

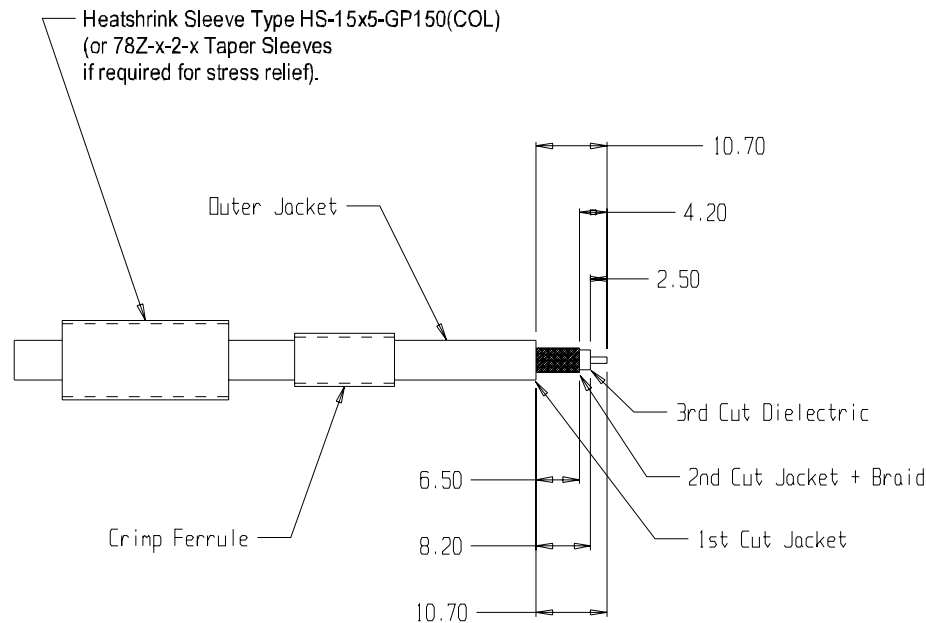
Assembly & Cable Preparation details for the following CASA Semi-Crimp Coaxial Connectors:-

Note - Double screened cables KO-2253d etc may be used provided the single screen crimp ferrule is substituted with the double screen part.

11SMA-50-2-RG316...

11SMA-50-2-RG316D...etc.

CASA Assembly Instruction Ref. "ASS-11SA" (drawing ASS-11SA.PRT)



Installation Steps:-

- 1) Prepare Cable End to Drawing detail and carefully tin the centre conductor of cables
- 2) Fit centre pin to inner conductor
locate/hold with jig and solder, remove any excess solder with scalpel and clean with isopropyl alcohol.
- 3) Fit Ferrule (and Heatshrink/Taper Sleeve)
- 4) Flare Braid to receive crimp spigot of connector
- 5) Install Connector Body onto cable
- 6) Slide Ferrule over Spigot & Braid
- 7) Screw connector on to the "Contact-Location-Jig" and push cable and connector body to correct position.
- 8) Crimp Ferrule with "2c?" (3.7mm Hex) Cavity
- 9) Inspect / check & clean as necessary
- 10) Slide Taper sleeve with tool (or Shrink-down the HS sleeve if fitted)

Use the SUHNER "RED" Crimp Cavity (3.7mm AF hexagonal) for the Ferrule.

JOB No.

26xx

CASA Modular Systems
P.O. BOX 38-828, WELLINGTON, NEW ZEALAND
TELEPHONE : (64-4) 5687 277
FACSIMILE : (64-4) 5685 161

CUSTOMER : **CASA Modular Systems**

DESCRIPTION : **Coax Connector Assembly Instruction**

DRAWN : **AWD**

DATE : **12/02/98**

APPROVED : **?**

DWG. SCALE : **1:1**

SIZE	DRAWING Reference No.	ISSUE
A4	ASS-11SA	A

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