

1. Scope

This specification specifies the assembly process of the following product.

PART NO.	CODE NO.
BNC(75)-BPJ-1.5CV-2(40)	CL302-0380-0-40

2. Assembly process

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△				
名称 TITLE BNC(75)-BPJ-1.5CV-2(40) ASSEMBLY PROCEDURE		 ヒロセ電機株式会社 HIROSE ELECTRIC CO., LTD.		
		APPROVED	MH. YAMANE	14. 02. 03
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		CHARGED	MA. SAEKI	14. 01. 31
		WRITTEN	MA. SAEKI	14. 01. 31
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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>	<p>5</p>	<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 UM.MSS-T-1 (2.5 hole).</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>		<p>(Reference) L dimensions and cable cut length after harnessing</p> <p>Cable cut length: L1-11.4 : L2+7.3 : L3+11.8</p>	<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>			<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>	<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>			<p>4</p>	<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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