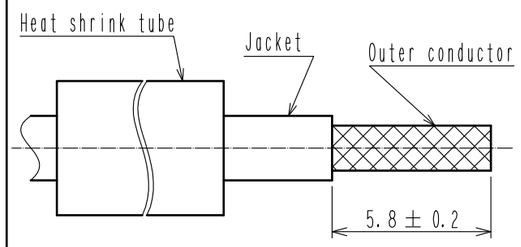
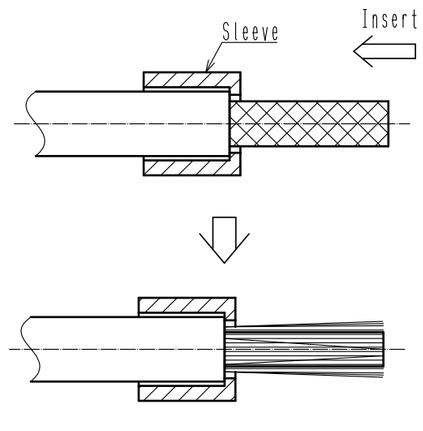
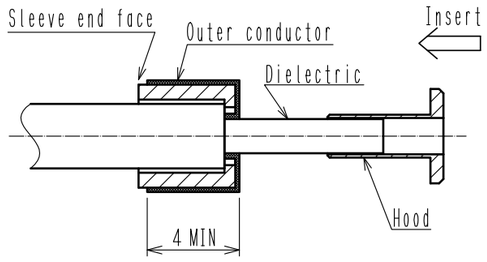
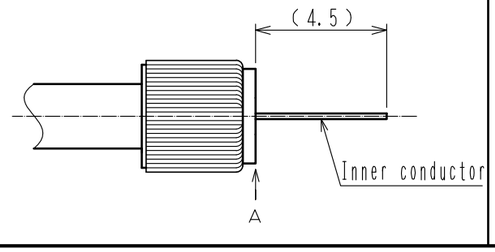
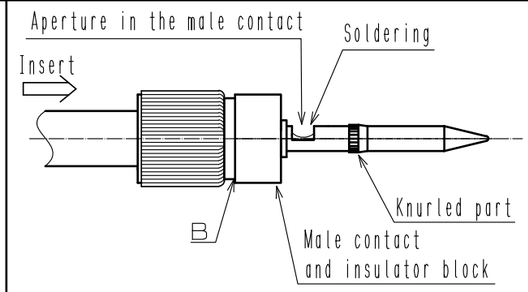
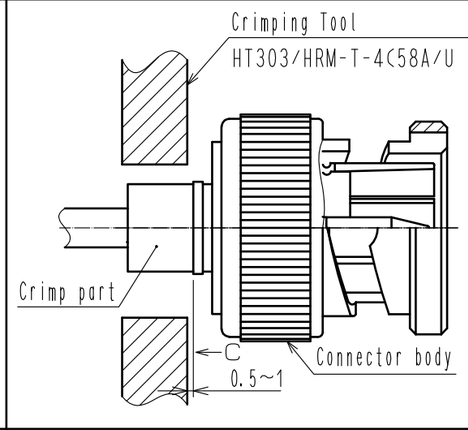
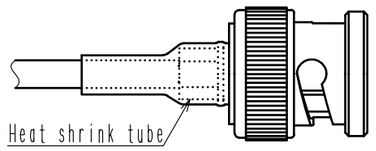
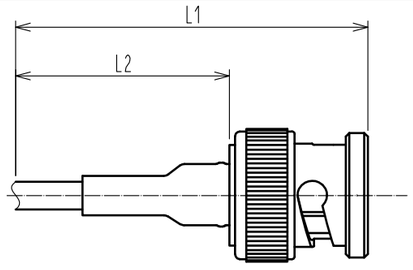
No.	Visual Instructions	Instructions
1		1-1. Putting the heat shrink tube on the cable as shown in the figure to the left. 1-2. Cut the jacket with the dimensions shown in the figure. Note 1. Cut the end of the cable to make it vertical before processing the end of the cable. Note 2. When terminal processing, be careful not to damage the outer conductor. Cable : 1.5CCA-EXBV(LF) 1.5C-QEV・CW
2		2-1. Insert the cable into the sleeve. Note 1. Insert the cable until jacket of the cable touches the step of the sleeve. 2-2. Loosen the outer conductor shown in the figure.
3		3-1. Loosen the outer conductor, and fold back on the sleeve. Note 1. The outer conductor should be folded back evenly on the sleeve. Note 2. Cut the outer conductor which protrudes from the end face of the sleeve. Note 3. There should be at least 4mm of the outer conductor on the sleeve. 3-2. Insert the hood between the outer conductor and the dielectric of the cable. Note 1. Insert the hood until attacked the jacket of the cable.
4		4-1. For aligning the end faces of the cable dielectric and the code tubing as shown in the figure part A, remove the excess part of the dielectric. Note 1. Do not damage or bend the inner conductor.

No.	Visual Instructions	Instructions
5	 (Reference)…Soldering conditions Iron tip : 380℃ Heating time : Within 5 seconds	5-1. Insert the male contact and insulator block into the cable, and solder the male contact. Note 1. Make sure the cable's inner conductor is visible in the whole part of the aperture for soldering of the male contact. Note 2. There should be no gap between the insulator and the code tubing as shown in the figure part B. Note 3. Solder carefully to prevent defects and overflow of solder to the knurled parts or outer diameter of the male contact. Note 4. Do not pull or rotate the male contact and insulator block on the cable after soldering.
6		6-1. Insert the block of step 5 into the connector body. Note 1. Insert until the end face of the insulator attacked the connector body. Note 2. Make sure the sleeve is completely inserted into the connector body. 6-2. Crimp the crimp part of the main unit with the crimping tool HT303/HRM-T-4C58A/U hole) as shown in the figure. Note 1. When crimping, keep the end face of the main unit 0.5 to 1mm away from step C part. Note 2. Check that the male contact is positioned as shown in the figure.
7		7. Cover hert shrink tube over the connector as shown inthe figure to the left and using a heat gun, shrink the heat tube.
		(Reference) Length and Cutting length after Harnessing. Cable Cutting length : L1-10.4 L2+ 4.6

	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△0					

TITLE

BNC(75)-P-1.5CV
ASSEMBLY PROCEDURE

HRS HIROSE ELECTRIC CO., LTD.

APPROVED	TO. KATAYAMA	20191029
CHECKED	TO. KATAYAMA	20191029
CHARGED	RO. YOKOYAMA	20191029
WRITTEN	ST. KISHI	20191029

TECHNICAL SPECIFICATION

ETAD-D0303-00 △0 1/1

FORM 213-1-1

Mar.1.2024 Copyright 2024 HIROSE ELECTRIC CO., LTD. All Rights Reserved.