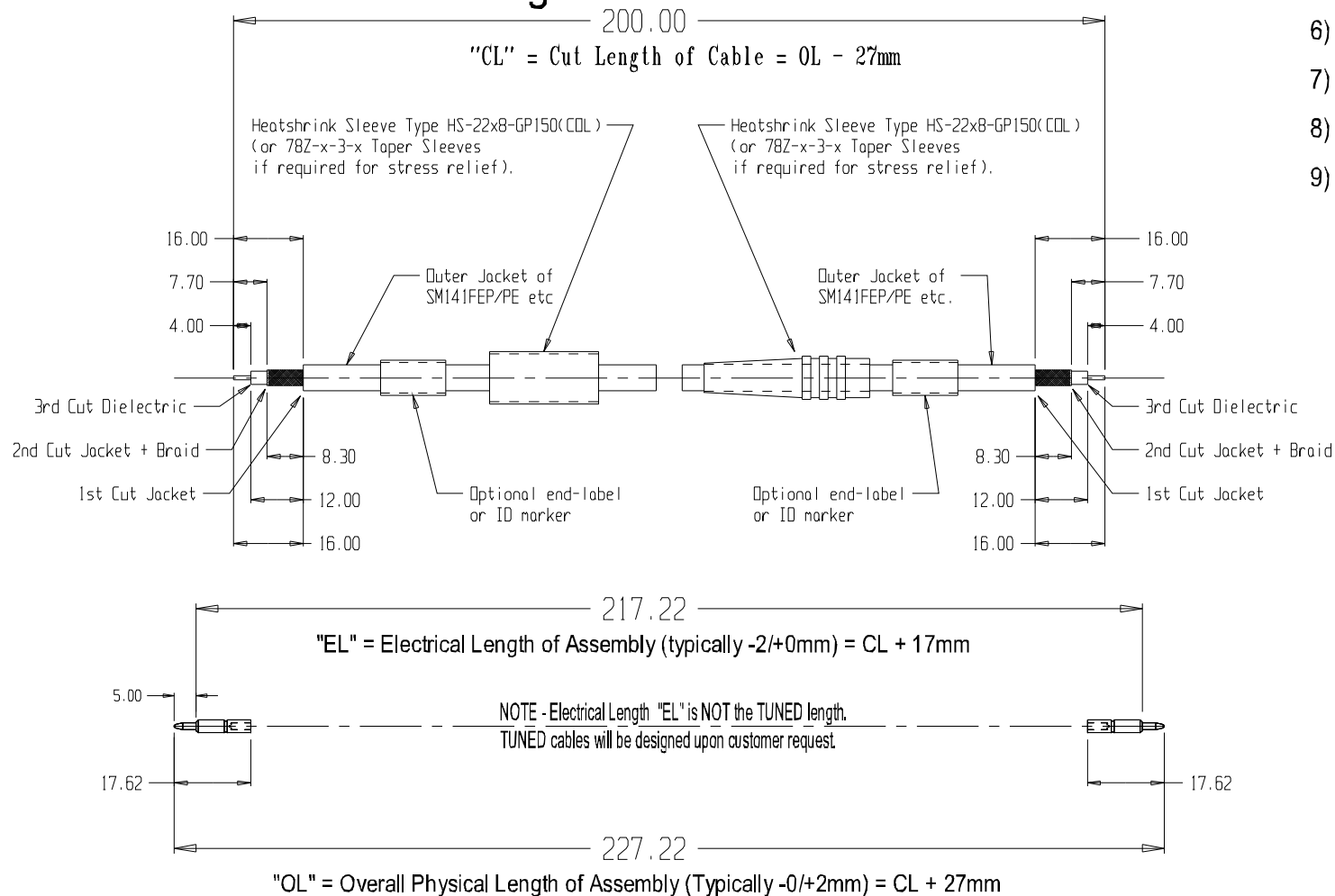


CASA Assembly Instruction for:- "11N-11N-UT141-xxmm(HS)"

Assembly & Cable Preparation details for the following CASA Solder Coaxial Connectors:-
Note - hard-line (semi-rigid) and Helix cables are machine-prepared and all cutting/trimming is hand-processed when ready for connector fixing etc. according to manufacturer's instructions
11N-50-3-UT141 (and variants)
11N-50-3-TS041
11N-50-6-FSJ1-50 (brand specific details to be detailed).
11N-50-9-FSJ1250 (must use hand tooling)
etc.

$$\text{CUT Length} = \text{"CL"} = \text{OL} - 27\text{mm}$$



Installation Steps (see makers detailed instructions):-

- 1) Prepare Cable End to Drawing detail
- 2) Remove slugs and/or trimmings
- 3) De-burr and Cleanrule (and Heatshrink Sleeve)
- 4) Fit and/or solder Centre Contact to inner conductor
- 5) Fit all heatshrink sleeves and markers
- 6) Flare form/swage copper-screen to suit
- 7) Install Connector Body onto contact & cable
- 8) Tighten nuts etc. to maker's specifications
- 9) Locate possitions for HS sleeves and shrink-down.

NOTE - Electrical Length "EL" is NOT the TUNED length.

Correction for VP (velocity of propagation) or PS (phase stability) must be made specific to the cable and specific application environment (temperature and frequency)

TUNED length correction factors range from 66-88% and TUNED cables will be designed upon customer request

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

Soldering: Use the resistance or Induction soldering machiner (or hand soldering) according to batch-size or other considerations
Cleaning: Thoroughly clean/remove all flux residues using isopropyl alcohol

CASA Modular Systems		CUSTOMER : CASA Modular Systems		SIZE	DRAWING Reference No.	ISSUE
P.O. BOX 38-828, WELLINGTON, NEW ZEALAND		DESCRIPTION : "11N-11N-SemiRigid" Cable Assembly Instruction		A4 11N-11N-SRigid A		
TELEPHONE : <64-4> 5687 277	FACSIMILE : <64-4> 5685 161	DRAWN : AWD	DATE : 11/01/24	APPROVED : ?	DWG. SCALE : 1:1	© COPYRIGHT : CASA Modular Systems ALL RIGHTS RESERVED