

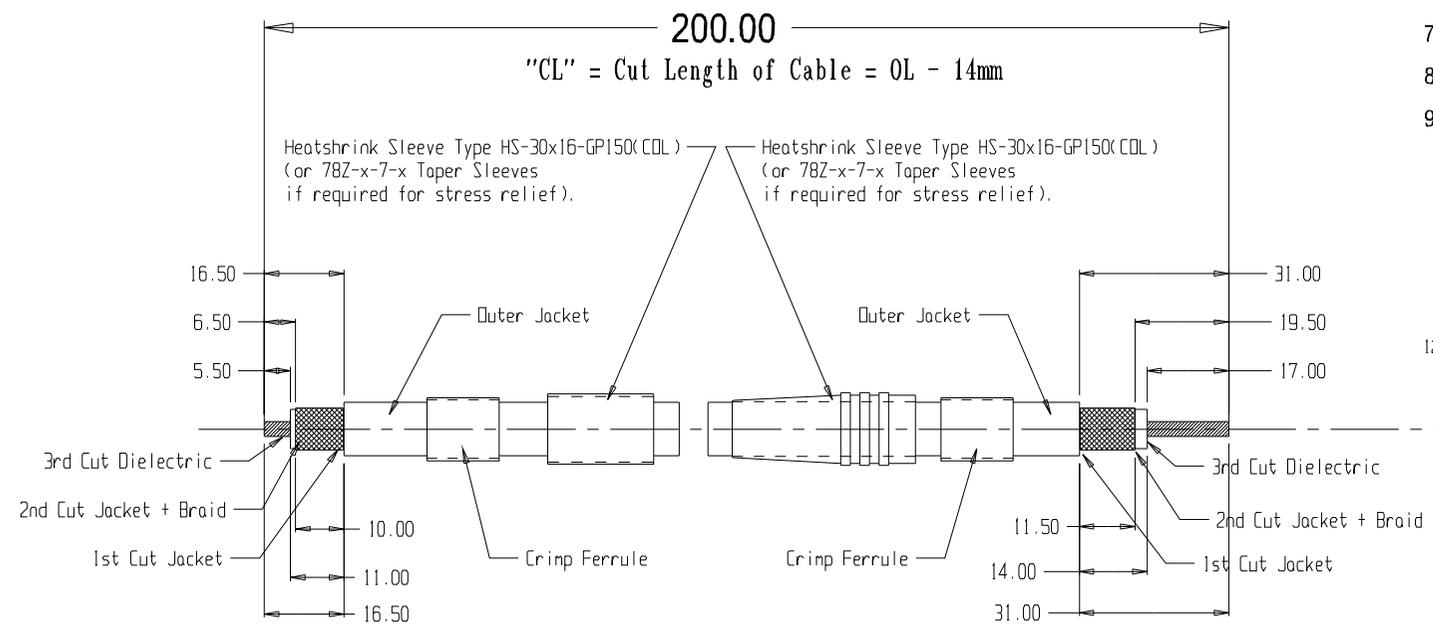
# CASA Assembly Instruction for:- "11N-11UHF-RG213/214/11-xxmm(HS)"

# Typical Assembly Process Sequence

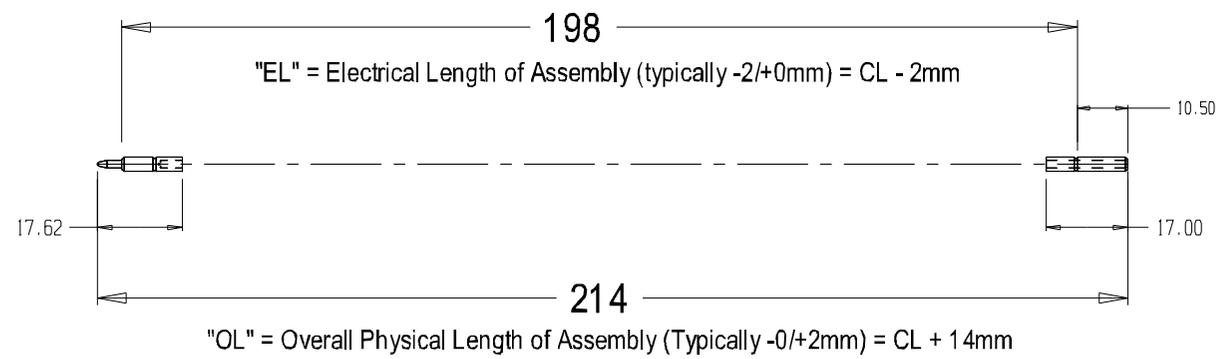
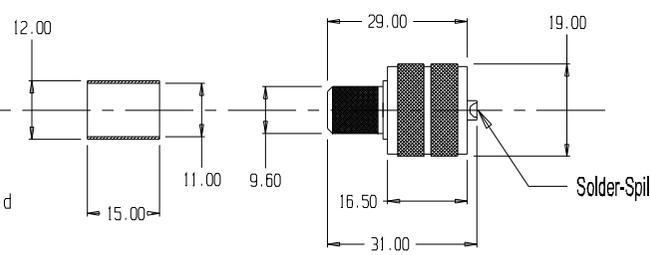
Assembly & Cable Preparation details for the following CASA Crimp Coaxial Connectors:-  
 Note - Double screened cables RG-214/U etc may be used provided the single screen crimp ferrule + centre pins substituted with the double screen part.  
 11N-50-7-43...  
 11UHF-0-7-RG213... ..solder-pin + crimp ferrule  
 etc.

- 1) Prepare Cable End to Drawing detail
- 2) Fit Ferrule (and Heatshrink/Taper Sleeve)
- 3) Crimp (or solder) Centre Contact to inner conductor of "N" cable end
- 4) Flare Braid to receive spigot
- 5) Install Connector Body onto contact & cable
- 6) Slide Ferrule over Spigot & Braid
- 7) Crimp Ferrule with "3D" Violet (10.7mm Hex-AF) Cavity
- 8) Repeat for UHF plug except solder centre contact to cable
- 9) Install Heatshrink (or taper sleeve) if/as appropriate

**CUT Length = "CL" = OL - 14mm**



11UHF-0-7-RG213... ..Crimp+Solder Plug



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  
 $2 \times (38 + 7.7) + 14 = 105.4\text{mm}$

Use the SUHNER "VIOLET" Crimp Cavity (10.7mm AF hexagonal) for the Ferrule  
 Use the SUHNER Violet Crimp Cavity (or equivalent 2.3mm AF square) or Solder the centre pin.

CASA Modular Systems 66 Fitzherbert Street, Petone, NZ TELEPHONE : <+64-4> 9393 777 WWW : <a href="http://www.casa.co.nz">http://www.casa.co.nz</a>	CUSTOMER : CASA Modular Systems	SIZE : A4	DRAWING Reference No. : 11N-11UHF-213 A	ISSUE : 30xx
	DESCRIPTION : "11N-11UHF" Cable Assembly Instruction for RG2'3 etc.	DRAWN : AWD	DATE : 23/09/19	APPROVED : ?
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