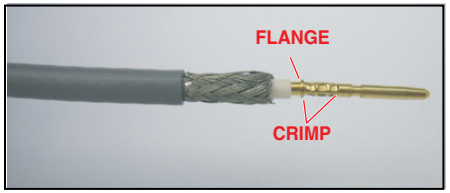
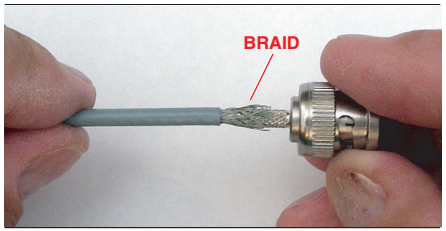
12-POINT CENTER PIN:

The crimp should extend from the flange as shown.



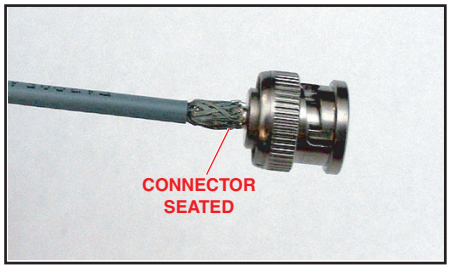
7 Rotate the connector gently in the direction of the foil wrap to open the braid enough to allow the connector to slide under the braid but over the foil.

Make sure the mylar foil remains inside the connector stem.



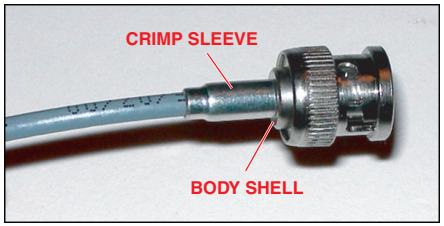
8 Slide the shell into place under the braided shield until the center pin snaps into place.

Pull gently on the cable to make sure the center pin is properly seated.



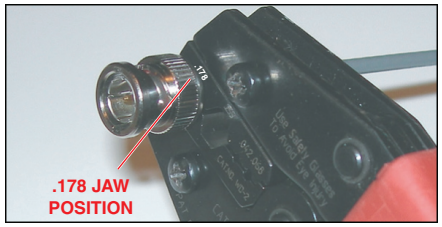
9 Slide the crimp sleeve over the shield and ferrule until it contacts the shell.

Make sure that no shield strands protrude from the sleeve.



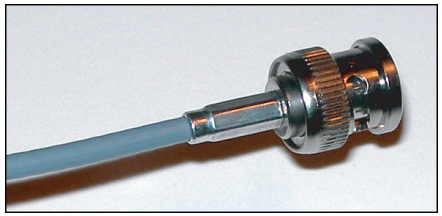
10 Use the .178-inch jaw position to crimp the crimp sleeve.

Crimp only one time. Double crimping will loosen the crimp sleeve and cause retention failure.



11 The finished connector should appear as shown in the photo at right, up tight to the body shell and no braided shield showing.

Center conductor pin height should be slightly recessed below center stationary sleeve.



BNC Connector Installation Using 4-, 12-Point Center Pin Crimp

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Required Tools

The following ADC tools are required to install a BNC connector on Type 735 cable:

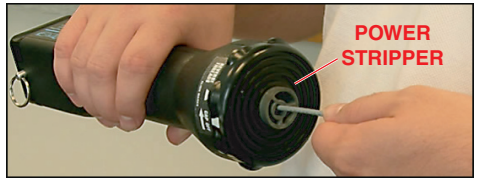
- BNC-S1 power stripper with BNC-H5 cutting head; or
- STC-13B manual stripping tool (if allowed)
- WT-2 crimp tool with WD-2 die set (for 4-point center pin and crimp sleeve)
- WT-C12 crimp tool (for 12-pt. center pin)

NOTE: The WT-C12-DS die set may be purchased separately and installed in an existing 12-point crimp tool.

Pre-Installation Tool Check

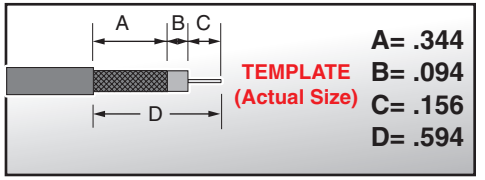
The following tests should be performed to insure that the stripping and crimping tools to be used to install the connectors are properly calibrated. If any of the tests are unsuccessful, the tool should be adjusted by a qualified person, or be replaced.

1 Use the stripper approved for the job to strip a piece of cable. When using a power stripper, wait until the stripper stops spinning before withdrawing the cable. When using a manual stripper, trim the center conductor to the proper length as shown in the template.



2 Check the dimensions against the template. If the dimensions do not match the template, check to see whether the correct cutting head in installed in the stripper.

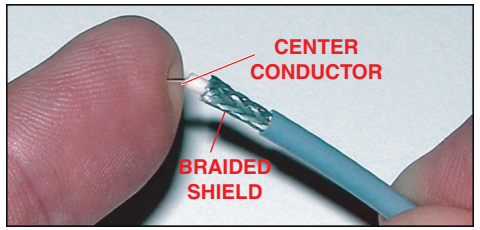
VERIFY TOOL CUTTING DEPTH.

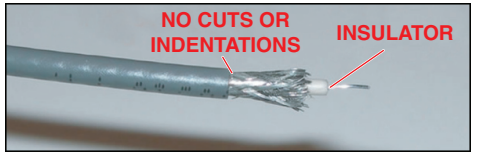


3 Visually inspect the center conductor for nicks. Bend the center conductor as shown 2-3 times. If it breaks, the stripper must be adjusted.

Visually inspect the braided shield. If the braided shield has been cut or stressed, the stripper must be adjusted.

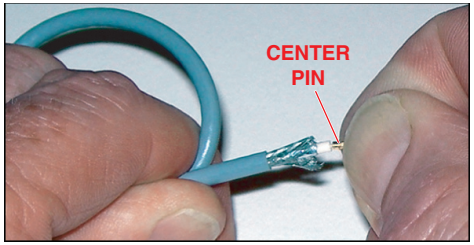
Visually inspect the insulator. Make sure the foil is cut and removed, but not the insulator. (Foil is already removed in photo.)





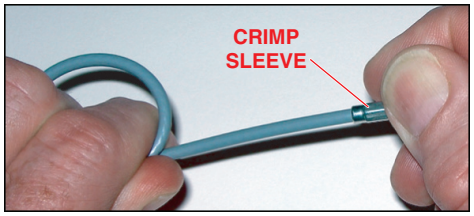
4 CHECK CENTER PIN CRIMPER.

Crimp the center pin to the center conductor using the tool approved for use in your facility. Grasp the center pin firmly, and pull back on the cable. If the center conductor pulls out of the center pin, the crimper is out of calibration.



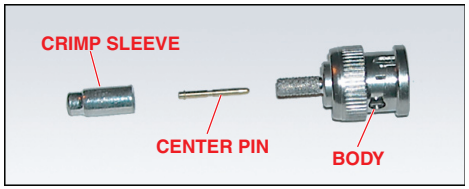
5 CHECK CRIMP SLEEVE CRIMPER.

Using a properly adjusted crimp sleeve crimper, complete a connector installation. Grasp the connector body firmly and pull back on the cable. If the cable pulls out of the crimp sleeve, the crimper is out of calibration.

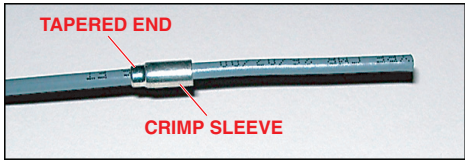


BNC Connector Installation (4- and 12-Point Center Pin Crimp)

The BNC connector is assembled from three pieces: the crimp sleeve, the center pin, and the body (shown at right).



1 Slide the crimp sleeve onto the cable (note the tapered end of the crimp sleeve goes onto the cable first).



2 Use either a power or manual stripper to strip the cable.

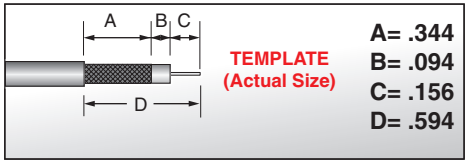
POWER STRIPPER

Run the power stripper for approximately 4 seconds, wait until the stripper stops spinning before withdrawing the cable.

MANUAL STRIPPER (if allowed)

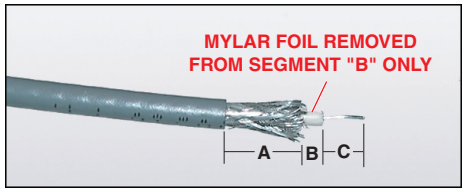
Rotate the manual stripper 3 times for each setting.

Trim the center conductor to the proper length as shown in the template to the right.

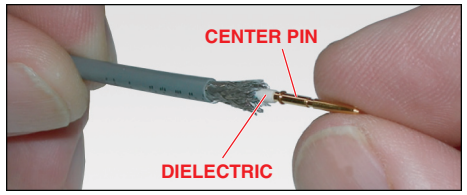


3 Remove the Mylar foil only from segment "B" (segment "B" only, maintain Mylar foil over segment "A").

Refer to template.



4 Slide the center pin onto the center conductor so that it seats against the dielectric material and no center conductor is exposed.

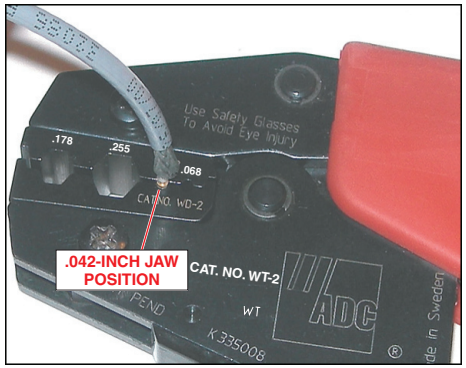


5 Crimp the center pin as follow:

4-POINT CENTER PIN:

Insert the pin onto the .042-inch jaw all the way to the flange.

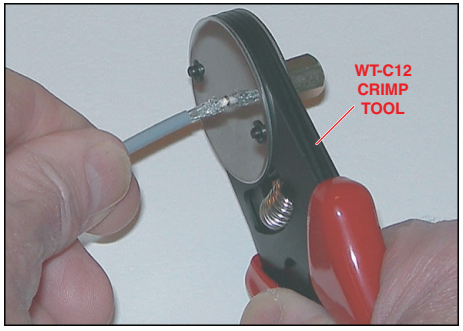
Fully cycle the tool to crimp the center pin.



12-POINT CENTER PIN:

Insert the pin into the WT-C12 crimp tool all the way to the flange.

Fully cycle the tool to crimp the center pin.



6 Inspect the center crimp as follows:

4-POINT CENTER PIN:

The crimp should extend from the flange as shown.