

Cannon



ITT Industries, Cannon 75 Ohm Right Angle BNC Plug



Tooling and Assembly Procedures For Field Installation

For further information or sample requests, please contact:

ITT Industries, Cannon
100 Sebeth Dr.
Cromwell, CT 06416

Phone: 860-635-1500
Fax: 860-635-2010
rfproducts.crom@itt.com

Tooling Required

Mitutoyo 1411w/BNC adapter measures BNC pin height. Other calibrated measuring devices are available.

Many of the crimp tools out in the field have dies that provide both hex's required to crimp 735 (.178 hex) and 734 (.255 hex) cable types. It is always a good practice to use tooling that is calibrated. In fact, many customers require it.

We recommend you use the Cannon crimp tool, but other tools are available from other manufacturers to crimp the center pin. It is always a good practice to use tooling that is calibrated. In fact, many customers require it.

Option 1: Using Existing Field Tooling

Mitutoyo 1411w/BNC adapter measures BNC pin height. Other calibrated measuring devices are available.

.178 crimp die set
Cannon P/N 050-000-0030160
Note: dies halves are marked with red dots. Red indicates dies are for 735 cable types.

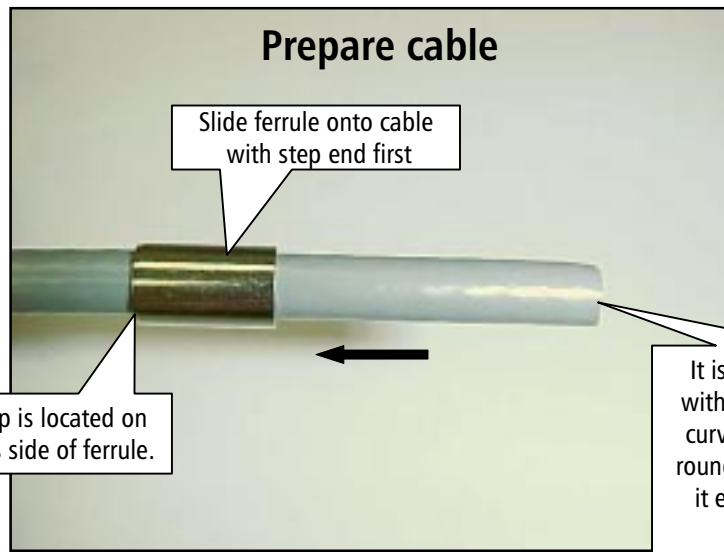
.255 crimp die set
Cannon P/N 050-000-0030170
Note: dies halves are marked with yellow and blue dots. Yellow indicates RG-59 cable and blue for 734 cable types

12 point crimp indent tool
Cannon P/N 050-000-0030070
Tool comes calibrated when purchased and is designed to be re-calibrated.

Crimp tool frame
Cannon P/N 050-000-0030210
Note: frame is also designed to accommodate Cannon QT-BNC crimp dies. Tool comes calibrated when purchased and is designed to be re-calibrated.

Option 2: Using Cannon Tooling

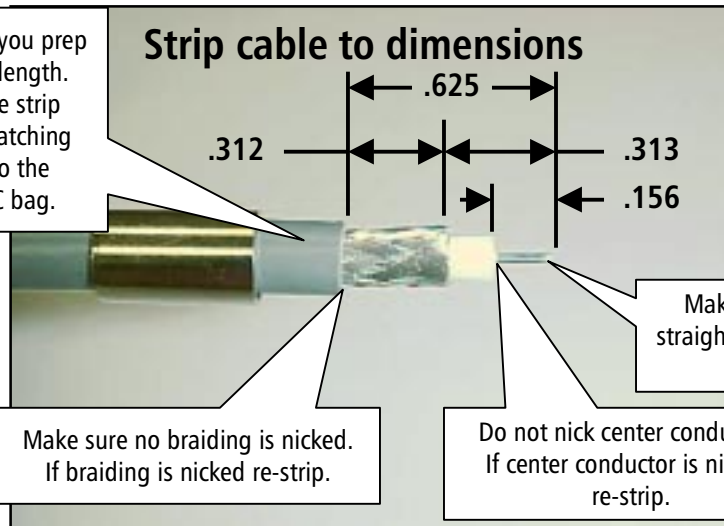
STEP 1



It is important to cut the cable with a sharp pair of cutters with curved blades. Maintaining the roundness of the cable will make it easier for the cable stripper to prep the cable.

STEP 2

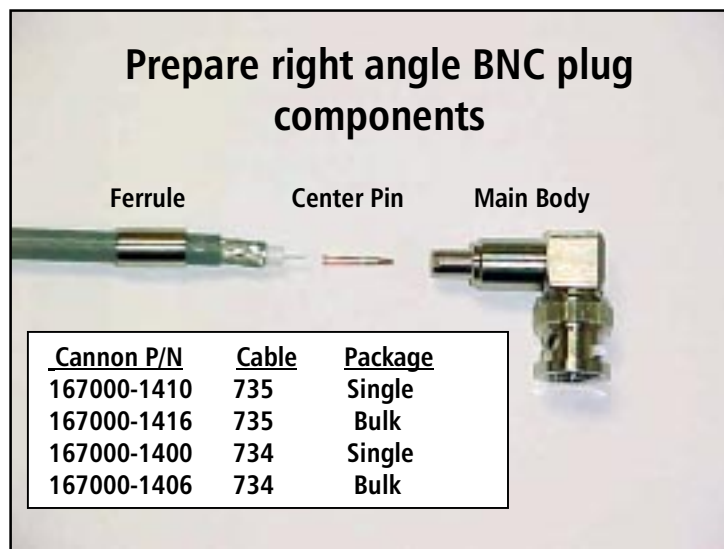
It is recommended that you prep the cable to our strip length. You can verify that the strip length is correct by matching the prepped cable to the template on the BNC bag.



Make sure no braiding is nicked. If braiding is nicked re-strip.

Do not nick center conductor. If center conductor is nicked re-strip.

STEP 3



STEP 4

Crimp center pin using options (1 or 2) tool

Position contact as shown. It should rest against dielectric

Insert pin assembly into tool

Insert pin assembly until it stops, hold in position making sure dielectric is butting against contact pin. Then squeeze handles until ratchet releases on tool. Remove crimped pin assembly and inspect.

Make sure center conductor of cable is visible inside hole of contact pin located here

12 point crimp indent tool

STEP 5

Inspect crimped contact

Notice contact pin rests against dielectric

Inspect crimped pin. There should be 12 uniform indents round the pin as shown in figure. Now perform a light pull test to verify pin is properly crimped onto cables center conductor.

Hole Location

Note: If pin pulls off during light pull test, tool may need to be re-calibrated. Crimped pin should hold a minimum of 6 lbs..

STEP 6

Install cable sub-assembly

Flair braid before inserting main body of connector

Insert rear post of main body between cables foil and braid until contact snaps into position. Again, perform a light pull test to verify that contact pin is seated.

Prepare to crimp ferrule

Dress braid evenly around rear post.
Slide ferrule over braid until it rests
flush against main body.

STEP 7

Make sure no braid is visible
between ferrule and main body.
If stray braiding is found in this
area, your customer may require
you to replace the connector

Complete termination with option 1 crimp tool

Make sure ferrule is aligned in
between the two die halves before
crimping.

The BNC body must rest
against the edge of the
hex die.

STEP 8

Squeeze handles until ratchet releases in
hand tool. Remove BNC from tool.
Perform a light pull test and visually
inspect finished assembly.

Gauge interface to measure pin height

Mate BNC to back of gauge

Mitutoyo 1411 gauge
with BNC adapter

Follow manufacturers instructions
to ensure gauge is properly set prior
to each days use.

STEP 9

Important: BNC's must
be checked 100% for pin
height.

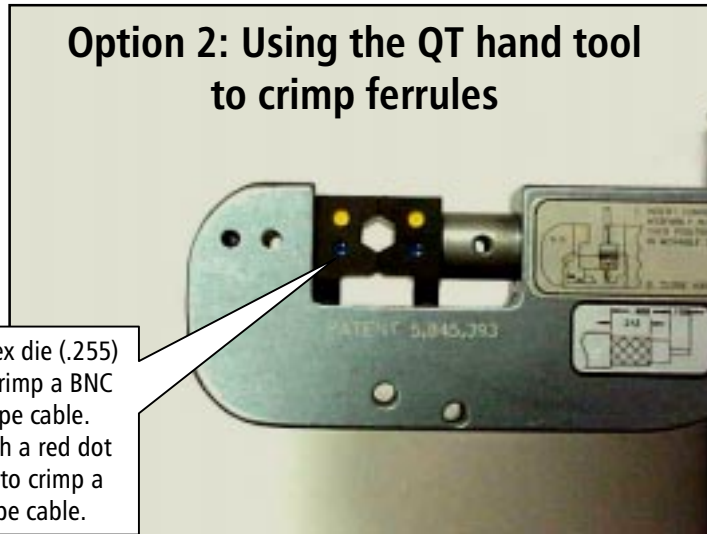
Note: All Telco's require you check the BNC interface to
make sure it meets their pin height specification. Most
specifications require each BNC assembled be checked with
a calibrated measuring device. There are other measuring
devices available from other manufacturers not shown
above.

It is very important to check
the customers specification
for +/- tolerance for center
pin height.

Option 2: Using the QT hand tool to crimp ferrules

STEP 8a

Note: blue dot on hex die (.255) indicates this will crimp a BNC ferrule for 734 type cable. A hex die (.178) with a red dot would be required to crimp a ferrule for 735 type cable.

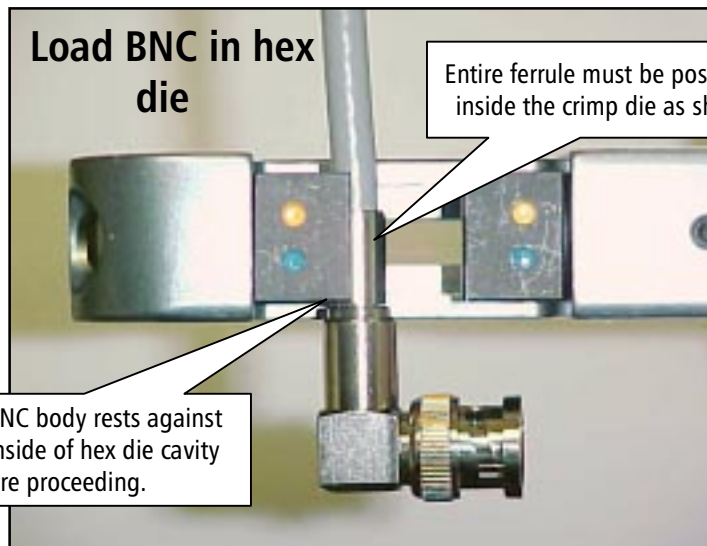


Load BNC in hex die

Entire ferrule must be positioned inside the crimp die as shown.

STEP 8b

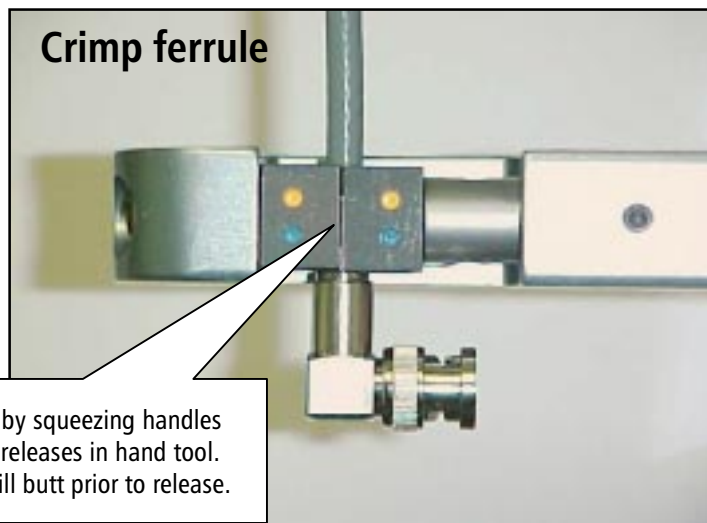
Make sure BNC body rests against edge, not inside of hex die cavity before proceeding.



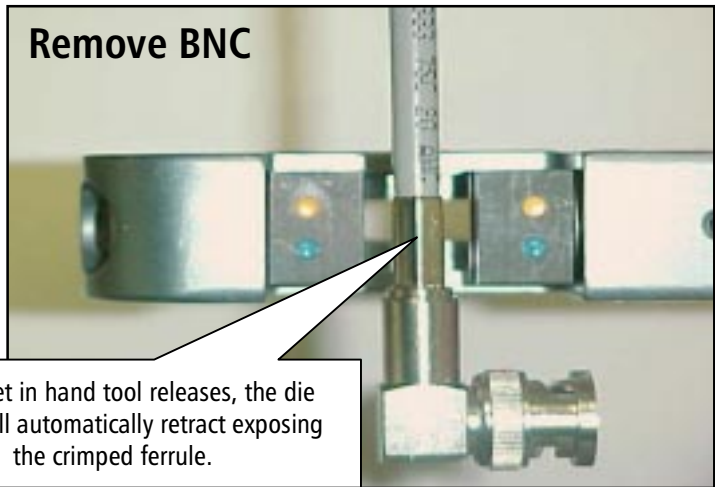
Crimp ferrule

STEP 8c

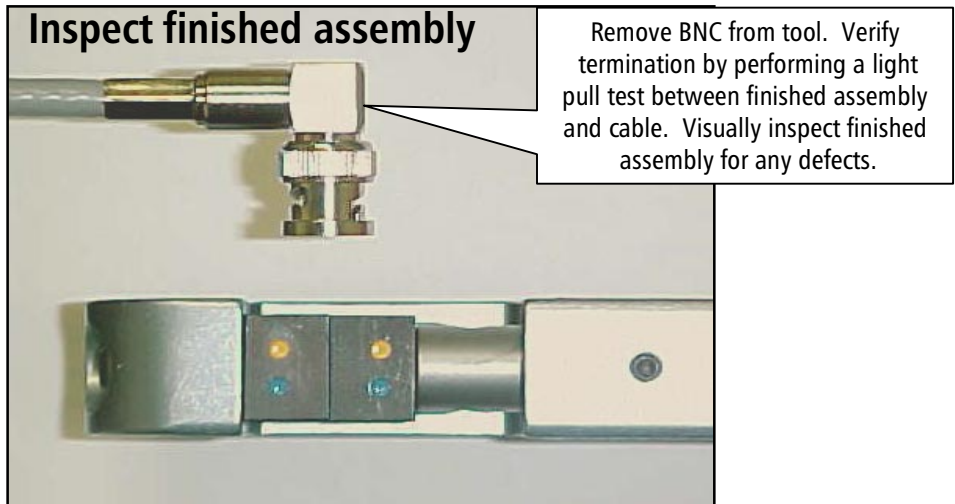
Crimp ferrule by squeezing handles until ratchet releases in hand tool. Die halves will butt prior to release.



STEP 8d



STEP 8e



STEP 9

