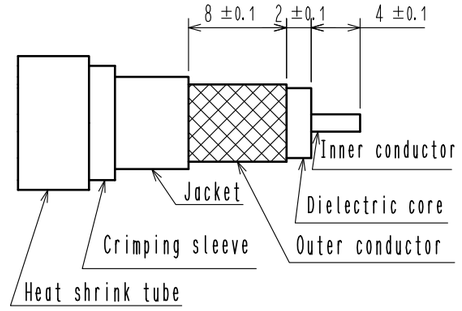
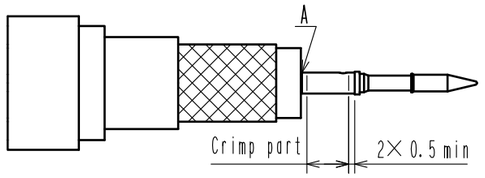
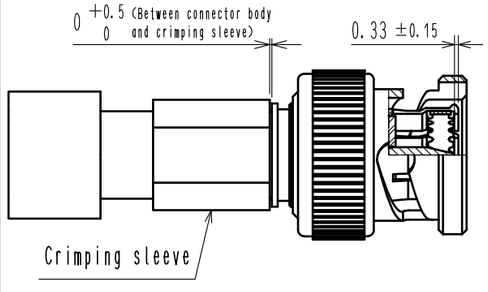
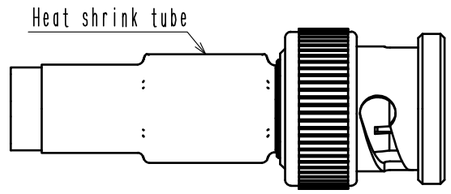
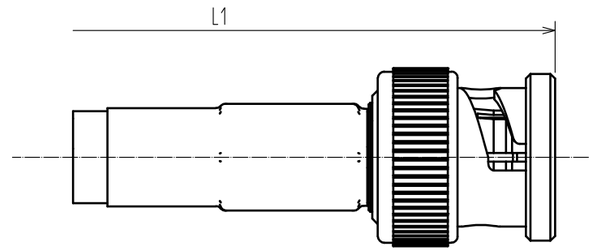
No.	Visual Instructions	Instructions
1		1. After putting the heat shrink tube and crimp sleeve on the cable, start preparation for terminal as shown in the figure to the left. Applicable Cables 5.5C-UHDG(Made By HIRAKAWA HEWTECH Co., Ltd) 5.5C-UHDGW(Made By HIRAKAWA HEWTECH Co., Ltd) Note. 1 If the cable conduction material becomes oxidized, the contacts may not me in a stable state. To prevent this from happening, be care with the storage of the cables. Note. 2 When removing the outer jacket and insulation, be careful not to damage the outer conduction material, dielectric material and central conductor (Especially when cutting). Note. 3 Be careful not to damage the dielectric material tip.
2		2-1. Insert male contact onto the cable. Note 1. No space between point A. (Between central terminal and cables dielectric material.) 2-2. Crimp male terminal contact. When using the Crimping Tool, make sure setting 6 is being used. Note 1. Confirm crimping section is in a specified range. Note 2. After Crimping in regards to cable, be careful male contact is not twisted or pulled. Crimping tool: MIL-DTL-M22520/7-01. Positioner: BNC75-12G/CRMD
3		3-1. Insert the terminal (as shown above in NO.2) into connector body. Note 1. Insert until hit wall of the connector body. (Confirm male contact tip position.) Note 2. Be careful that insulator base does not spring out or male contact does not buckle. Note 3. Confirm that the crimping sleeve is as positioned as shownin the figure to the left. Note 4. If there is copper tape on the outer conductor, connector body outer side cover evenly and crimp to braided wire. Note 5. Be careful that copper tape is not spread unevenly. 3-2. Crimping sleeve is crimped to the hexagonal section. Crimping Tool: MIL-DTL-M22520/5-01, Die: MIL-DTL-M22520/5-55 (If die size is HEX 0.324 Inch/Width 0.4 inch, other parts can be used.) Note 1. After crimping, meet the condition, HEX8.3±0.1. Note 2. Crimping sleeve is crimped to the entire.

No.	Visual Instructions	Instructions
4		4. Cover heat shrink tube over the connector as shown in the figure to the left and using a heat gun, shrink the heat tube. Note 1. Be careful not to melt the cables dielectric material.



(Reference)Length and Cutting length after Harnessing.
Cable Cutting length: L1-11.3

	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△0					

TITLE

BNC(75)-P-5.5C-12G
ASSEMBLY PROCEDURE

HIROSE ELECTRIC CO., LTD.

APPROVED	TO. KATAYAMA	20190520
CHECKED	TO. KATAYAMA	20190520
CHARGED	RO. YOKOYAMA	20190520
WRITTEN	ST. KISHI	20190520

TECHNICAL SPECIFICATION | ETAD-D1467-00 | △0 | 1/1

FORM 213-1-1