CASA Assembly Instruction for:- "11BNC-PE-RG58-xxmm(HS)"

Assembly & Cable Preperation details for the following CASA Crimp Coaxial Connectors:-
Note - Double-screened cables RG-233 etc. may be used provided the
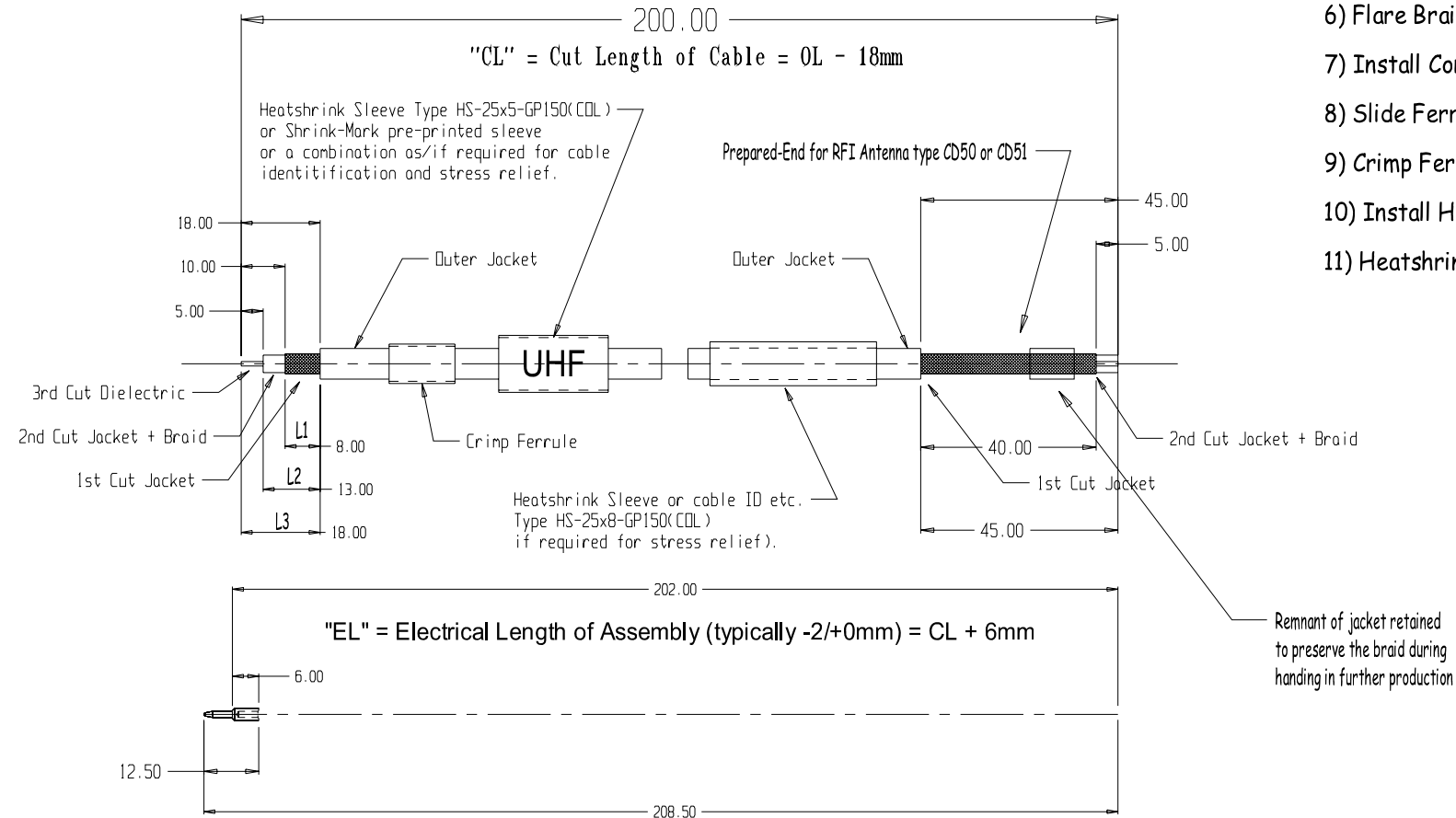single screen crimp ferrule is substituted with the DOUBLE screen part.
11BNC-50-3-RG58(J01000A1255)
or other brands subject to appropriate preperation dimensions.
11BNC-50-3-4(Suhner)
11BNC-50-3-RG58NT3Au(CASA) or other brands as approved by clients

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

CUT Length = "CL" = OL - 8.5mm

200.00

"CL" = Cut Length of Cable = OL − 18mm

Heatshrink Sleeve Type HS-25x5-GP150(COL)
or Shrink-Mark pre-printed sleeve
or a combination as/if required for cable
identitification and stress relief.

Prepared-End for RFI Antenna type CD50 or CD51

18.00
10.00
5.00

45.00
5.00

UHF

Outer Jacket

Outer Jacket

3rd Cut Dielectric

2nd Cut Jacket + Braid

1st Cut Jacket

L1   8.00
L2   13.00
L3   18.00

Crimp Ferrule

Heatshrink Sleeve or cable ID etc.
Type HS-25x8-GP150(COL)
if required for stress relief).

40.00

45.00

2nd Cut Jacket + Braid

1st Cut Jacket

Remnant of jacket retained
to preserve the braid during
handing in further production

Schleuniger 207
Cable # xx (PE-RG58-cc)
Step 1 = xxx
Step 2 = xxx
Step 3 = xxx

202.00

"EL" = Electrical Length of Assembly (typically -2/+0mm) = CL + 6mm

6.00

12.50

208.50

"OL" = Overall Physical Length of Assembly (typically -0/+2mm) = CL + 8.5mm

JOB No.
XXXX

Use the SUHNER "Orange" 75Z-0-3-4 (2B) Hand Tool or "Orange" Die-Sets 76Z-0-3-1 or 51
Crimp Cavity Size 1.6mm (o.o63") 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	CUSTOMER : CASA Modular Systems	SIZE	DRAWING Reference No.	ISSUE
P.O. BOX 38-828, WELLINGTON, NEW ZEALAND	DESCRIPTION : "11BNC-PE" Cable Assembly Instruction	A4	11B-PE-RG58	A
TELEPHONE : (64-4) 9393 777 FACSIMILE : (64-4) 9393 778	DRAWN A.W.D	DATE : 15/10/08	APPROVED ?	DWG. SCALE 1:1	(C) COPYRIGHT : CASA Modular Systems ALL RIGHTS RESERVED