Tuesday, April 10, 2007 21:59:00 CASA Assembly Instruction for: - "16SMA-16SMA-RG316-xxxmm(HS)" Installation Steps:-Assembly & Cable Preparation details for the following CASA Crimp Coaxial Connectors:-1) Prepare Cable End to Drawing detail shown here Note - Single screened cables RG17/RG3164 etc. may be used provided the 2) Fit HS ID Marker/labels and clear HS cover tubes single screen crimp ferrule substituted with the double screen part. 16SMA-50-2-RG316 (may be already fitted to supplied cable 3) Fit and CRIMP centre pin onto centre conductor 165MA-50-2-RG316 (Suhner or equivalent) 4) Fit Ferrule (and Heatshrink/Taper Sleeve) CUT Length = "CL" = OL - 8 mm 5) Clean and Inspect dielectric to contact interface 6) Flare Braid to receive spigot 200.00 7) Install Connector Body onto contact & cable "CL" = Cut Length of Cable = OL - 8mm 8) Slide Ferrule over Spigot & Braid Heatshrink Sleeve Type HS-20x5-GP150(CDL) Heatshrink Sleeve Type HS-20x5-GP150(CDL) (or 78Z-x-2-x Taper Sleeves (or 78Z-x-2-x Taper Sleeves 9) Crimp Ferrule with "2B" (5.5mm Hex) Orange Cavity if required for stress relief). if required for stress relief). 10) Install Heatshrink (or taper sleeve). 12.00 Duter Jacket Duter Jacket 12.00 -5.50 11) Heatshrink Sleeves and ID markers as appropriate 2.50 -3rd Cut Dielectric (12.0 x 0.30) Schleuniger 207 -6.506.50 - 2nd Cut Jacket + Braid (5.50 x 0.85) Cable # 17 (24BNC-50-2-KC19-93) - 9.50 9.50 1st Cut Jacket (2.50 x 1.44) 5.00 Step 1 = 08.3×3.00 12.00 Crimo Ferrule Crimp Ferrule 12.00 Step 2 = 13.1×1.84 CF-4x3.4x7-CuNi Step $3 = 17.1 \times 0.90$ Internal FIXED contact "EL" = Electrical Length of Assembly (typically -2/+0mm) = CL + 19mm in 16SMA... body Solder-Pin in 16SMA Body 219.00 ? Absolute MINIMUM Cable Length = $2 \times (14+7.7) = 43.4$ mm without heatshrink ? RECOMENDED Pracital Minimum = 50mm 12.50 7.50 with or without Heatshrink. Angular/Radial orientation ? Minimum Cable length WITH Taper Sleeves "OL" = Overall Physical Length of Assembly (typically -0/+2mm) = CL + 8mm to suit client requirements $2 \times (38 + 7.7) + 14 = 105.4$ mm (specify 0~180 degrees) 16.28 JOB No 2649 CUSTOMER SIZE DRAWING Reference No. CASA Modular Systems Modular Systems Use the SUHNER "RED" 75Z-0-2-4 (1B) Hand Tool or "Red" Die-Sets 76Z-0-2-1 or xx 16SM-16SM DESCRIPTION "16SMA-16SMA" Cable Assembly Instruction Crimp Cavity Size 1.6mm (0.063") square + 5.5mm (0.217") AF hexagonal for the Ferrule BOX 38-828. WELLINGTON, NEW ZEALAND $\overline{ extbf{(C)}}$ COPYRIGHT : CASA Modular Systems TELEPHONE : (64-4) 9393 777 APPROVED : DWG. SCALE The centre pin is crimped unless soldering is being specified by the customer. DRAWN 19/03/07 A.W.D ALL RIGHTS RESERVED

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