

1. Scope

This specification specifies the assembly process
of the following product.

PART NO.	CODE NO.
BNC(75)-BPJ-1.5CW-(P)(40)	CL302-0388-2-40

2. Assembly process

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	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE												
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名 称 T I T L E			<div><div>HRS</div><div>ヒロセ電機株式会社 HIROSE ELECTRIC CO., LTD.</div></div> <table><tr><td>APPROVED</td><td>MH. YAMANE</td><td>14. 01. 31</td></tr><tr><td>CHECKED</td><td>TY. OZAKI</td><td>14. 01. 30</td></tr><tr><td>CHARGED</td><td>MA. SAEKI</td><td>14. 01. 30</td></tr><tr><td>WRITTEN</td><td>MA. SAEKI</td><td>14. 01. 30</td></tr></table>			APPROVED	MH. YAMANE	14. 01. 31	CHECKED	TY. OZAKI	14. 01. 30	CHARGED	MA. SAEKI	14. 01. 30	WRITTEN	MA. SAEKI	14. 01. 30
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	Figure	Process Description		Figure	Process Description
1		<p>1. After putting the heat-shrinkage tubing on the cable, treat the end of the cable at the dimension shown in the figure.</p> <p>Note (1) Pay attention not to damage the outer conductor.</p> <p>Note (2) Cut the end of the cable to make it vertical before processing the end of the cable.</p>	5		<p>1. Insert the block of Step 4 into the main unit of the connector.</p> <p>Note (1) Insert until the end face of the insulator seat touches the main unit of the connector.</p> <p>Note (2) Make sure the sleeve is completely inserted in to the connector.</p> <p>Note (3) Do not rotate the main unit of the connector against the cable until they are swaged.</p> <p>2. Swage the swaged part of the main unit with the swaging tool P073-T-4.</p> <p>Note (1) Swage at the part 0.5 - 1mm away from the end face of the main unit.</p> <p>3. Confirm that the position of the female terminal is as per the dimension shown in the figure.</p> <p>4. Cover with heat-shrinkable tubing to the end face A, and shrink it with a heat gun.</p>
2		<p>1. Insert the cable into the sleeve.</p> <p>Note (1) Insert the cable until the cable casing touches the step of the sleeve.</p> <p>2. Loosen the braid of the outer conductor, and fold back on the sleeve.</p> <p>Note (1) Cut the outer conductor which protrudes from the end face of the sleeve.</p> <p>Note (2) There should be at least 4mm of the outer conductor on the sleeve.</p> <p>Note (3) The outer conductor should be folded back evenly on the sleeve.</p>			
3		<p>1. Insert the code tubing between the outer conductor and the insulator of the cable.</p> <p>Note (1) Insert the code tubing until the outer conductor is adequately pressed against the sleeve.</p> <p>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.</p> <p>Note (1) Do not damage or bend the center conductor.</p>			
4		<p>1. Insert the female terminal and insulator seat block into the cable, and solder the female terminal.</p> <p>Note (1) Make sure the cable's center conductor is visible in the whole part of the aperture for soldering of the female terminal.</p> <p>Note (2) There should be no gap between the insulator seat and the code tubing.</p> <p>Note (3) Solder carefully in order not to make a cold joint and to prevent the solder from flowing to the outside diameter of the female terminal and the knurled part.</p> <p>Note (4) Do not pull or rotate the female terminal and insulator seat block on the cable after soldering.</p>			

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