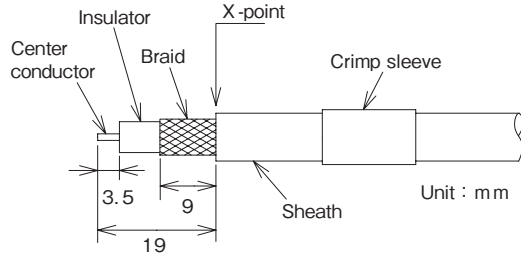


Crimping type BNC Connector (Max.7C size) Mounting Instructions

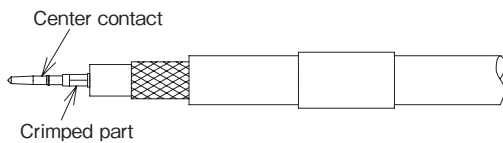
1 Please be advised about the required steps for Crimping type BNC Connector (BNCP-K series except BNCP-8CHK) to mount on TACHII's Coaxial Cable TCX-HD, TCX-FBL, TCX-2V series etc. Make sure to use Coaxial Cable and Crimping Tool recommended by TACHII.

2 Pass at first the crimp sleeve to coaxial cable, make step-cut to coaxial cable as per the size in the drawing. At this time, remove AL/PET tape fully and completely to X-point by opening the braid not to deform as far as possible. If metal foil remains, remove perfectly metal foil-ends, braid debris which cause short ot etc., without removing metal foil forcedly.



(Note 1)
In Coaxial Cable with AL/PET tape etc., please make sure to insert the cable into Connector after removing the tape, otherwise impossible.

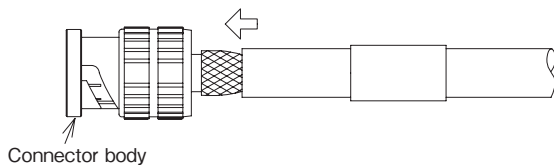
3 Strand lightly rightward in case of center conductor made with stranded wire. Crimp with crimping tool not to remain space between insulator, by sliding firmly to foot of the center conductor. (Important point to affect the return loss!) Refer to Page 19 on proper crimp height value range, and to Page 20 on Crimping tool.



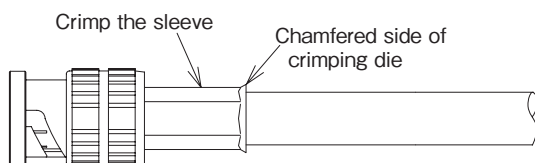
(Note 2)
Adjust the crimping tool in case of the crimp height value is not in proper range. Do not crimp the uneven part at the foot of center contact. Do not clutch up the grip more strongly by crimping frame ratchet release, which cause crimp height unstable. Confirm the crimp frame adjustment by the instruction attached to the frame.



4 Insert center contact, after crimping, to connector body until slightly feeling "snap" at this time as per the drawing.



5 Crimp the crimp sleeve by crimping tool after moving the sleeve hit to connector body. At this time, crimp by pushing the non-chamfered side of crimping die to connector body.



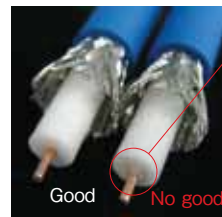
Special remarks on processing



Open the braid carefully to sheath side, not to deform the braid by removing sheath abt. 30mm. Remove the AL/PET tape by making nicks all around of the tape on X-point of braid foot by cutter etc.



To remove completely the braid debris
Cut the braid by 9mm as per the left-side drawing. At this time, remove the braid debris etc. perfectly by blower and so on as per the picture.



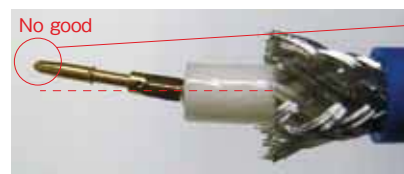
To make sure no insulator part remained on foot of conductor
Make sure no insulator part remained on the foot of center conductor after making step-cut. If remained, it shall cause serious influence of bad contact and return loss.



The center contact is properly crimped in order.



The gap is made between center contact and insulator!!
<How to settle>
Do the correct mounting again back to the very beginning.



The crimped center contact at a tilt!!
<How to settle>
Return the center contact axially straight.

(Note 3)
Do not squeeze the cable forcedly to connector body, as expected "snap" feeling at the time, can be noticed by proper pushing force. If squeeze into, breakage of insulator, center contact etc. may be happened. When no "snap" feeling, or unclear of such feeling, confirm the contact locked condition by pulling cable slightly (less than 19.6N or max. 2kg), then make sure by visual and finger-touch whether the contact edge reaches to correct position from connector connection side.

(Note 4)
After inserting the cable into connector, confirm whether the center contact locked to connector body by pulling cable slightly (less than 19.6N or max. 2kg).

(Note 5)
The hexagonal holes on crimping sleeve of the crimping dies for up to 5C (CDS-284G, -35V, -45F) are chamfered, but the crimping die for 6C ~ 7C (CDS-67G) is not chamfered.

(Note 6)
To prevent the spring-back (phenomena of the shape trying to return the original), keep the clutched crimping condition for more than one second by crimping frame.