

CASA Assembly Instruction for:- "21SMA-PE-UT141-xxxmm(xx)"

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

Note - Semi-Rigid cables UT141/EZ141/SM141etc. may be used provided the appropriate connectors are deployed.

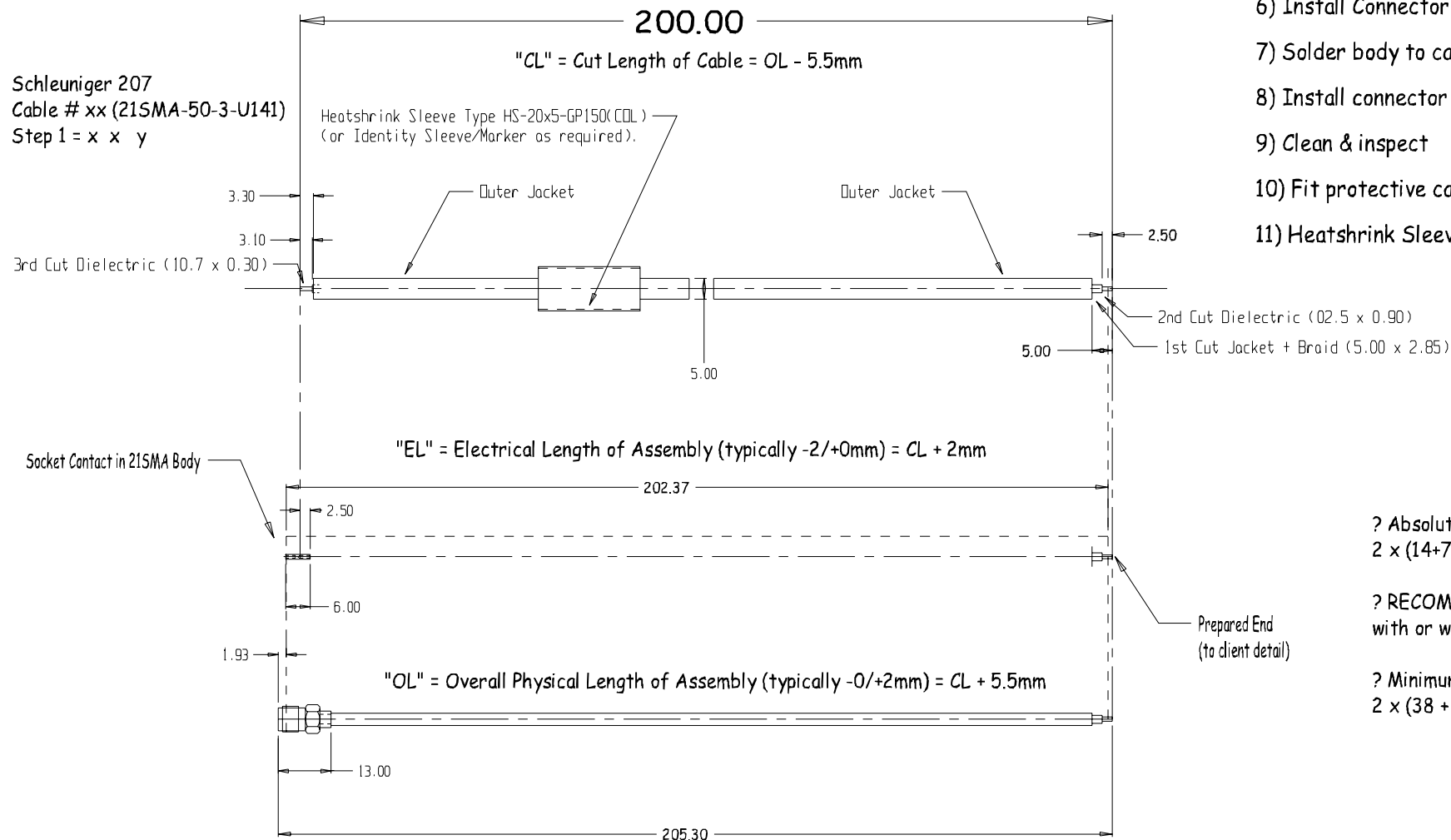
21SMA-50-3-UT141 (may be already fitted to supplied cable)

21SMA-50-3-15 (Suhner or equivalent)

21SMA-50-3-47

etc.

$$\text{CUT Length} = "CL" = OL - 5.5 \text{ mm}$$



Installation Steps:-

- 1) Prepare Cable Ends to Drawing detail shown here
- 2) Fit HS ID Marker/labels and clear HS cover tubes
- 3) Fit and solder centre pin onto centre conductor
- 4) Clean and Inspect dielectric to contact interface
- 5) Set all parts with appropriate W gauges and jigs
- 6) Install Connector Body onto contact & cable
- 7) Solder body to cable outer
- 8) Install connector dielectric incert and press with W53
- 9) Clean & inspect
- 10) Fit protective cap to connector thread.
- 11) Heatshrink Sleeves and ID markers as appropriate

Schleuniger 207
Cable # xx (21SMA-50-3-15/UT141 etc.)
Step 1 = 08.3 x 3.00
Step 2 = 13.1 x 1.84
Step 3 = 17.1 x 0.90

? Absolute MINIMUM Cable Length =
 $2 \times (14 + 7.7) = 43.4 \text{ mm}$ without heatshrink

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

? Minimum Cable length WITH Taper Sleeves
 $2 \times (38 + 7.7) + 14 = 105.4 \text{ mm}$

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 :
"21SMA to Prepared End Cable Assembly"

DRAWN : A.W.D. DATE : 11/04/07 APPROVED : ? DWG. SCALE : 1:1

SIZE : A4 DRAWING Reference No. : 21SM-PE ISSUE : A

© COPYRIGHT : CASA Modular Systems
ALL RIGHTS RESERVED

JOB No.

2649