

CASA Assembly Instruction for:- "16MCX-21/24/25SMAR -RG316-xxmm(HS)"

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

Note - Double screened cables K02252D, KO2252D etc may be used provided the single screen crimp ferrule + centre pins substituted with the double screen part

16MCX-50-2-13/133NE or NH(Suhner)

etc..

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24SMAR-50-2-RG316(J01151R0011)

...etc.

CUT Length = "CL" = OL - 19.5mm

Installation Steps:-

- 1) Prepare Cable End to Drawing detail
- 2) Fit Ferrule (and Heatshrink/Taper Sleeve)
- 3) Crimp (or solder) Centre Contact to inner conductor
- 4) Slide Ferrules and Heatshrink/taper sleeves on to cable
- 5) Flare Braid to receive spigot
- 6) Install Connector Body onto contact & cable
- 7) Slide Ferrule over Spigot & Braid
- 8) Orient Bodies to achieve alignment of flange/flat/angle as appropriate (requested by customer etc.)
- 9) Crimp Ferrules with "2C" (5.5mm Hex) Cavity
- 10) Install W14 Screw Cap Gauge into 16SMA. nut
- 11) Solder centre conductor in 16SMA... Cavity
- 12) Fit press cap into 16SMA..
- 13) Remove W14 Screw Cap/Gauge
- 14) Heatshrink sleeving or slide taper sleeve.
- 15) Test for Shorts and continuity
- 16) Inspect and pack

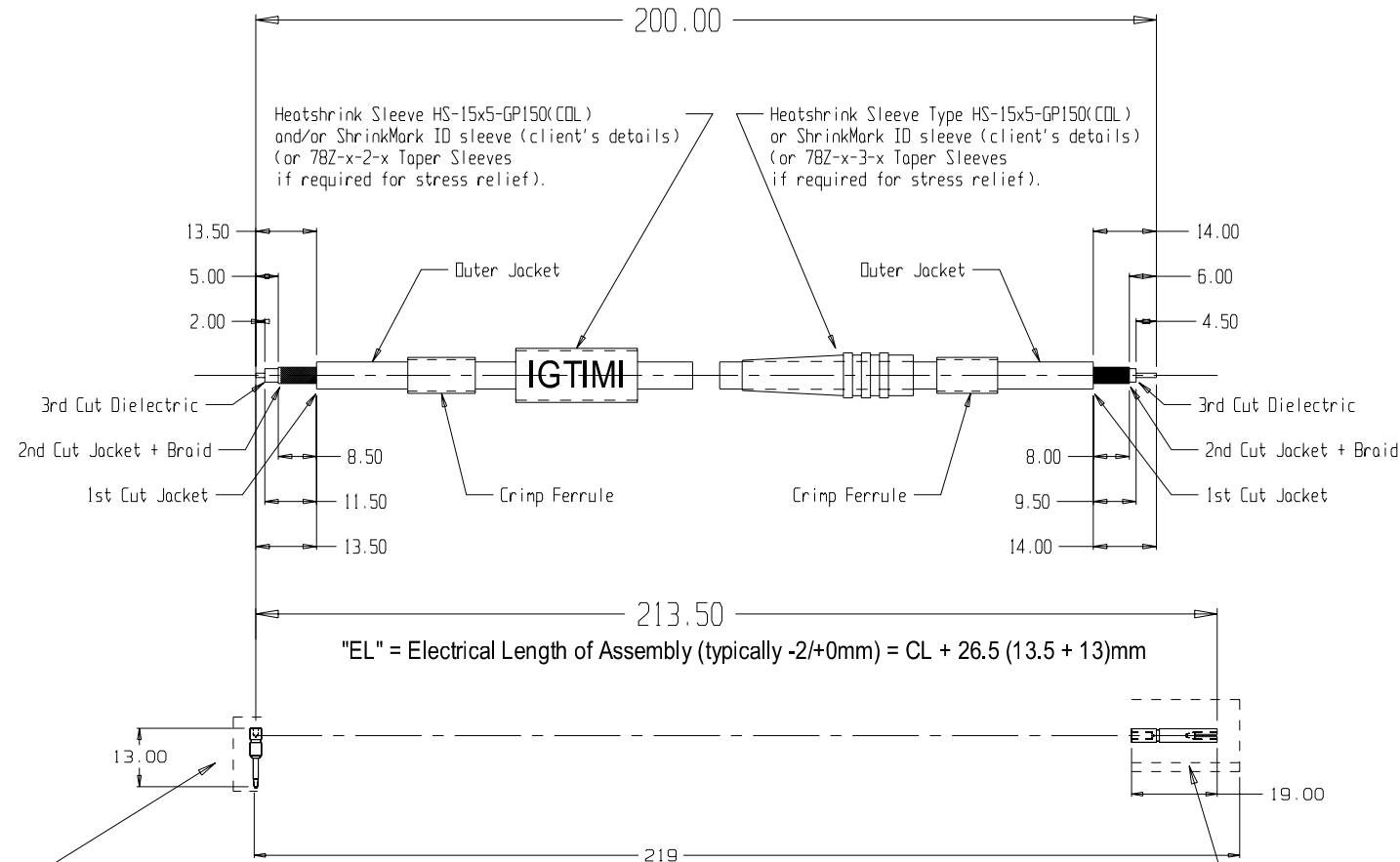
SPECIAL NOTES:

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

Reference FLAT on 24SMA..



"EL" = Electrical Length of Assembly (typically -2/+0mm) = CL + 26.5 (13.5 + 13)mm

"OL" = Overall Physical Length of Assembly (Typically -0/+2mm) = CL + 19mm

Orientation of the 16SMA... RA connector needs to be referenced to the flat on the 24SMA... Bulkhead Receptical

Use the SUHNER "ORANGE" Crimp Cavity (5.5mm AF hexagonal) for the Ferrule
 Use the SUHNER Violet Crimp Cavity (or equivalent 2.3mm AF square) or Solder the centre pin.

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CUSTOMER : **CASA Modular Systems**

DESCRIPTION : **"16MCX-24SMAR" REVERSE Cable Assembly Instruction**

DRAWN : **AWD** DATE : **15/10/08** APPROVED : **?** DWG. SCALE : **1:1**

SIZE **A4** DRAWING Reference No. **16MCX-24SMARB** ISSUE **30xx**
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