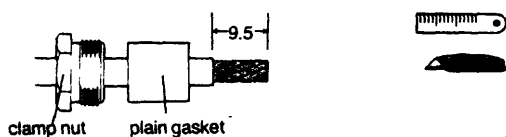


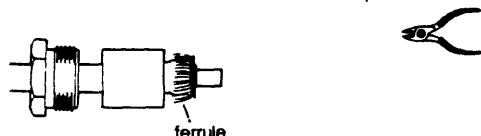
# Assembly instructions

## Instruction (a)

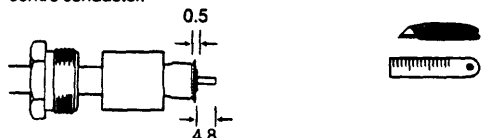
- 1** Slide clamp nut and plain gasket over cable and trim outer sheath from cable, as shown.



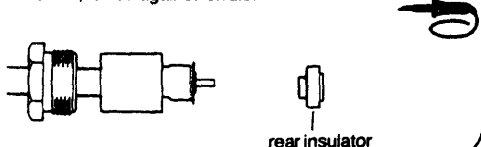
- 2** Fold back braid and push ferrule over dielectric to trap braid between outer sheath and ferrule. Trim off surplus braid.



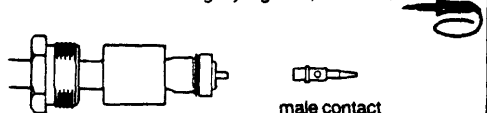
- 3** Trim back dielectric and check the length of the protruding centre conductor.



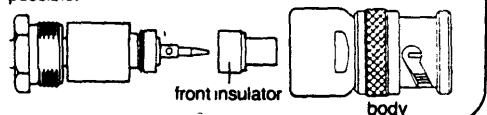
- 4** Tin centre conductor, then slide rear insulator over dielectric, to butt against ferrule.



- 5** Fit contact (male for plugs, female for jacks) onto centre conductor, with collar pressed into recess in rear insulator. Hold cable and contact tightly together, and solder.



- 6** Slide plain gasket and clamp nut up to ferrule, trapping braid. Fit front insulator over contact to butt against rear insulator and press sub-assembly into body as far as possible.



- 7** Engage and tighten clamp nut.

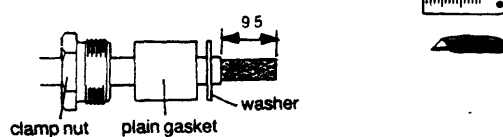


Note: a plug body is shown, but these instructions are relevant to both plugs and jacks. The shape of the contacts and insulators may vary from the drawings shown.

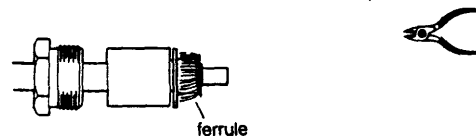
[BNC 001]

## Instruction (b)

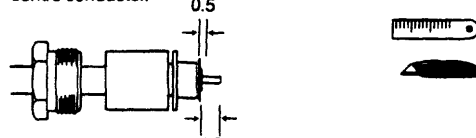
- 1** Slide clamp nut, plain gasket and washer over cable; trim outer sheath from cable as shown.



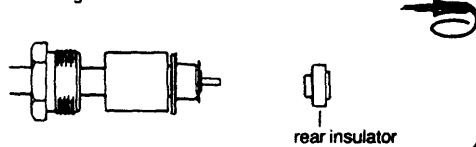
- 2** Fold back braid and push ferrule over dielectric to trap braid between outer sheath and ferrule. Trim off surplus braid.



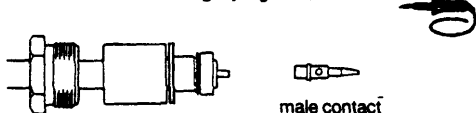
- 3** Trim back dielectric and check length of the protruding centre conductor.



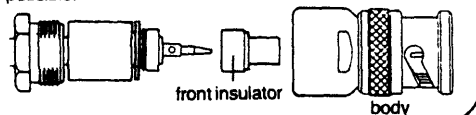
- 4** Tin centre conductor; then slide rear insulator over dielectric to butt against ferrule.



- 5** Fit contact (male for plugs, female for jacks) onto centre conductor, with collar pressed into recess in rear insulator. Hold cable and contact tightly together, and solder.



- 6** Slide washer, plain gasket and clamp nut up to ferrule, trapping braid. Fit front insulator over contact to butt against rear insulator and press sub-assembly into body as far as possible.



- 7** Engage and tighten clamp nut.



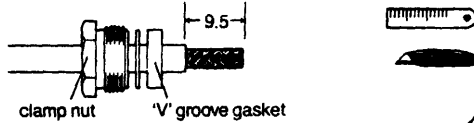
Note: a plug body is shown, but these instructions are relevant to both plugs and jacks. The characteristics of the contacts and insulators may vary from the drawings shown.

[BNC 002]

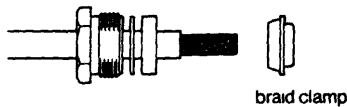
# Assembly instructions

## Instruction (a)

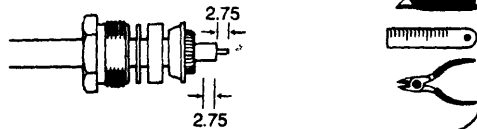
- 1** Slide clamp nut, washer and 'V' groove gasket over cable, (groove of gasket to face free end of cable) Trim outer sheath from cable as shown, without disturbing the braid.



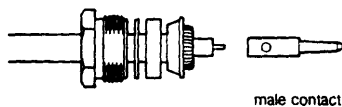
- 2** Slide braid clamp over braid so that internal shoulder butts against face of outer sheath.



- 3** Fold braid back over braid clamp avoiding crossed wires and trim off surplus braid. Trim back dielectric and check length of protruding centre conductor.



- 4** Tin centre conductor and fit contact (male for plugs, female for jacks) onto centre conductor, hold cable and contact tightly together and solder.

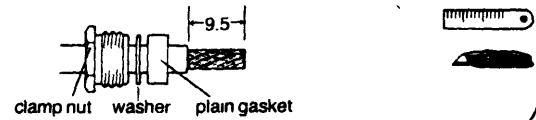


- 5** Slide 'V' groove gasket, washer and clamp nut up to braid clamp and press sub-assembly into body as far as possible.

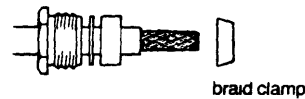


## Instruction (b)

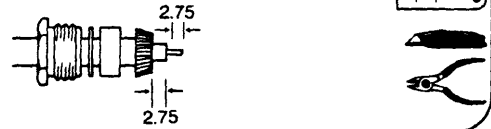
- 1** Slide clamp nut, washer and plain gasket over cable: trim outer sheath from cable as shown, without disturbing the braid.



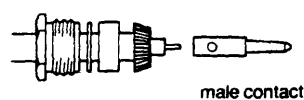
- 2** Fit braid clamp so that the internal shoulder butts to the end of the outer cable



- 3** Fold back braid, avoiding crossed wires, and trim surplus braid. Trim dielectric and check that dimension of exposed centre conductor is as shown.



- 4** Tin centre conductor and fit contact to butt against face of dielectric. Hold cable and contact tightly together and solder.



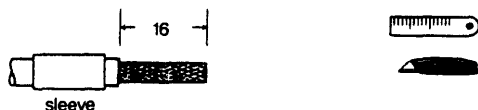
- 5** Slide plain gasket, flat washer and clamp nut to braid clamp and press sub-assembly into body as far as possible.



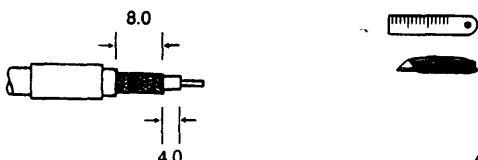
# Assembly instructions

## Instruction (a)

- 1** Slide metal crimp sleeve over cable, trim outer sheath from cable as shown.



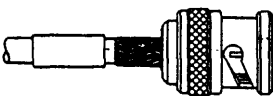
- 2** Trim back braid and dielectric to the dimensions shown.



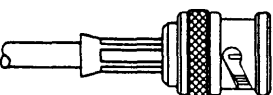
- 3** Fit contact over centre conductor to butt against the dielectric, then crimp.



- 4** Press sub-assembly into body, until contact clicks into place and ensuring that the knurled ferrule is inserted between the dielectric and braid.



- 5** Slide the sleeve along the cable, until it butts against the body sub-assembly. Crimp, using the tool listed below.



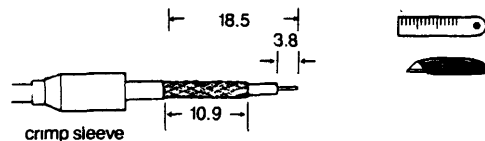
Note: a plug is shown, but these instructions are relevant to both plugs and jacks. The shape of contacts and insulators may also vary from the drawings shown.

Cable groups	Tool	Die	(BS ref)
012	} 30040	(fixed die)	
A25, B25		30032XAX	(WE)
010, B10, 060	} 30040	(fixed die)	
052		30032XAHFD	(WD)
007	30039	30032XAHZH	(WG)

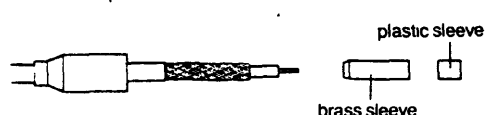
[BNC 005]

## Instruction (b)

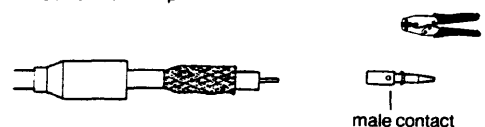
- 1** Slide metal crimp sleeve over cable, trim outer sheath, braid and dielectric as shown.



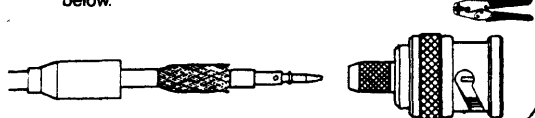
- 2** Slide small brass sleeve over dielectric and under braid. Place small plastic sleeve on the end of the dielectric.



- 3** Fit contact over centre conductor to butt against the dielectric: then crimp.



- 4** Press sub-assembly into body, ensuring knurled ferrule is inserted between the dielectric and braid. Slide sleeve to butt against body sub-assy. Crimp, using the tool listed below.



Note: a plug body is shown, but these instructions are relevant to both plugs and jacks. The shape of contacts and insulators may also vary from the drawings shown.

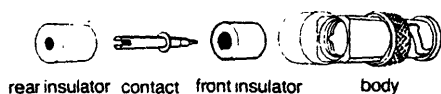
Cable group	Tool	Die	(BS ref)
022	} 30040	(fixed die)	
		30039 30032XAHFD	(WD)

[BNC 006]

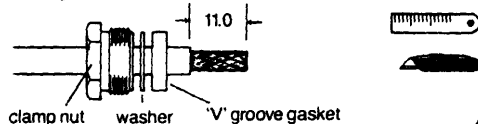
## Assembly instructions

## Instruction (a)

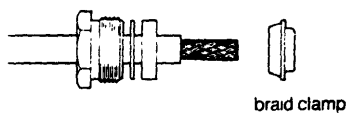
- 1** Assemble contact and insulators in the sequence shown. Fit them into the body with the contact slot aligned ready for the conductor.



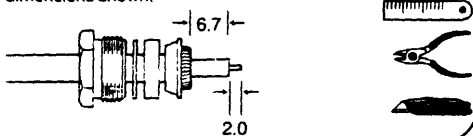
- 2** Slide clamp nut, washer and 'V' groove gasket over cable and trim the outer sheath as shown. Ensure that the groove in the gasket is towards the free end of the cable.



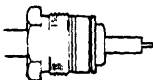
- 3** Fit braid clamp so that internal shoulder butts against the end of the outer sheath.



- 4** Fold back braid avoiding crossed wires and trim the surplus braid. Trim dielectric and the centre conductor to the dimensions shown.



- 5** Slide 'V' groove gasket, flat washer and clamp nut along to the braid clamp ensuring that the groove seats on the clamp.



- 6** Tin centre conductor and press sub-assembly into body. Tighten clamp nut and solder centre conductor to slot in contact.

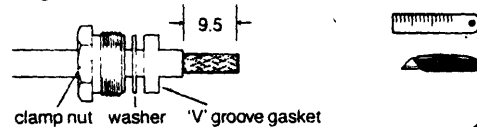


- 7** Fit the small gasket onto the cap, then fit the cupped insulator, followed by the cap, into the body and tighten.

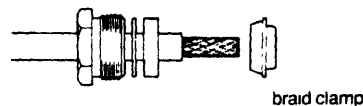


## Instruction (b)

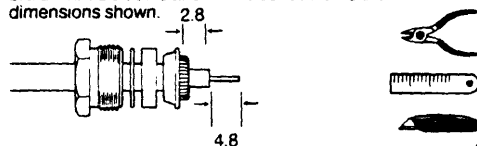
- 1** Slide clamp nut, washer and 'V' groove gasket over cable and trim outer sheath as shown. Ensure that the groove in the gasket is towards the free end of the cable.



- 2** Fit braid clamp so that the internal shoulder butts against the end of the outer sheath.



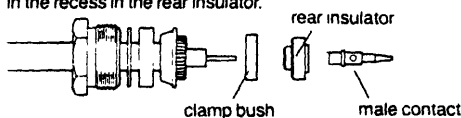
- 3** Fold back braid avoiding crossed wires and trim excess braid. Trim dielectric and centre conductor to the dimensions shown.



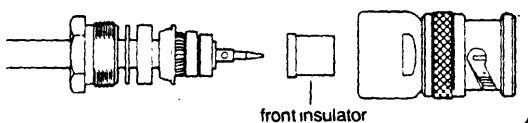
- 4** Tin centre conductor.



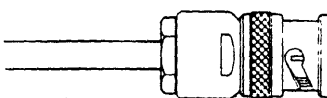
- 5** Slide clamp bush and rear insulator over dielectric to butt against braid. Fit contact (male for plugs, female for jacks) onto centre conductor so that the collar on the contact seats in the recess in the rear insulator.



- 6** Hold contact and cable tightly together and solder.



- 7** Slide 'V' groove gasket, flat washer and clamp nut to braid clamp. Fit front insulator over contact to butt to rear insulator. Press sub-assembly into connector body.



- 8** Engage and tighten clamp nut.

Note: a plug is shown, but these instructions are relevant to both plugs and jacks. The shape of contacts and insulators will vary.

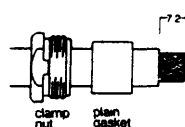
[BNC 007]

[BNC 008]

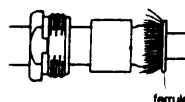
# Assembly instructions

## Instruction (a)

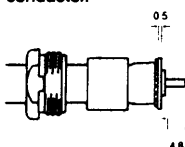
- 1** Slide clamp nut and plain gasket over cable and trim outer sheath from cable as shown.



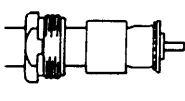
- 2** Fold back braid and push ferrule over dielectric to trap braid between outer sheath and ferrule. Trim off surplus braid.



- 3** Trim dielectric and check length of protruding centre conductor.



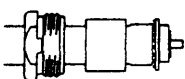
- 4** Tin centre conductor and slide rear insulator over dielectric to butt against ferrule.



rear insulator



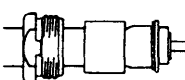
- 5** Fit contact, (male for plugs, female for jacks) onto centre conductor with the collar pressed into the recess in the rear insulator. Hold cable and contact tightly together and solder.



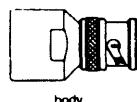
male contact



- 6** Slide plain gasket and clamp nut to the ferrule, trapping braid. Fit front insulator over contact to butt against rear insulator.

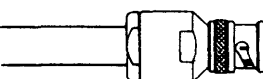


front insulator



body

- 7** Press sub-assembly into body. Engage and tighten clamp nut.

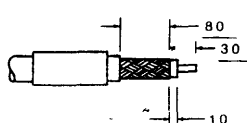


A plug body is shown, but these instructions are relevant to both plugs and jacks. The shape of contacts and insulators will vary.

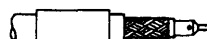
[BNC 009]

## Instruction (b)

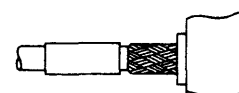
- 1** Slide crimp sleeve over cable and trim as shown.



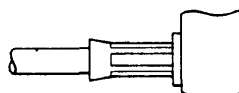
- 2** Fit contact to butt up against dielectric. Then crimp.



- 3** Fit sub-assembly to body ensuring the knurled ferrule is inserted between the dielectric and the braid. Push firmly until contact "clicks" home.



- 4** Slide the crimp sleeve along the cable and over the braid to butt up against the body. Crimp.



- 5** Repeat for other cable entry.

Cable groups	Tool	Die	(BS ref)
B10	} 30040 30039	(fixed die)	
		30032XAHFD	(WD)

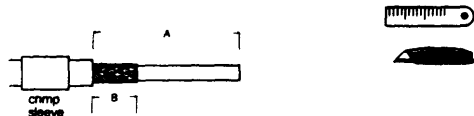
[BNC 010]

## Assembly instructions

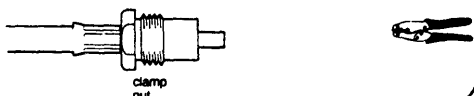
# Assembly instructions

## Instruction (a)

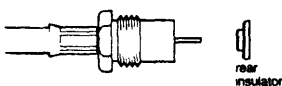
- 1** Slide crimp sleeve over cable. Trim outer sheath and braid to dimensions shown.



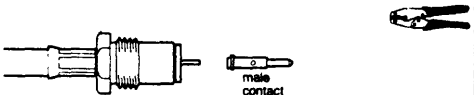
- 2** Place clamp nut over dielectric and under the braid to butt against the outer sheath. Slide sleeve forward until it butts against the clamp nut and crimp, ensuring that the crimp die is touching the face of the clamp nut.



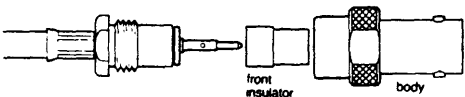
- 3** Trim the dielectric flush with the clamp nut. Slide rear insulator over centre conductor and into recess in the nut, until the insulator butts against the face of the nut.



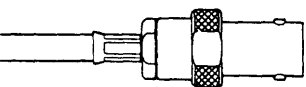
- 4** Fit contact onto centre conductor until the collar butts against face of rear insulator, trimming the conductor if necessary. Crimp the sleeve.



- 5** Fit front insulator over the contact so that it touches the rear insulator. Press sub-assembly into the body.



- 6** Engage and tighten clamp nut.\*



Note: a jack body is shown, but these instructions apply to both plugs and jacks. The shape of the contacts and insulators will vary.

### Dimensions for part 1:

General cables

A=27mm

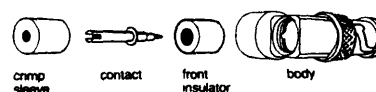
B=8mm

Cable group	Tool	Die	(BS reference)
030	30039	30032XXXED	(VC)
062	30039	30032XXXIA	(VR)
117	30039	30032XXXW	(VQ)

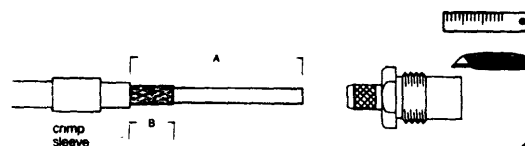
[BNC 013]

## Instruction (b)

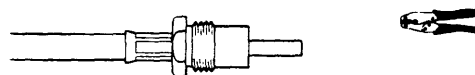
- 1** Assemble the contact and insulators in the sequence shown.



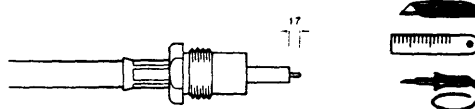
- 2** Slide crimp sleeve over cable. Trim outer sheath and braid to dimensions shown.



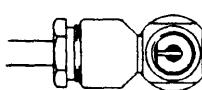
- 3** Place clamp nut over dielectric to butt against outer sheath face ensuring that the knurled ferrule is inserted between the dielectric and braid. Slide the sleeve along the cable until it butts against the clamp nut. Crimp, using the correct tool from the chart.



- 4** Trim dielectric as shown. Tin centre conductor.



- 5** Press sub-assembly into the body and tighten the clamp nut.



- 6** Solder centre conductor to the slot in the contact.



- 7** Fit the small gasket onto the cap, then fit the cupped insulator, followed by the cap, into the body and tighten.



### Dimensions for part 1:

General cables

A=31.5mm

B=8mm

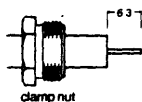
Cable group	Tool	Die	(BS reference)
030	30039	30032XXXED	(VC)
062	30039	30032XXXIA	(VR)
117	30039	30032XXXW	(VQ)

[BNC 014]

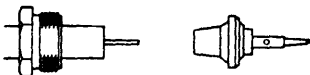
# Assembly instructions

## Instruction (a)

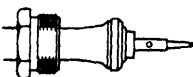
- 1** Slide clamp nut over cable, trim outer sheath, braid and dielectric flush, as shown.



- 2** Push contact/ferrule sub-assembly onto cable until the dielectric touches the insulator and so that the tapered ferrule enters under the braid. The braid and sheath should cover the outside of the tapered ferrule.



- 3** Solder centre conductor onto the contact.



- 4** Push cable assembly into the body.



- 5** Engage and tighten clamp nut.



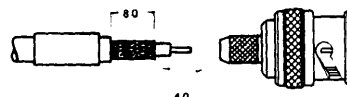
[BNC 015]

## Instruction (b)

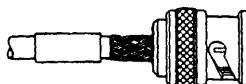
- 1** Slide crimp sleeve over cable, trim outer sheath as shown.



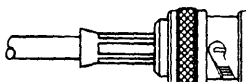
- 2** Trim braid and dielectric to dimensions



- 3** Push cable fully into the body to ensure centre conductor is firmly located in centre contact. Ensure knurled ferrule is inserted under the braid



- 4** Slide crimp sleeve along cable until it butts against the body sub-assembly; then crimp, using tool 30040 or 30039 with die set 30032WD.

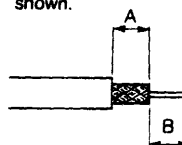


(B)

[BNC 016]

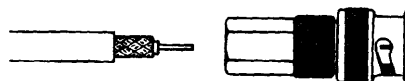
## Instruction (c)

- 1** Trim outer sheath, braid and dielectric to the dimensions shown.

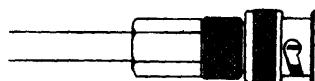


	Straight	Elbow
A	6.4	6.4
B	12.7	6.4

- 2** Twist braid in a clockwise direction to expose the dielectric.



- 3** Push the cable into the connector as far as possible and twist-on.



[BNC 017]



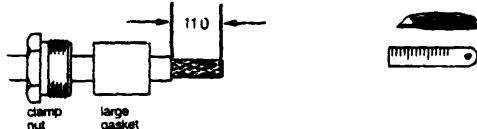
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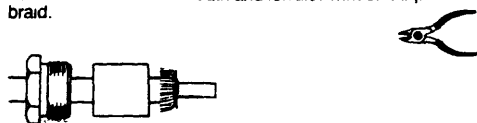
- 1** Assemble the contact and insulators in the sequence shown. Fit them into the body with the contact slot aligned ready for the conductor.



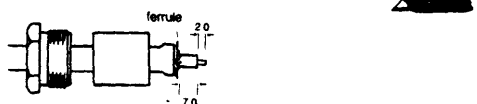
- 2** Slide clamp nut and large gasket over cable and trim outer sheath from cable as shown.



- 3** Fold back braid, and push ferrule over dielectric to trap braid between end of outer sheath and ferrule. Trim off surplus braid.



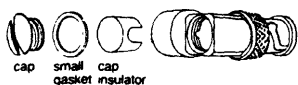
- 4** Slide gasket and nut to ferrule, trapping the braid against the flange. Trim back dielectric and check the length of the protruding centre conductor.



- 5** Tin centre conductor and press sub-assembly into the body. Tighten clamp nut and solder centre conductor to slot in contact.



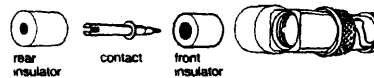
- 6** Fit the small gasket onto the cap, then fit the cupped insulator, followed by the cap, into the body and tighten.



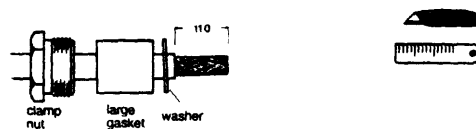
[BNC 018]

## Instruction (b)

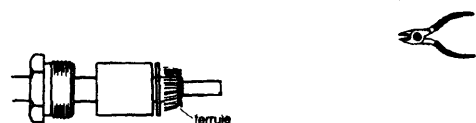
- 1** Assemble the contact and insulators in the sequence shown. Fit them into the body with the contact slot aligned ready for the conductor.



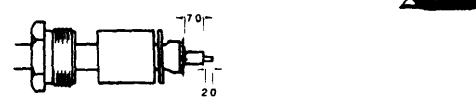
- 2** Slide clamp nut, large gasket and washer over cable and trim outer sheath from cable as shown.



- 3** Fold back braid and push ferrule over dielectric to trap braid between end of outer sheath and ferrule. Trim surplus braid.



- 4** Slide gasket nut and washer to ferrule, trapping the braid against the flange. Trim dielectric and check the length of the protruding centre conductor.



- 5** Tin centre conductor and press sub-assembly into the body. Tighten clamp nut and solder centre conductor to slot in contact.



- 6** Fit the small gasket onto the cap, then fit the cupped insulator, followed by the cap, into the body and tighten.

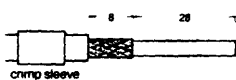


[BNC 019]

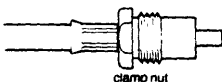
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## Instruction (a)

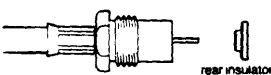
- 1** Slide crimp sleeve over cable and trim outer sheath and braid to dimensions shown.



- 2** Place clamp nut over dielectric and under the braid to butt against the outer sheath. Slide sleeve forward until it butts against the clamp nut and crimp, with the tool touching the nut.



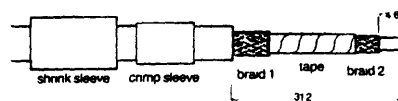
- 3** Trim dielectric flush with clamp nut. Slide rear insulator over centre conductor and into clamp nut recess until insulator butts to clamp nut.



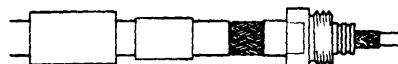
- 4** Fit contact onto centre conductor until collar butts to rear insulator, trimming conductor if necessary. Crimp the contact.

## Instruction (b)

- 1** Slide shrink sleeve and long crimp sleeve over cable. Trim outer sheath and braid to dimensions shown. (For cable with three braids, trim outer-most braid to the 31.2mm dimension shown)



- 2** Place knurled part of ferrule over tape and under braid 1. Slide long crimp sleeve over braid to butt against ferrule and then crimp, using tool 30040 or 30039 with die set 30032 XAHFD



- 3** Fold braid 2 back over grooved portion of ferrule. Slide short crimp sleeve over braid to butt against ferrule and crimp. Trim excess braid.



- 4** Trim dielectric to dimension shown. Slide rear insulator over cable and onto short crimp sleeve. Fit contact over centre conductor to butt against insulator and then crimp.

