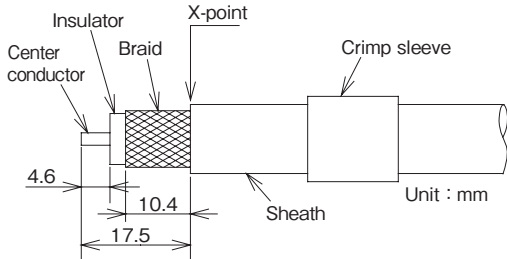


# Crimping type BNC Connector(BNCP-8CHK) Mounting Instructions

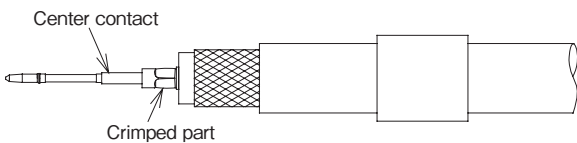
**1** Please be advised about the required steps for Crimping type BNC Connector (BNCP-8CHK) to mount on TACHII's Coaxial Cable TCX-8CHD. Make sure to use Coaxial Cable and Crimping Tool recommended by TACHII.

**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. Then remove perfectly metal foil-ends, braid debris which cause short out etc.



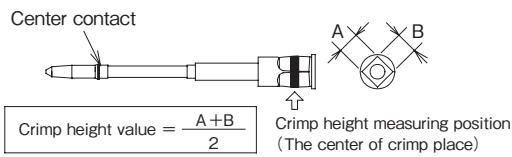
(Note 1)  
Make sure to insert Coaxial Cable into Connector by removing AL/PET tape completely, otherwise impossible.

**3** Crimp with the specialized crimping tool undermentioned, not to remain space between insulator, by inserting firmly center contact to the foot of center conductor. (Important point to affect the return loss !)



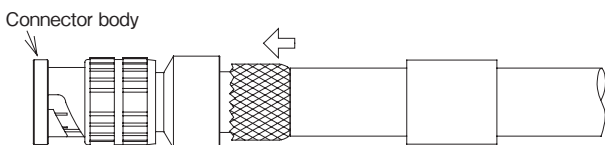
<Crimping tool>  
Please use TCF-08G.  
(Crimping frame : TCF-02, Crimping die : CDS-08G)

(Note 2)  
Adjust the crimping frame, in case of the crimp height is not in proper range. Do not crimp the step part in 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.

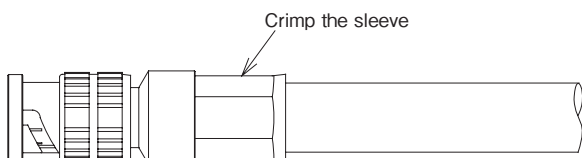


Proper range of crimp height : **2.41 ~ 2.52mm**

**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. No need to pay special attention on the crimping direction because of non-chamfered side on crimp die (CDS-08G).



## Special remarks on processing



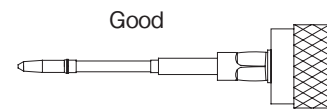
Open the braid carefully to sheath side, not to deform the braid by removing sheath abt. 25mm. Remove the AL/PET tape by making nicks all around of the tape on X-point of braid foot by cutter etc.



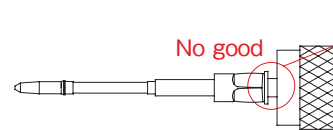
To remove completely the braid debris  
Cut the braid by 10.4mm as per the left-side drawing. At this time, remove the braid debris etc. perfectly by blower and so on as per the photo.



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

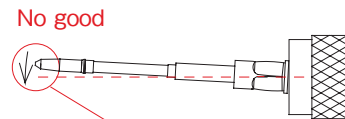


Center contact is properly crimped in order.



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)  
Pay full attention to make sure the center contact edge inserted into the center hole of Teflon insulator inside of connector body.

(Note 4)  
In case of not getting "snap" feeling, do not squeeze forcibly. 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 5)  
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 6)  
When crimp the sleeve, clutch up the grip further to the end after crimp frame ratchet released. To prevent the spring-back (phenomena of the shape trying to return the original), keep the clutched crimping condition for more than one second. At the end, confirm no movement at all by adding force anteroposteriorly to the crimping sleeve.