

Part Number	Description	Cable
1274563-1, 1274640-1	Mini BNC Straight Cable Plug Connector	735A
1274563-2, 1274640-2, 1274975-1	Mini BNC Straight Cable Plug Connector	734A
1274563-3	Mini BNC Straight Cable Plug Connector	RG179
1274568-1, 1274671-1	Mini BNC Straight Cable Jack Connector	735A
1274568-2	Mini BNC Straight Cable Jack Connector	734A
1274568-3	Mini BNC Straight Cable Jack Connector	RG179

Figure 1

## 1. INTRODUCTION

This instruction sheet contains the assembly procedures for the Mini BNC Straight Cable Plug Connectors and Mini BNC Straight Cable Jack Connectors shown in Figure 1. These connectors are crimp attachment type connectors that attach to the cable listed in Figure 1.

The table in Figure 2 references the crimp tooling used to apply these connectors. The table includes crimp tooling descriptions and part number.

TOOL DESCRIPTION	PART NUMBER CROSS-REFERENCE	
	Part Number	Crimp Configuration Contact(Sq)/Ferrule(Hex)
PRO-CRIMPER* III Frame	354940-1	--
Crimp Die (735A and RG179)	58425-2	.042 [1.07]/ .178 [4.52]
Crimp Die (734A)	58425-1	.042 [1.07]/ .255 [6.48]

Figure 2

**NOTE** Dimension on this sheet are in inches [with millimeters in brackets] unless otherwise specified.

## 2. DESCRIPTION

Each Mini BNC Straight Cable Connector (Plug and Jack) consists of a subassembly, a center contact, and a crimp ferrule. See Figure 1.

## 3. ASSEMBLY PROCEDURE

**NOTE** Although the illustrations show Mini BNC Straight Cable Plug Connector 1274563-[ ] and Mini BNC Straight Cable Jack Connector 1274568-[ ], the assembly procedures for all plugs and jacks are identical.

**DANGER** Follow safety precautions included with the tools used for assembly.

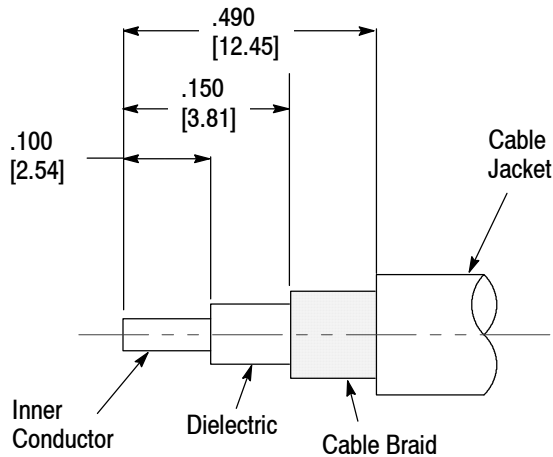


Figure 3

1. Slide the crimp ferrule onto the cable.



To avoid personal injury, be sure to use appropriate safety equipment, including gloves, when using cable stripping tools.

2. Strip the cable according to the dimensions in Figure 3.

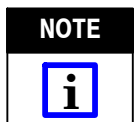


Do NOT damage the cable braid, dielectric, or inner conductor of the cable.

3. Push the center contact over the center conductor and crimp using the tooling listed in Figure 2. See Figure 4.

4. Flare the cable braid. See Figure 5. Then push the subassembly over the center contact, under the cable braid until the center contact snaps into place.

5. Slide the crimp ferrule over the flared cable braid and the housing assembly. While holding the crimp ferrule, pull back slightly on the cable to insure that the center contact is seated in the subassembly.



Do not slide larger diameter crimp ferrules beyond the ferrule stop. Refer to Figure 6. (This applies to the 1274563 1274640 series only.)

6. Crimp using the tooling listed in Figure 2. Refer to Figure 6.

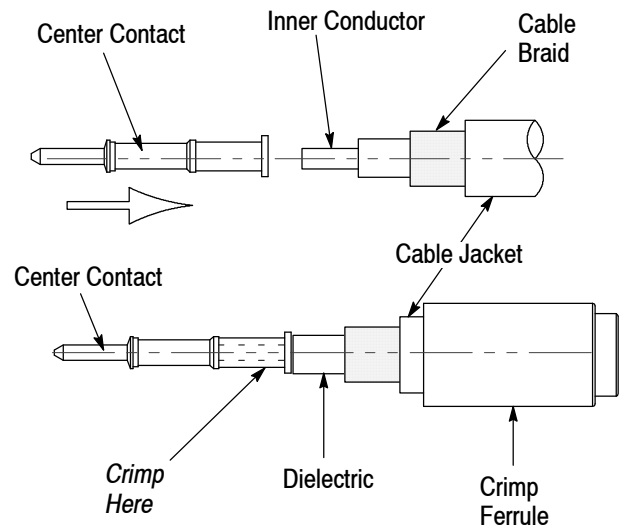


Figure 4

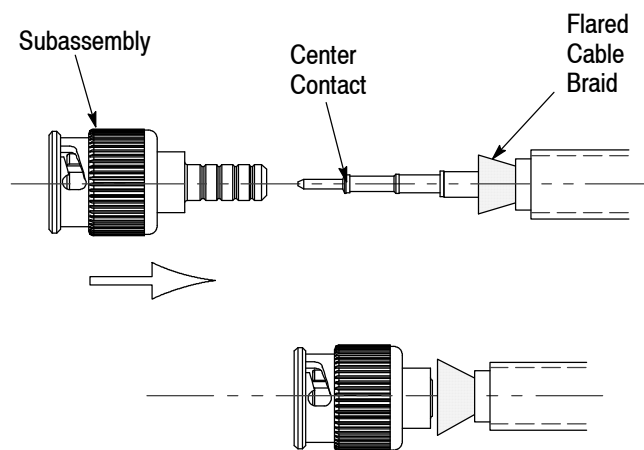
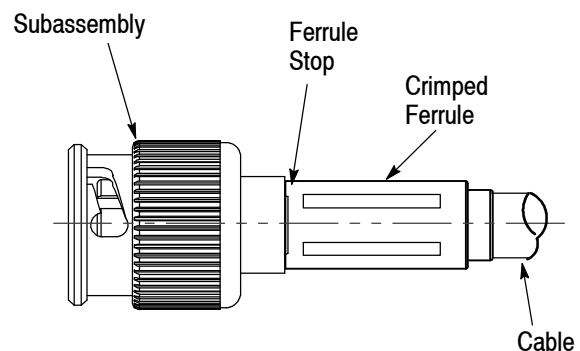


Figure 5



Crimp Using the Tooling in Figure 2

Figure 6

#### 4. REVISION SUMMARY

- Updated document to corporate requirements.