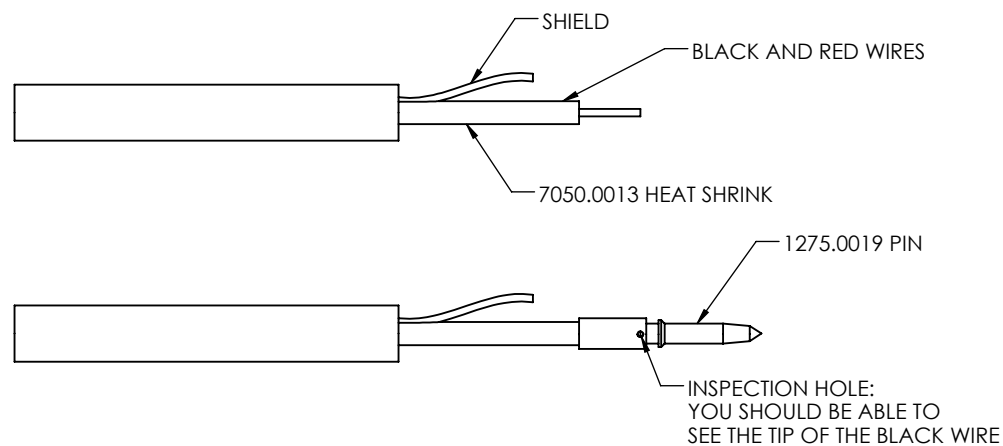
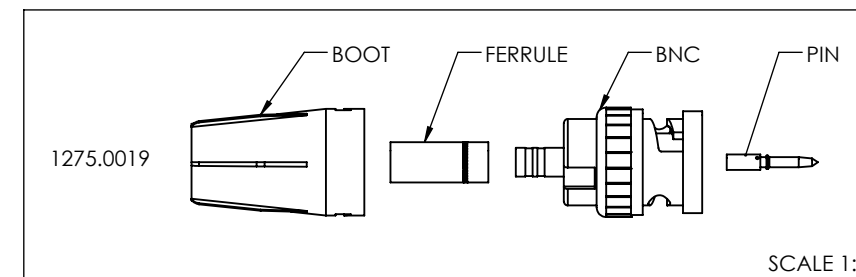


REV.	DESCRIPTION	DATE	BY	ECO
A	INITIAL ASSEMBLY DRAWING CREATED	3/7/2011	WS	
B	ADDED TABLE AND DRAWING UNDER BILL OF MATERIALS CBL180 LABEL INSTRUCTION WAS ALSO ADDED	3/28/2012	WS	4097
C	PART 1275.0019 UPDATED TO rearTWIST BNC CONNECTOR. STEPS FOR TERMINATING CONNECTOR UPDATED	7/28/2015	SJA	4410
D	REBUILT MODELS AND DRAWING, REVISED INSTRUCTIONS, ADDED USED PARTS TO BOM	10/30/2018	D. WEBSTER	4749



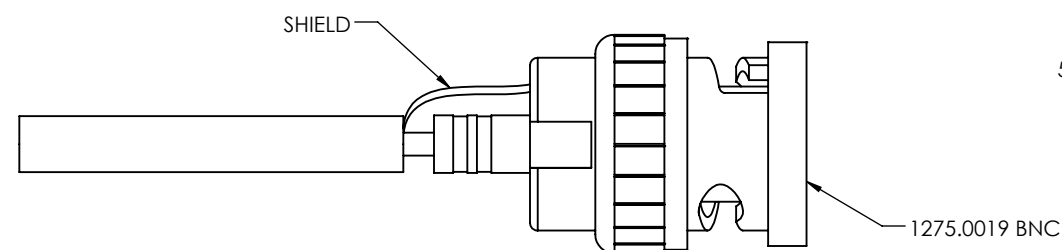
ASSEMBLY INSTRUCTIONS:

1. SLIDE 1275.0019 BOOT AND FERRULE ONTO THE CABLE AS SHOWN.
2. CUT THE WIRES TO THE GIVEN LENGTHS, AND REMOVE THE PLASTIC FROM THE SHIELD. DON'T TIN ANY WIRES.
3. APPLY 7050.0013 HEAT SHRINK TUBING TO THE RED AND BLACK WIRES, LEAVING THE TIP OF THE BLACK WIRE EXPOSED AND SHIELD OUT.
4. INSTALL THE 1275.0019 PIN ON THE BLACK WIRE AND CRIMP WITH 0.068 HEX DIE. USE THE INSPECTION HOLE TO ENSURE THE WIRE IS INSERTED FAR ENOUGH.
5. PUSH THE CABLE INTO THE 1275.0019 BNC CONNECTOR UNTIL THE PIN SNAPS INTO PLACE. PULL PIN WITH SMOOTH PLIERS (DO NOT DAMAGE SURFACE FINISH) AS NEEDED, LEAVING THE SHIELD OUT.

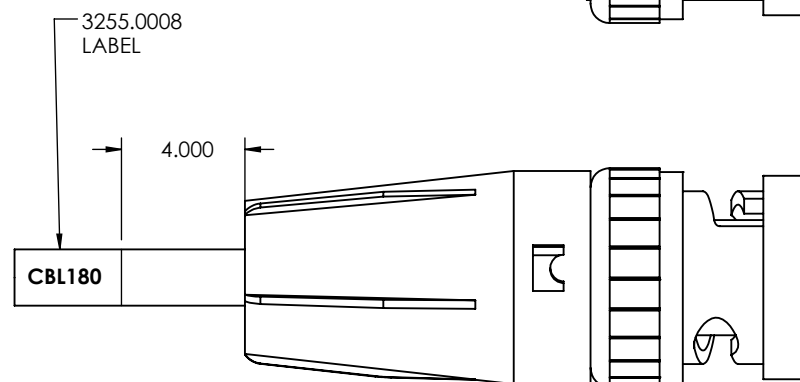
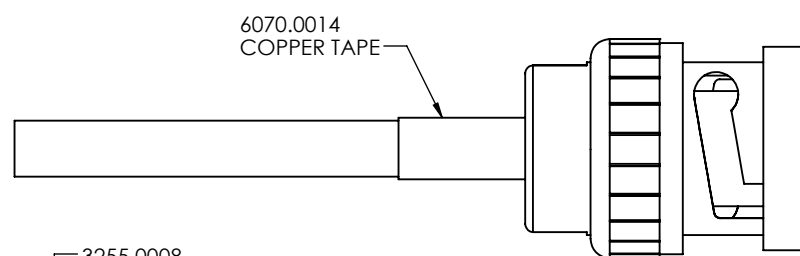
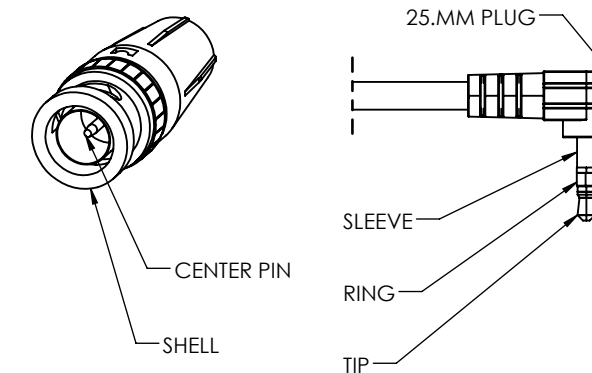


TEST FOR CONTINUITY AND SHORTS:  
THE SHELL AND CENTER PIN OF THE BNC CONNECTOR SHOULD BE CONNECTED TO THE SLEEVE AND RING OF THE 2.5MM PLUG, RESPECTIVELY. THE TIP OF THE 2.5MM PLUG SHOULD HAVE NO CONTINUITY.

BCN CONNECTOR	2.5MM PLUG
SHELL/GROUND	SLEEVE
CENTER PIN	RING
NO CONNECT	TIP



6. ENSURE THE SHIELD WIRES ARE TOUCHING THE BNC CONNECTOR BODY AND APPLY A 0.50" X 0.25" STRIP OF 6070.0014 COPPER TAPE OVER CONNECTOR BODY AND SHIELD. TRIM SHIELD WIRES AS NEEDED.



7. SLIDE THE FERRULE OVER THE BNC CONNECTOR BODY AND CRIMP WITH 0.178 HEX DIE.
8. SNAP THE BOOT ONTO THE BNC CONNECTOR BODY.
9. ADD PRINTED LABEL 3255.0008 "CBL180" WITH THE LATEST REV.
10. TEST THE CABLE FOR CONTINUITY USING THE CHART AND DIAGRAM GIVEN.
11. PLACE COMPLETED CABLE IN BAG WITH 1275.0020 CONN BNC ADAPT JACK AND CERTIFICATE OF COMPLIANCE PAPER. PRINT BARCODE LABEL AND ATTACH IT TO THE BAG.

Notes:

1. See BOM as provided by PCB Engineering.
2. All equivalencies must be approved by PCB Engineering.
3. All components and processes must be **ROHS** compliant.

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3/7/2011

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TITLE  
**CBL180 ASSEMBLY INSTRUCTIONS**

SIZE **B** NUMBER **CBL180** REV. **D**

SCALE 2:1 SHEET 1 OF 1