

CASA Assembly Instruction for:- "16SMA-PE-RG316-xxxmm(HS)"

Assembly & Cable Preparation details for the following CASA Crimp Coaxial Connectors:-

Note - Single screened cables RG17/RG316 etc. may be used provided the

single screen crimp ferrule substituted with the double screen part.

16SMA-50-2-RG316 (may be already fitted to supplied cable

etc.

$$\text{CUT Length} = "CL" = OL - 4 \text{ mm}$$

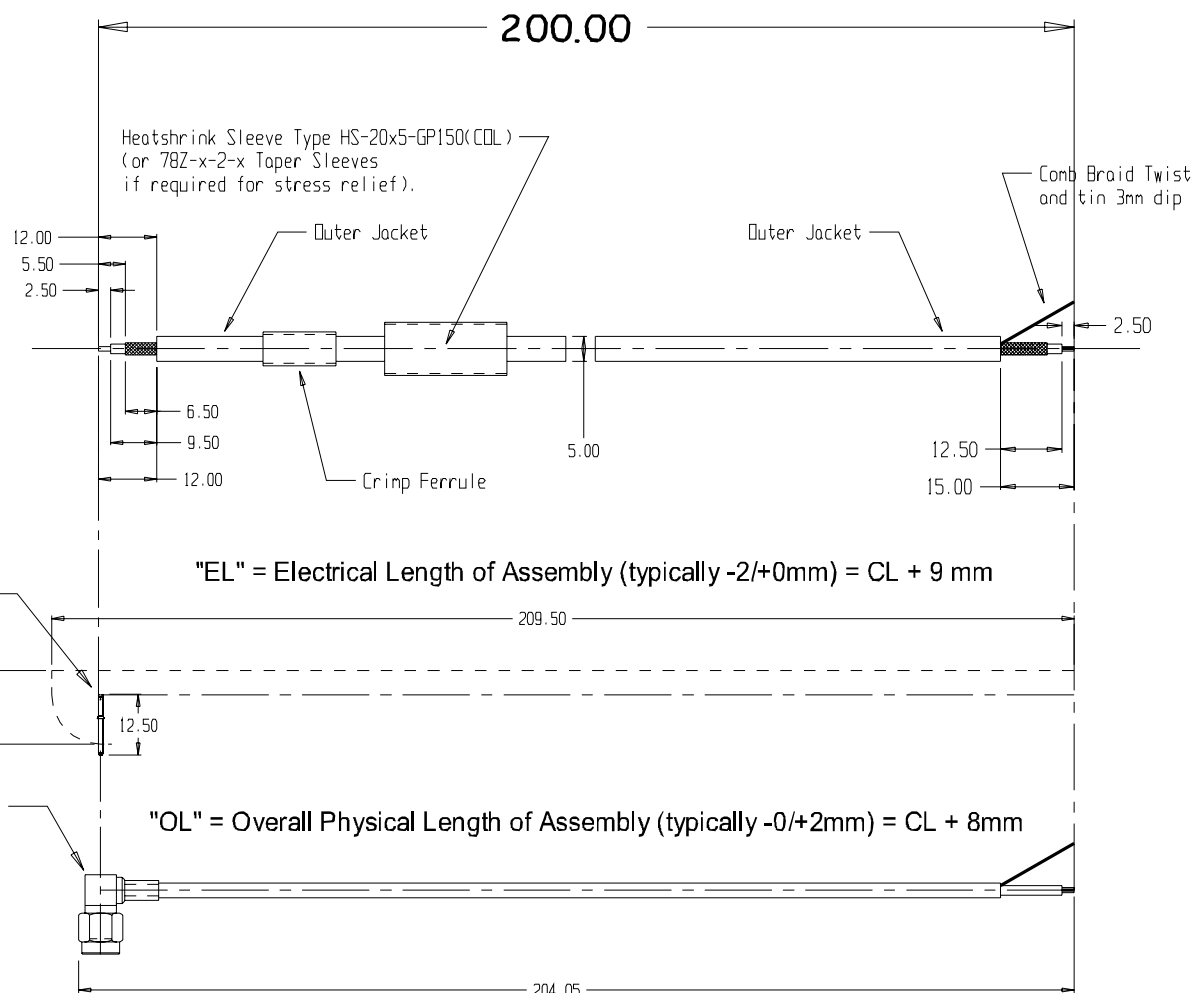
Schleuniger 207

Cable # xx

Step 1 = 02.5 x 1.44

Step 2 = 5.50 x 0.84

Step 3 = 12.0 x 0.30



Installation Steps:-

- 1) Prepare Cable End to Drawing detail shown here
- 2) Fit HS ID Marker/labels and clear HS cover tubes
- 3) Fit and CRIMP centre pin onto centre conductor
- 4) Fit Ferrule (and Heatshrink/Taper Sleeve)
- 5) Clean and Inspect dielectric to contact interface
- 6) Flare Braid to receive spigot
- 7) Install Connector Body onto contact & cable
- 8) Slide Ferrule over Spigot & Braid
- 9) Crimp Ferrule with "2B" (5.5mm Hex) Orange Cavity
- 10) Install Heatshrink (or taper sleeve).
- 11) Heatshrink Sleeves and ID markers as appropriate
- 12) Strip Prepared end jacket to drawing
- 13) Comb braid and fold back over jacket
- 14) Strip dielectric to drawing
- 15) Flair and twist braid to single tail
- 16) Tin dip braind and dilectric to 2mm deep

? Absolute MINIMUM Cable Length =
2 x (14+7.7) = 43.4mm without heatshrink

? RECOMENDED Pracital Minimum = 50mm
with or without Heatshrink.

? Minimum Cable length WITH Taper Sleeves
2 x (38 + 7.7) + 14 = 105.4mm

JOB No.

2649

Use the SUHNER "RED" 75Z-0-2-4 (1B) Hand Tool or "Red" Die-Sets 76Z-0-2-1 or xx
Crimp Cavity Size 1.6mm (0.063") square + 5.5mm (0.217") AF hexagonal for the Ferrule
The centre pin is crimped unless soldering is being specified by the customer.

CASA Modular Systems

P.O. BOX 38-828, WELLINGTON, NEW ZEALAND

TELEPHONE : (64-4) 9393 777

FACSIMILE : (64-4) 9393 778

CUSTOMER : CASA Modular Systems

DESCRIPTION :
16SMA to Prepared End Cable Assembly Instruction

DRAWN : A.W.D

DATE : 10/04/07

APPROVED : ?

DWG. SCALE : 1:1

SIZE

A4

DRAWING Reference No.

16SMA-PE

ISSUE

A

© COPYRIGHT : CASA Modular Systems
ALL RIGHTS RESERVED