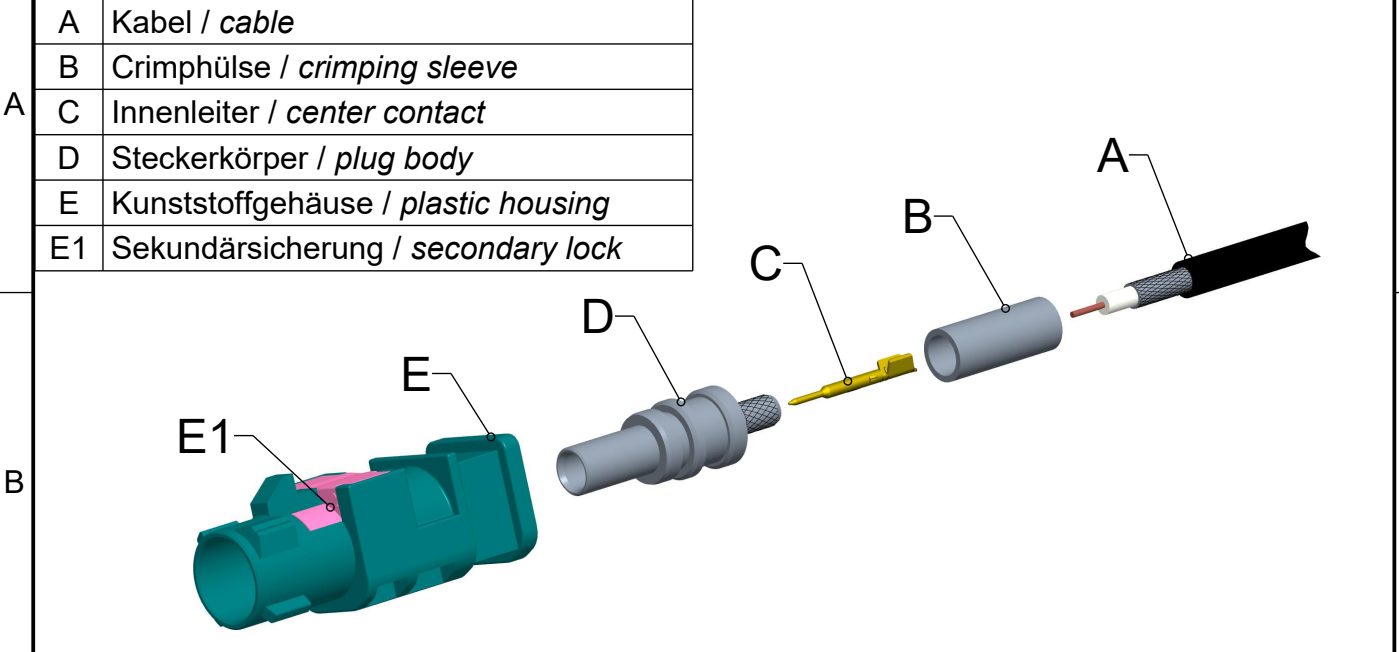


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1 2 3 4



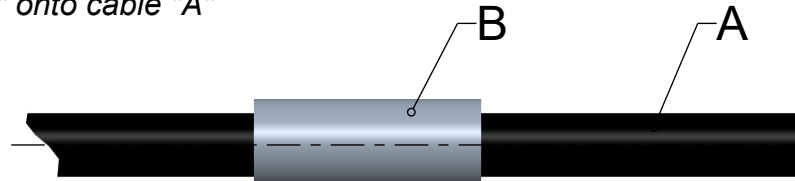
Teile Nummer <i>part number</i>	Kabelgruppe <i>cable group</i>	Werkzeug 1 <i>tool 1</i>	Werkzeug 2 <i>tool 2</i>
59S100-102XX-Y	02 / RG 174 02 / RG 316 02 / DACAR 462	11W161-800	11W150-302
59S100-103XX-Y	03 / RG 179 B/U-d 03 / 1.5DS-QFB (TA)	11W161-800	11W15B-503
59S100-106XX-Y	06 / RG 58	11W161-806	11W150-108
59S100-1BAXX-Y	BA / AMC 4.0	11W161-8M4	11W15W-5BA
59S100-1BFXX-Y	BF / Shikoku 2DS-PPFW	11W161-8M4	11W15W-5BA
59S100-1BSXX-Y	BS / Shikoku 1.5DS-QEHBE M SH-131 BS / Shikoku 1.5DS-QEHB SH-030	11WB016_A01	11WM012
59S100-1BYXX-Y	BY / TFC 4.0mm double braid	11WB034	11W15W-5BA
59S100-1D6XX-Y	D6 / DACAR 077	11W161-801	11W150-108
	D6 / DACAR 200	11W161-800	
59S100-1D8XX-Y	D8 / B-75-1.7-2.7	11W161-801	11W150-302
59S100-1E4XX-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
59S100-1E7XX-Y	E7 / B-61-1.87-2.9	11W161-800	11W150-302
59S100-1E8XX-Y	E8 / DACAR 362	11W161-800	11W150-104
59S100-1M4XX-Y	M4 / DACAR 302, DACAR 302-3, DACAR 302-4	11W161-8M4	11W150-104
59S100-1AXXX-Y	AX / RTK 044	11W161-8M4	11W150-104

Rosenberger	<i>general tolerance</i>	<i>assembly instr.:</i>	<i>scale:</i> 2:1 (1:1)	<i>crimp insert:</i> ---
	ISO 2768 mH	--- <i>panel piercing:</i> ---	<i>series:</i> --- ---	<i>cable:</i> --- ---
vertraulich / confidential	<i>date</i>	<i>name</i>	Montageanleitung assembly instruction	
y00 22-1754 J_Dandl 20.12.2022	<i>drawn</i>	F_Neureiter		
x00 21-0752 M_Thaler 28.04.2021	<i>check</i>	F_Zehentmeie		
w00 18-0698 C_Ostermaier 09.05.2018	<i>appr.</i>	F_Danzl		
v00 16-v728 R_Gnodtke 11.07.2017				
u00 16-0457 M_Kolbe 22.03.2016			<i>drawing-no.:</i>	<i>sheet:</i>
t00 15-1459 M_Kolbe 14.03.2016			MA_59V058	1
<i>rev. change-no</i>	<i>name</i>	<i>date</i>	<i>remarks:</i>	<i>of:</i> 10

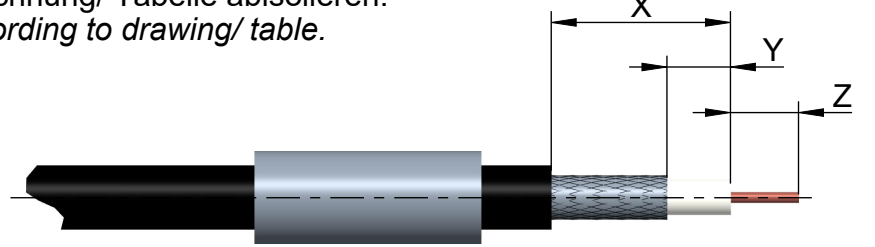
1 2 3 4

1 2 3 4

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



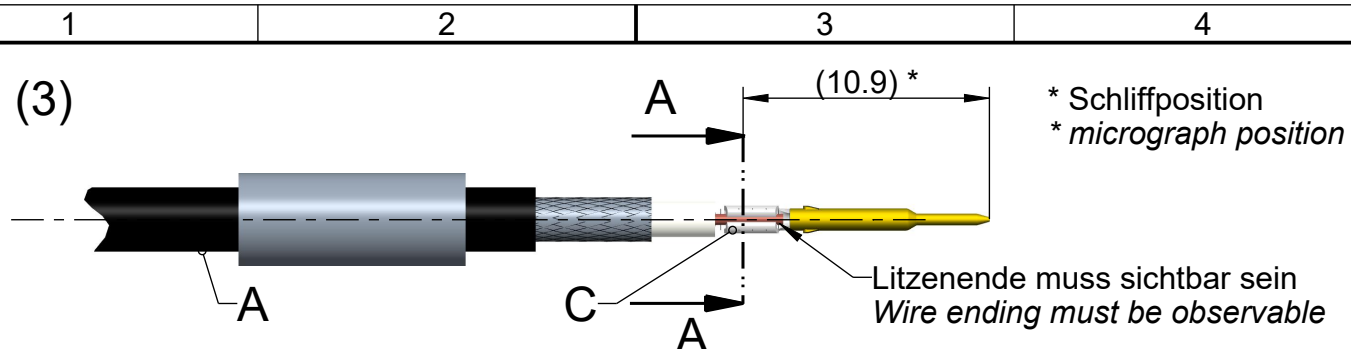
(2) Kabel nach Zeichnung/ Tabelle abisolieren.
Strip cable according to drawing/ table.



Teile Nummer <i>part number</i>	Kabelgruppe <i>cable group</i>	X	Y	Z
59S100-102XX-Y	02 / RG 174 02 / RG 316 02 / DACAR 462	7.9±0.2	2.8±0.2	3±0.2
59S100-103XX-Y	03 / RG 179 B/U-d 03 / 1.5DS-QFB (TA)	7.9±0.2	2.8±0.2	3±0.2
59S100-106XX-Y	06 / RG 58	9.4±0.2	2.8±0.2	3±0.2
59S100-1BAXX-Y	BA / AMC 4.0	10±0.2	2±0.2	3±0.2
59S100-1BFXX-Y	BF / Shikoku 2DS-PPFW	9.7±0.2	2.8±0.2	3±0.2
59S100-1BSXX-Y	BS / Shikoku 1.5DS-QEHBE M SH-131 BS / Shikoku 1.5DS-QEHB SH-030	7.9±0.2	2.8±0.2	3±0.2
59S100-1BYXX-Y	BY / TFC 4.0mm double braid	7.9±0.2	2.8±0.2	3±0.2
59S100-1D6XX-Y	D6 / DACAR 077 D6 / DACAR 200	9.4±0.2	2.8±0.2	3±0.2
59S100-1D8XX-Y	D8 / B-75-1.7-2.7	7.9±0.2	2.8±0.2	3±0.2
59S100-1E4XX-Y	E4 / DACAR 037 E4 / Draka FL09YBCYW 1.1/2.9 DKB E4 / CommScope AMC-58 Low Loss EZ E4 / G & G 69337	9.4±0.2	2.8±0.2	2.6±0.2
59S100-1E7XX-Y	E7 / B-61-1.87-2.9	7.9±0.2	2.8±0.2	3±0.2
59S100-1E8XX-Y	E8 / DACAR 362	7.9±0.2	2.8±0.2	3±0.2
59S100-1M4XX-Y	M4 / DACAR 302, DACAR 302-3, DACAR 302-4	7.9±0.2	2.8±0.2	3±0.2
59S100-1AXXX-Y	AX / RTK 044	7.9±0.2	2.8±0.2	3±0.2

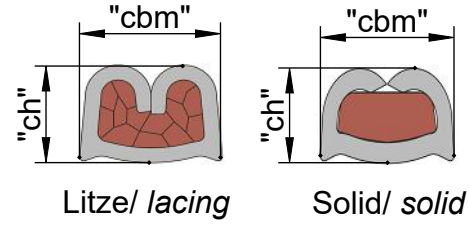
Rosenberger	<i>general tolerance</i>	ISO 2768	<i>assembly instr.:</i>	scale: 3:1 (1:1)	<i>crimp insert:</i> ---
	mH		panel piercing: ---	series: ---	<i>cable:</i> ---
vertraulich / confidential	<i>date</i>	<i>name</i>	Montageanleitung assembly instruction		
y00 22-1754 J_Dandl 20.12.2022	drawn	F_Neureiter			
x00 21-0752 M_Thaler 28.04.2021	check	F_Zehentmeie	drawing-no.: MA_59V058		
w00 18-0698 C_Ostermaier 09.05.2018	appr.	F_Danzl			
v00 16-v728 R_Gnodtke 11.07.2017			sheet: 2		
u00 16-0457 M_Kolbe 22.03.2016					
t00 15-1459 M_Kolbe 14.03.2016			of: 10		
rev. change-no name date					
remarks: .					

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 "C" 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).



Schnitt A-A
section A-A

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.

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

PD_FB_01

-METRIC-

ISO-Projektion
Methode 1

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 . . . drawing-no.: MA_59V058			
drawn		28.02.2005		F_Neureiter						
check.		20.12.2022		F_Zehentmeie						
appr.		21.12.2022		F_Danzl						
rev.		change-no		name		date				
y00		22-1754		J_Dandl		20.12.2022		sheet: 3		
x00		21-0752		M_Thaler		28.04.2021		of: 10		
w00		18-0698		C_Ostermaier		09.05.2018				
v00		16-v728		R_Gnodtke		11.07.2017				
u00		16-0457		M_Kolbe		22.03.2016				
t00		15-1459		M_Kolbe		14.03.2016				
remarks:										

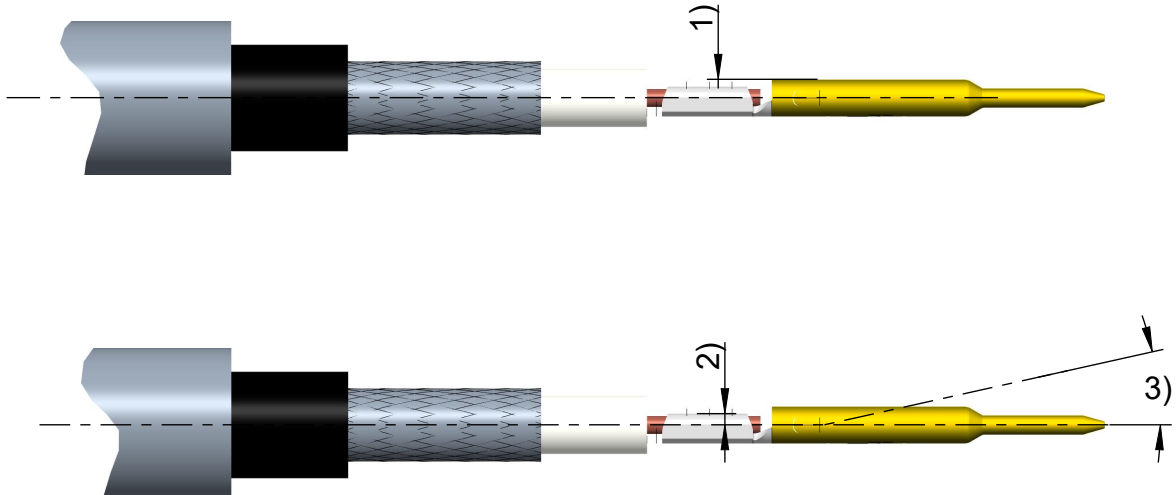
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ISO-Projektion Methode 1
 -METRIC-
 PD_FB_01

1	2		3		4
A	Kabelgruppe <i>cable group</i>		Crimpmaße <i>crimp dimensions</i>		Auszugskraft <i>tensile strength</i>
			Crimpbreite "cbm" <i>crimp width "cbm"</i>	Crimphöhe "ch" <i>crimp height "ch"</i>	
	02 / RG 174 02 / RG 316 02 / DACAR 462		(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
	BA / AMC 4.0		(1.34±0.05) **	0.88±0.03	>60N
B	BF / Shikoku 2DS-PPFW		(1.34±0.05) **	0.88±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		(tbd±0.05) **	0.74±0.03	>6N
	D6 / DACAR 200		(1.15±0.05) **	0.78±0.03	>20N
	D8 / B-75-1.7-2.7		(tbd±0.05) **	0.74±0.03	>12N
C	E4 / DACAR 037 E4 / Draka FL09YBCYW 1.1/2.9 DKB E4 / CommScope AMC-58 Low Loss EZ E4 / G & G 69337		(1.45±0.05) **	1.1±0.03	>60N
	E7 / B-61-1.87-2.9		(1.15±0.05) **	0.78±0.03	>20N
	E8 / DACAR 362		(1.15±0.05) **	0.78±0.03	>20N
	M4 / Dacar 302	Handtool	(1.34±0.05) **	0.88±0.03	>60N
	⊙00 Dacar 302-3				
	⊙00 Dacar 302-4	Crimpapplicator	(1.34±0.05) **	0.99±0.03	>60N
	AX / RTK 044	Crimpapplicator ⊙00	(1.34±0.05) **	0.99±0.03	>60N
D	** werkzeuggebunden ** tool related				
E					
Rosenberger		<i>general tolerance</i> ISO 2768 mH	<i>assembly instr.:</i> --- <i>panel piercing:</i> ---	<i>scale:</i> 2:1 (1:1) <i>series:</i> --- ---	<i>crimp insert:</i> --- <i>cable:</i> --- ---
vertraulich / confidential		<i>date</i> <i>name</i>	<i>title:</i> <h2 style="text-align: center;">Montageanleitung assembly instruction</h2>		
y00	22-1754	J_Dandl	20.12.2022	<i>drawn</i> 28.02.2005 F_Neureiter	
x00	21-0752	M_Thaler	28.04.2021	<i>check.</i> 20.12.2022 F_Zehentmeie	
w00	18-0698	C_Ostermaier	09.05.2018	<i>appr.</i> 21.12.2022 F_Danzl	
v00	16-v728	R_Gnodtke	11.07.2017	<i>drawing-no.:</i>	
u00	16-0457	M_Kolbe	22.03.2016	MA_59V058	
t00	15-1459	M_Kolbe	14.03.2016		
rev.	<i>change-no</i>	<i>name</i>	<i>date</i>	<i>remarks:</i> .	
1	2		3		4

sheet: 4
of: 10

(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.*

PD_FB_01

-METRIC-

ISO-Projektion
 Methode 1

Rosenberger			general tolerance		assembly instr.: ---		scale: 5:1 (1:1)		crimp insert: ---	
			ISO 2768		panel piercing: ---		series: ---		cable: ---	
			mH				---		---	
vertraulich / confidential			date		name		Montageanleitung assembly instruction			
drawn		28.02.2005		F_Neureiter						
check.		20.12.2022		F_Zehentmeie						
appr.		21.12.2022		F_Danzl						
drawing-no.:		MA_59V058		sheet: 5						
rev. change-no		name		date		drawing-no.:		of: 10		
y00		22-1754		J_Dandl		20.12.2022		remarks: .		
x00		21-0752		M_Thaler		28.04.2021				
w00		18-0698		C_Ostermaier		09.05.2018				
v00		16-v728		R_Gnodtke		11.07.2017				
u00		16-0457		M_Kolbe		22.03.2016				
t00		15-1459		M_Kolbe		14.03.2016				

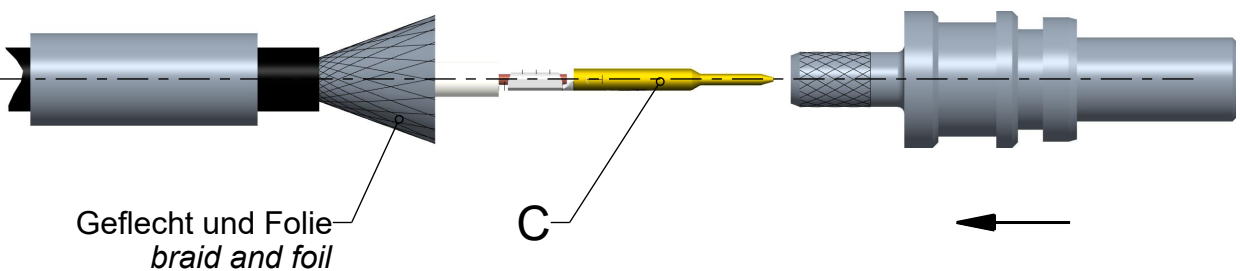
1

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(5)



Geflecht und Folie
 braid and foil

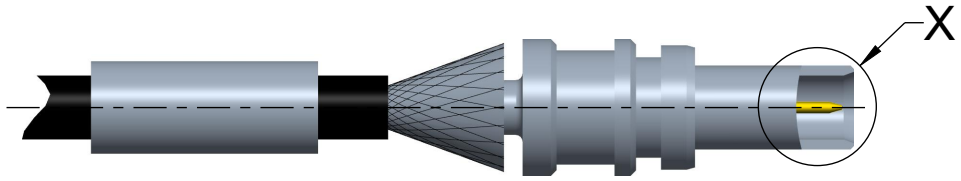
C

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:

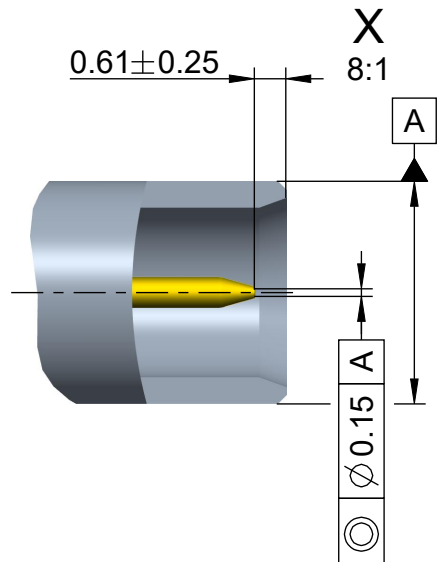
Geflecht aufweiten und Folie entfernen.
 Der Innenleiter "C" darf dabei nicht verbogen werden.
*Splay out the braid and cut and remove the foil.
 Don't bend the center contact "C" during expanding!*

(6)



Vorbereitetes Kabel in den Steckerkörper "D" einschieben bis der Innenleiter spürbar einrastet und das Kontaktstückmaß 0.61 ± 0.25 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 0.61 ± 0.25 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.)



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	
y00 22-1754		J_Dandl 20.12.2022		check. 20.12.2022		F_Neureiter			
x00 21-0752		M_Thaler 28.04.2021		appr. 21.12.2022		F_Zehentmeie			
w00 18-0698		C_Ostermaier 09.05.2018							
v00 16-v728		R_Gnodtke 11.07.2017							
u00 16-0457		M_Kolbe 22.03.2016						drawing-no.: MA_59V058	
t00 15-1459		M_Kolbe 14.03.2016						sheet: 6	
rev. change-no		name		date		remarks: .		of: 10	

1

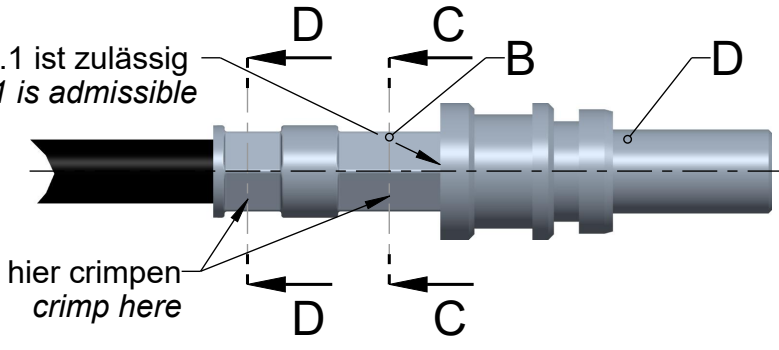
2

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(7)

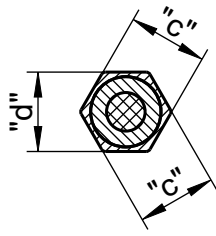
Spalt von 0.1 ± 0.1 ist zulässig
 gap of 0.1 ± 0.1 is admissible



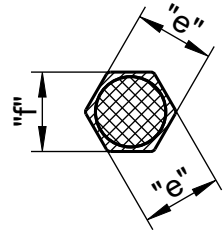
hier crimpen
 crimp here

Crimphülse "B" über das Geflecht bis an den Steckerkörper "D" heranschieben und möglichst nahe am Steckerkörper crimpen (Werkzeug 2). Das Kontaktstückstandsmaß 0.61 ± 0.25 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 0.61 ± 0.25 still has to be accomplished.



Schnitt C-C
 section C-C



Schnitt D-D
 section D-D

PD_FB_01

-METRIC-

ISO-Projektion
 Methode 1

Rosenberger			general tolerance	assembly instr.:	scale: 3:1 (1:1)	crimp insert: ---			
			ISO 2768	---	series: ---	cable: ---			
vertraulich / confidential			mH	panel piercing:	---	---			
			---	---	---	---			
				date	title: Montageanleitung assembly instruction				
drawn	28.02.2005	name		drawing-no.: MA_59V058					
y00	22-1754	J_Dandl	20.12.2022				check.	20.12.2022	F_Zehentmeie
x00	21-0752	M_Thaler	28.04.2021				appr.	21.12.2022	F_Danzl
w00	18-0698	C_Ostermaier	09.05.2018						
v00	16-v728	R_Gnodtke	11.07.2017						
u00	16-0457	M_Kolbe	22.03.2016						
t00	15-1459	M_Kolbe	14.03.2016						
rev.	change-no	name	date			sheet: 7			
						of: 10			
remarks: .									

1

2

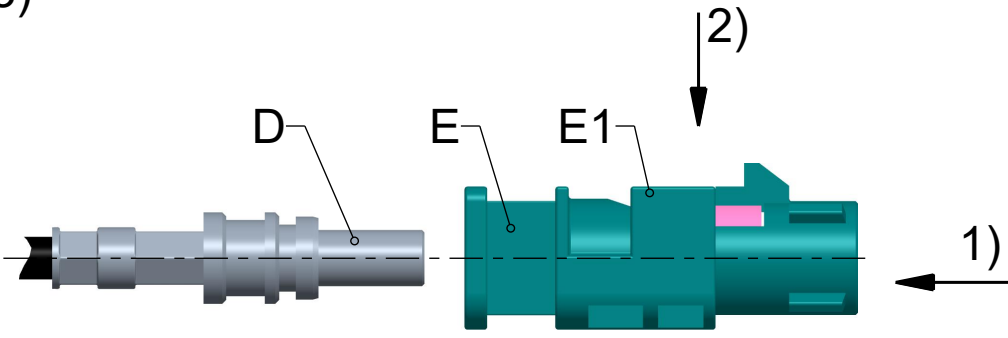
3

4

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1	2		3		4																																																														
A Kabelgruppe <i>cable group</i>	Crimpmaße <i>crimp dimensions</i>				Auszugskraft <i>tensile strength</i>																																																														
	C-C Crimpmaße <i>C-C crimp dimensions</i>		D-D Crimpmaße <i>D-D crimp dimensions</i>																																																																
	"c"	"d"	"e"	"f"																																																															
02 / RG 174 02 / RG 316 02 / DACAR 462	(3.3±0.05)**	3.3±0.05	(3.5±0.05)**	3.5±0.05	>110N																																																														
03 / RG 179 B/U-d 03 / 1.5DS-QFB (TA)	(3.3±0.05)**	3.3±0.05	(3.3±0.05)**	3.3±0.05	>110N																																																														
06 / RG 58	(5.5±0.1)**	5.5±0.1	N.A.	N.A.	>110N																																																														
BA / AMC 4.0	(5.35±0.1)**	5.35±0.1	(5.35±0.1)**	5.35±0.1	>110N																																																														
BF / Shikoku 2DS-PPFW	(5.35±0.1)**	5.35±0.1	(5.35±0.1)**	5.35±0.1	>110N																																																														
BS / Shikoku 1.5DS-QEHBE M SH-131 BS / Shikoku 1.5DS-QEHB SH-030	(3.63±0.05)**	3.63±0.05	N.A.	N.A.	>110N																																																														
BY / TFC 4.0mm double braid	(5.35±0.1)**	5.35±0.1	(5.35±0.1)**	5.35±0.1	>110N																																																														
D6 / DACAR 077 D6 / DACAR 200	(5.5±0.1)**	5.5±0.1	N.A.	N.A.	>110N																																																														
D8 / B-75-1.7-2.7	(3.3±0.05)**	3.3±0.05	(3.5±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±0.1)**	5.5±0.1	N.A.	N.A.	>110N																																																														
E7 / B-61-1.87-2.9	(3.3±0.05)**	3.3±0.05	(3.5±0.05)**	3.5±0.05	>110N																																																														
E8 / DACAR 362	(4.3±0.05)**	4.3±0.05	N.A.	N.A.	>110N																																																														
M4 / DACAR 302 DACAR 302-3 DACAR 302-4	(y00) (4.3±0.05)**	4.3±0.05	N.A.	N.A.	>110N																																																														
AX / RTK 044	(x00) (4.33±0.05)**	4.33±0.05	N.A.	N.A.	>110N																																																														
					** Werkzeuggebunden ** tool related																																																														
D																																																																			
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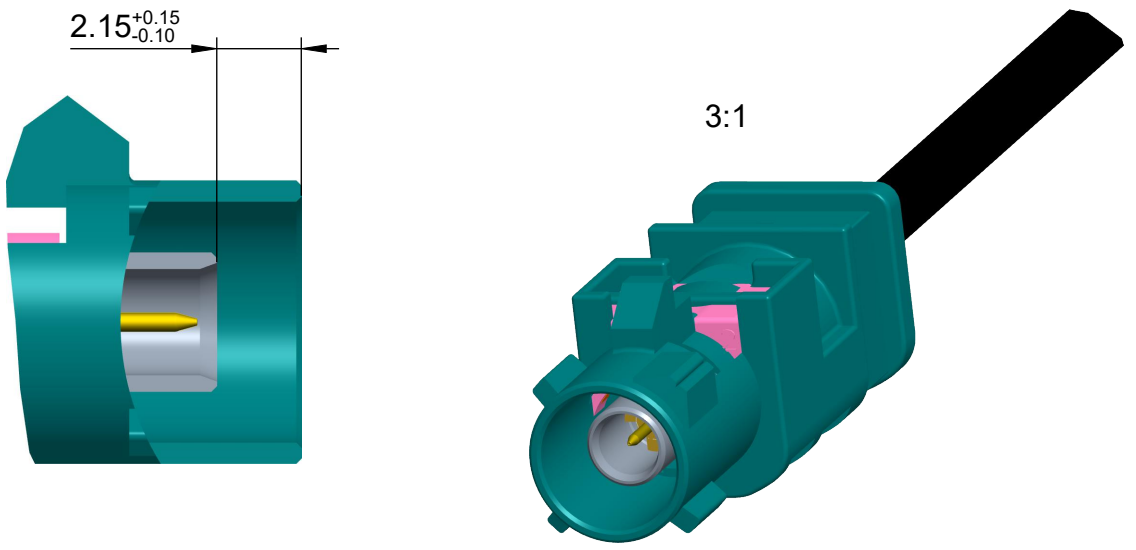
(8)



- 1) Steckerkörper "D" mit angecrimpten Kabel in Gehäuse "E" einführen bis Kontakt spürbar einrastet und das Kontaktstückmaß $2.15^{+0.15}_{-0.10}$ 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 $2.15^{+0.15}_{-0.10}$ is attained.
- 2) Push Secondary lock "E1" completely until stop.

(9)



Rosenberger			general tolerance		assembly instr.: ---		scale: 2:1 (1:1)		crimp insert: ---	
			ISO 2768		panel piercing: ---		series: ---		cable: ---	
			mH				---		---	
vertraulich / confidential			date		name		title: Montageanleitung assembly instruction .. drawing-no.: MA_59V058			
y00 22-1754		J_Dandl	20.12.2022		F_Neureiter					
x00 21-0752		M_Thaler	28.04.2021		F_Zehentmeie					
w00 18-0698		C_Ostermaier	09.05.2018							
v00 16-v728		R_Gnodtke	11.07.2017							
u00 16-0457		M_Kolbe	22.03.2016				drawing-no.: MA_59V058		sheet: 9	
t00 15-1459		M_Kolbe	14.03.2016						of: 10	
rev. change-no			name		date		remarks: .			

PD_FB_01

-METRIC-

ISO-Projektion
Methode 1

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PD_FB_01

-METRIC-



ISO-Projektion
Methode 1

1	2		3		4		
Revision	Change						
x00	cable version -1AX added						
y00	added Dacar 302-4, Dacar 302-3, Dacar 302 removed RTK031						
A	A						
B	B						
C	C						
D	D						
E	E						
F	F						
Rosenberger			<i>general tolerance</i> ISO 2768 mH	<i>assembly instr.:</i> --- <i>panel piercing:</i> ---	<i>scale:</i> 2:1 (1:1)	<i>crimp insert:</i> --- <i>cable:</i> --- ---	
vertraulich / confidential			<i>drawn</i>	<i>date</i>	<i>name</i>	<i>title:</i>	
y00	22-1754	J_Dandl	20.12.2022	check.	20.12.2022	F_Zehentmeie	Montageanleitung assembly instruction
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t00	15-1459	M_Kolbe	14.03.2016				<i>drawing-no.:</i> MA_59V058
rev.	change-no	name	date				<i>sheet:</i> 10 <i>of:</i> 10
							<i>remarks:</i> .
1	2		3		4		