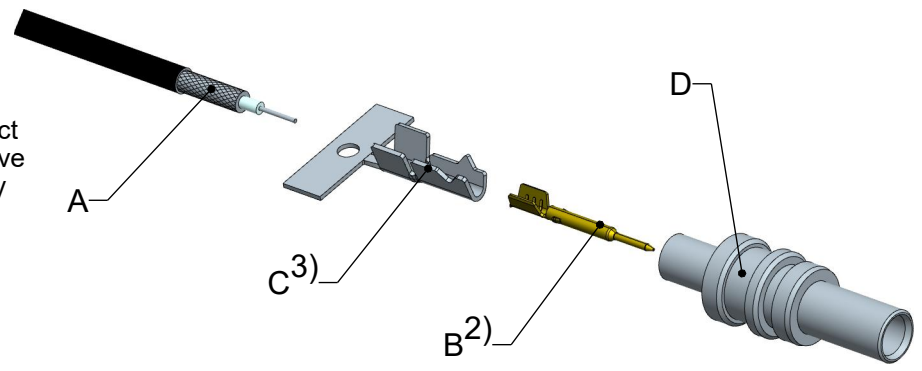


A = Kabel / cable  
 B = Innenleiter / center contact  
 C = Stützhülse / support sleeve  
 D = Steckerkörper / jack body

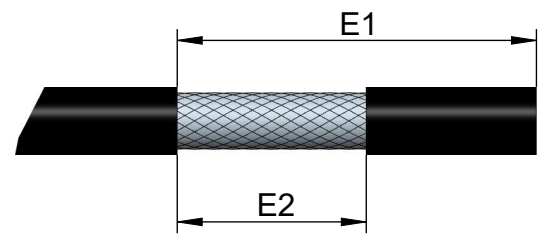


	Werkzeug 1 tool 1	Werkzeug 2 tool 2	Werkzeug 3 tool 3
RG178	11WB078	11W150-101	11WS017
RTK 013	11WB079	11W150-101	11WS012

f00

2) Auf Spule zu 500, 5000 oder 20000 St. geliefert. / supplied on reels of 500. 5000 or 20000 pcs.  
 3) Auf Spulen zu 5000 St. geliefert. / supplied on reels of 5000 pcs.

1.)



(Teilabzug)  
(partial remove)

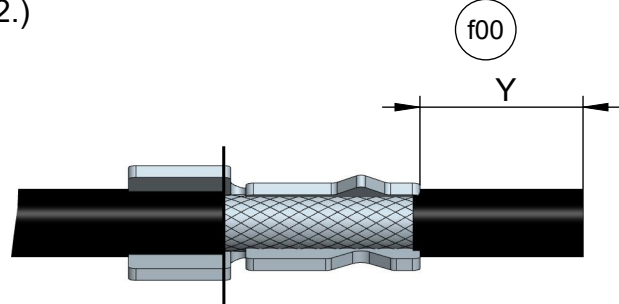
1.) Kabelmantel "A" nach Zeichnung einschneiden und auf Maß abziehen. (Teilabzug)

Cut cable "A" jacked according to drawing. (Partial remove)

e00 f00

	RG 178	RTK 013
E1	9.8 + 0.3	9.5 + 0.2
E2	Min 5.0	Min 5.0

2.)



f00

2.) Stützhülse "C" bündig zum Kabelmantel mit Werkzeug 3 aufcrimpen. Crimp support sleeve "C" with tool 3 flush to the jacked.

	RG 178	RTK 013
Drahtcrimphöhe wire crimp height	1.94 ± 0.05	1.81 ± 0.02
Drahtcrimpbreite wire crimp width	1.94 ± 0.05	1.91 ± 0.03
Isocrimphöhe insulation crimp height	2.44 ± 0.05	1.90 ± 0.03
Isocrimpbreite insulation crimp width	2.44 ± 0.05	2.00 ± 0.03
Auszugskraft/ retention force	50N	30N
Maß Y Dimension Y	4.8 ± 0.2	4.5 ± 0.2

**Rosenberger**

general tolerance  
ISO 2768  
mH

assembly instr.:  
MA\_59V086  
panel piercing:  
---

scale: 5:1 (1:1)  
series: FAKRA-HF  
DIN 72594

crimp insert: f00  
cable: RG 178  
RTK 013 f00

vertraulich / confidential


g00	20-1166	S_Guggenberg	07.07.2020
f00	19-1667	J2_Engelhard	16.04.2020
e00	18-2341	J2_Engelhard	14.12.2018
d00	18-1399	J2_Engelhard	05.09.2018
c00	16-1271	M_Volkmar	27.07.2016
b00	13-1354	C_Biermann	20.11.2013
rev.	change-no	name	date

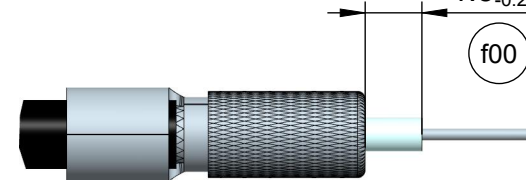
date	name
17.04.2008	M_Ruf
08.07.2020	F_Repp
14.07.2020	F_Danzl

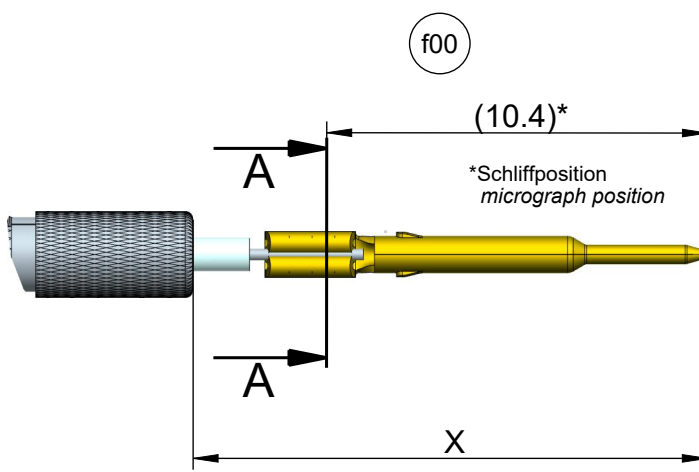
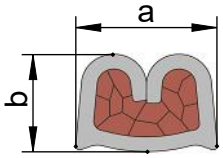
title: **Montageanleitung  
assembly instruction**

drawing-no.: MA\_59V086  
sheet: 1  
of: 3

1 2 3 4

3.)  3.) Eingeschnittenen Kabelmantel abziehen, Kabelgeflecht über Crimphülse "C" zurückschlagen.  
 Remove the cable jacket, strike back the cable braid over support sleeve "C".

4.)  4.) Kabel nach Zeichnung nachsetzen.  
 Cut back insulation by drawing.  $1.5^{+0.2}_{-0.2}$  (f00)

5.)  5.) Innenleiter "B" mit Werkzeug 1 aufcrimpen.  
 Crimp the center contact "B" with tool 1 onto the cable.  
 (f00) (10.4)\*  
 \*Schliffposition micrograph position  
 Schnitt A-A section A-A  
 (f00)  
 Litze/ lacing  
 a) Werkzeuggebundenes Maß:  
 Die ausziehkräfte des Leiters müssen EN IEC 60352-2 erfüllen.  
 a) Depending on the crimp tool:  
 Cable retention force must fulfill EN IEC 60352-2.

(f00) (g00) (e00)

RG 178	11WB078	0.9±0.05	0.74±0.03	13.7±0.2	6 N
RTK 013	11WB079	0.9±0.05	0.71±0.03	13.7±0.2	6 N
Kabel Cable	Werkzeug 1 tool 1	a	b	X	Augszugskraft retention force

**Rosenberger** general tolerance ISO 2768 mH assembly instr.: MA\_59V086 panel piercing: --- scale: 5:1 (1:1) crimp insert: (f00) series: FAKRA-HF DIN 72594 cable: RG 178 RTK 013 (f00)

**vertraulich / confidential**

rev.	change-no	name	date	date	name
g00	20-1166	S_Guggenberg	07.07.2020	17.04.2008	M_Ruf
f00	19-1667	J2_Engelhard	16.04.2020	08.07.2020	F_Repp
e00	18-2341	J2_Engelhard	14.12.2018	14.07.2020	F_Danzl
d00	18-1399	J2_Engelhard	05.09.2018		
c00	16-1271	M_Volkmar	27.07.2016		
b00	13-1354	C_Biermann	20.11.2013		

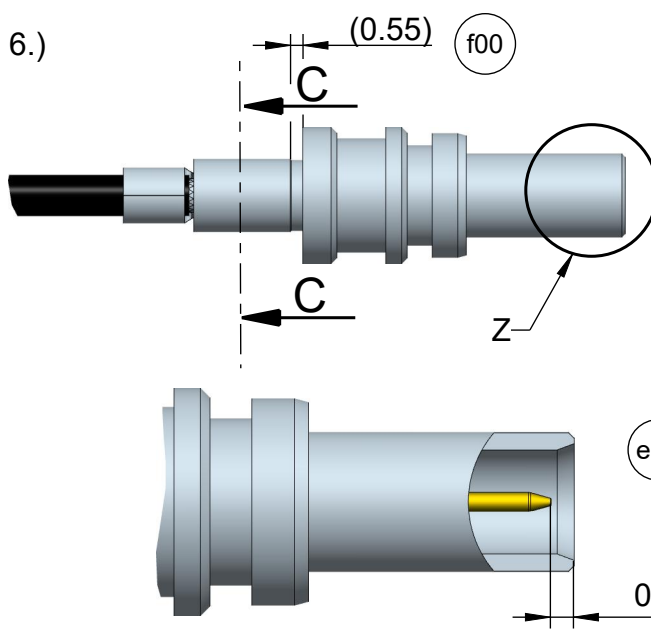
title: **Montageanleitung assembly instruction**

drawing-no.: MA\_59V086 sheet: 2 of: 3

remarks: .

1 2 3 4

1 2 3 4



6.) Vorbereitetes Kabel mit aufgedrimptem Innenleiter in den Steckkörper "D" einschieben bis Anschlußmaß erreicht wird, dann mit Werkzeug 2 crimpen.

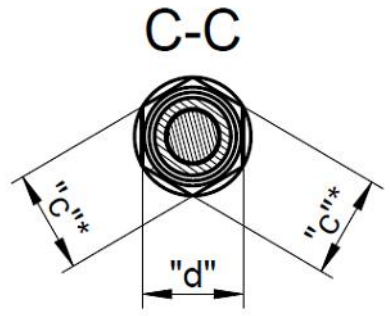
*Push prepared cable with the crimped center contact into the plug body until the connection dimension is reached, then crimp it with tool 2.*

Ansicht: Z  
View: Z

\* werkzeuggebunden  
tool related

e00 f00

Kabelgruppe cabel group	Crimphöhe crimp height		Auszugskraft tensile strength	Tool2
	C-C Crimpmaße C-C Crimp dimensions			
	"c"	"d"		
RG 178 B/U	(2.75 ± 0.05)*	2.75 ± 0.05	>70N	11W150-101
RTK 013	(2.75 ± 0.05)*	2.75 ± 0.05	>40N	11W150-101



Rev.	Change
e00	- dimension changed from 9.5+0.3 to 9.8+0.3 - arranged tables under step 5) and 6) - representation and dimensioning of center contact to outer contact
f00	- change of tables, RTK013 added - dimension "Y" added - dimension of insulation cut 1.5±0.2 added - translation corrected - view of center contact corrected - dimension "X" added - crimp position (0.55) added - crimp insert removed and cable added
g00	- coax-insert removed - crimp dimension b switched

<b>Rosenberger</b>		general tolerance ISO 2768 mH	assembly instr.: MA_59V086 panel piercing: ---	scale: 5:1 (1:1)	crimp insert: cable: RG 178 RTK 013
<b>vertraulich / confidential</b>		date	name	title: <b>Montageanleitung assembly instruction</b>	
g00	20-1166	S_Guggenberg	07.07.2020	drawn	M_Ruf
f00	19-1667	J2_Engelhard	16.04.2020	check.	08.07.2020 F_Repp
e00	18-2341	J2_Engelhard	14.12.2018	appr.	14.07.2020 F_Danzl
d00	18-1399	J2_Engelhard	05.09.2018		
c00	16-1271	M_Volkmar	27.07.2016		
b00	13-1354	C_Biermann	20.11.2013		
rev.	change-no	name	date	drawing-no.: MA_59V086	
				sheet:	3
				of:	3
remarks: .					

1 2 3 4