1. Scope

This specification specifies the assembly process of the following product.

PART NO.	CODE NO.
BNC(75)-BPJ-1.5CV-(P)(40)	CL302-0369-8-40

2. Assembly process

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	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△					

名 称 TITLE

BNC(75)-BPJ-1.5CV-(P)(40)
ASSEMBLY PROCEDURE

HRS ヒロセ電機株式会社
HIROSE ELECTRIC CO., LTD.

APPROVED	MH. YAMANE	14.02.05
CHECKED	TY. OZAKI	14.02.04
CHARGED	MA. SAEKI	14.02.04
WRITTEN	MA. SAEKI	14.02.04

技 術 指 定 書 TECHNICAL SPECIFICATION

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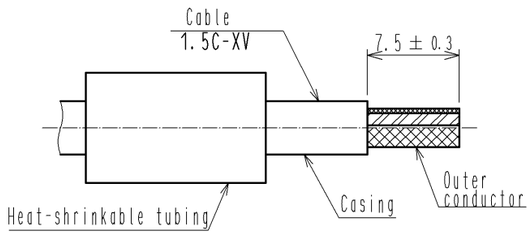
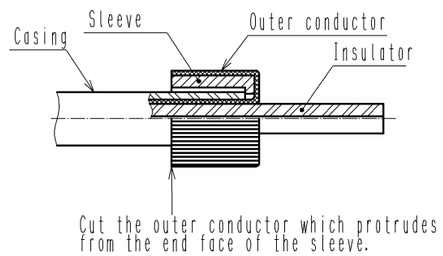
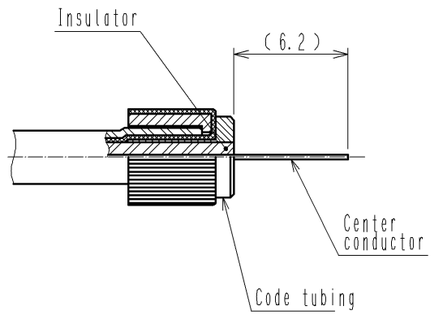
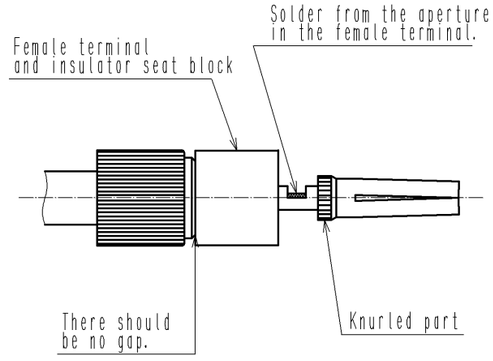
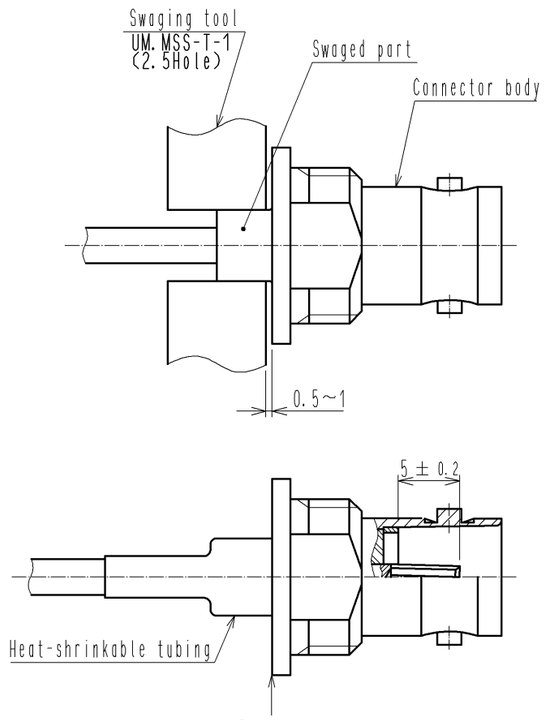
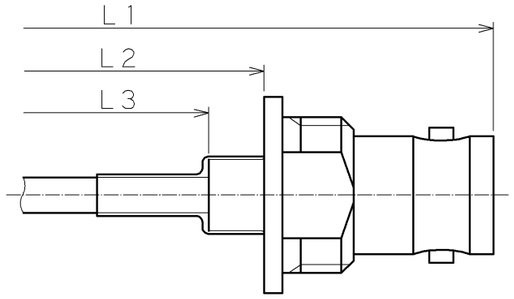
	Figure	Process Description
1		1. After putting the heat-shrinkage tubing on the cable, treat the end of the cable at the dimension shown in the figure. Note (1) Pay attention not to damage the outer conductor. Note (2) Cut the end of the cable to make it vertical before processing the end of the cable.
2		1. Insert the cable into the sleeve. Note (1) Insert the cable until the cable casing touches the step of the sleeve. 2. Loosen the braid of the outer conductor, and fold back on the sleeve. Note (1) Cut the outer conductor which protrudes from the end face of the sleeve. Note (2) There should be at least 4mm of the outer conductor on the sleeve. Note (3) The outer conductor should be folded back evenly on the sleeve.
3		1. Insert the code tubing between the outer conductor and the insulator of the cable. Note (1) Insert the code tubing until the outer conductor is adequately pressed against the sleeve. 2. For aligning the end faces of the cable insulator and the code tubing as shown in the figure, remove the excess part of the insulator. Note (1) Do not damage or bend the center conductor.
4		1. Insert the female terminal and insulator seat block into the cable, and solder the female terminal. Note (1) Make sure the cable's center conductor is visible in the whole part of the aperture for soldering of the female terminal. Note (2) There should be no gap between the insulator seat and the code tubing. Note (3) Solder carefully in order not to make a cold oint and to prevent the solder from flowing to the outside diameter of the female terminal and the knurled part. Note (4) Do not pull or rotate the female terminal and insulator seat block on the cable after soldering.
5		1. Insert the block of Step 4 into the main unit of the connector. Note (1) Insert until the end face of the insulator seat touches the main unit of the connector. Note (2) Make sure the sleeve is completely inserted in to the connector. Note (3) Do not rotate the main unit of the connector against the cable until they are swaged. 2. Swage the swaged part of the main unit with the swaging tool UM.MSS-T-1 (2.5 hole). Note (1) Swage at the part 0.5 - 1mm away from the end face of the main unit. 3. Confirm that the position of the female terminal is as per the dimension shown in the figure. 4. Cover with heat-shrinkable tubing to the end face A, and shrink it with a heat gun.



(Reference)
L dimensions and cable cut length after harnessing

Cable cut length: L1-11.4
: L2+7.3
: L3+11.8

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