

Tyco Electronics Part Number	Description	Cable
1274566-1	Mini BNC Right-Angle Cable Plug Connector	735A
1274566-2	Mini BNC Right-Angle Cable Plug Connector	734A

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedure for the Mini BNC Right-Angle Cable Plug Connector shown in Figure 1. This connector is a solder/crimp-type attachment connector that attaches to the cable listed in Figure 1.

The table in Figure 2 references the crimp tooling used to apply this connector. The table includes tool descriptions, the Tyco Electronics part number, and the crimp configuration for the tooling.

NOTE

Dimension on this sheet are in inches [with millimeters in brackets], unless otherwise specified. Figures are not drawn to scale.

2. DESCRIPTION

Each Mini BNC Right-Angle Cable Plug Connector consists of a subassembly, a crimp ferrule, and a cap. See Figure 1.

3. ASSEMBLY PROCEDURE

- Slide the crimp ferrule onto the cable.

DANGER

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

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

CAUTION

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

Tool Description	Tyco Electronics Part Number	Crimp Configuration Ferrule [Hex]
Pro-Crimper Hand Tool Frame	354490-1	--
Crimp Die (735A)	58425-2	.178 [4.52]
Crimp Die (734A)	58425-1	.255 [6.48]

Figure 2

- Flare the cable braid and push the subassembly over the inner conductor (under the cable braid). See Figure 4.
- Slide the crimp ferrule back over the cable braid and housing assembly until the inner conductor is positioned in the center contact slot. See Figure 4.

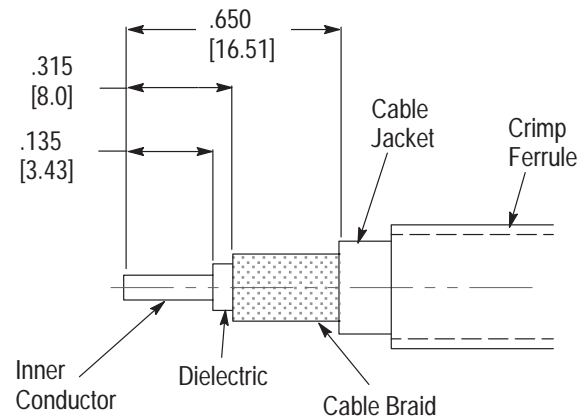


Figure 3

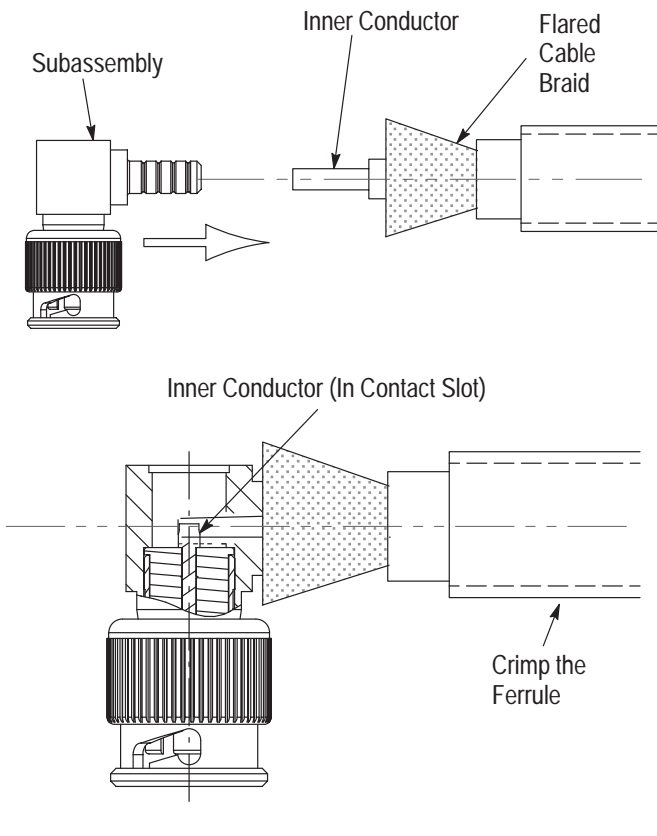


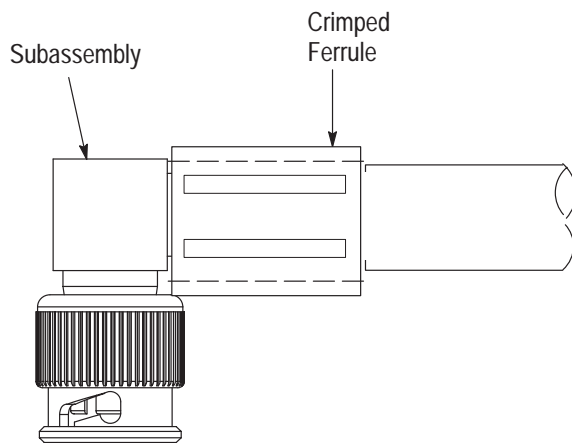
Figure 4

5. Crimp using the tooling listed in Figure 2. See Figure 5.

DANGER

To avoid personal injury, be sure to exercise caution when handling hot soldering equipment.

6. Solder the cable inner conductor to the center contact in the housing assembly. See Figure 6.



Crimp Using the Tooling in Figure 2

Figure 5

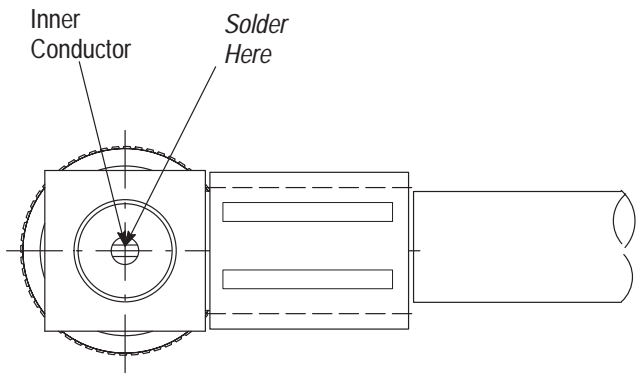


Figure 6

7. Place cap in the subassembly as shown in Figure 7. Peen or dimple the cap firmly in place.

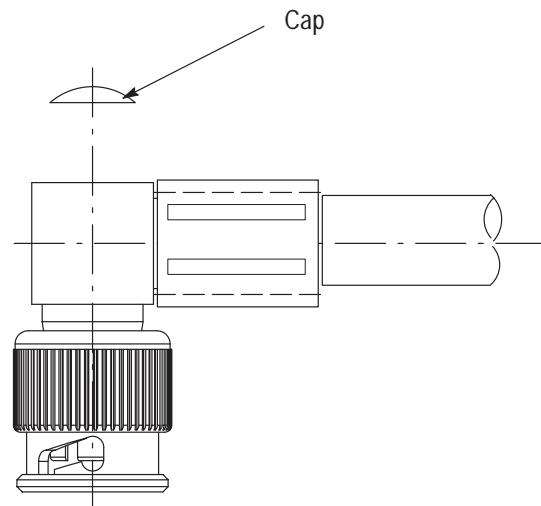


Figure 7

4. REVISION SUMMARY

Per EC 0990-0559-04

- Added 127456-2 and 58425-1