

CASA Assembly Instruction for: - "16SMA-PE-RG316-xxxmm(HS)"

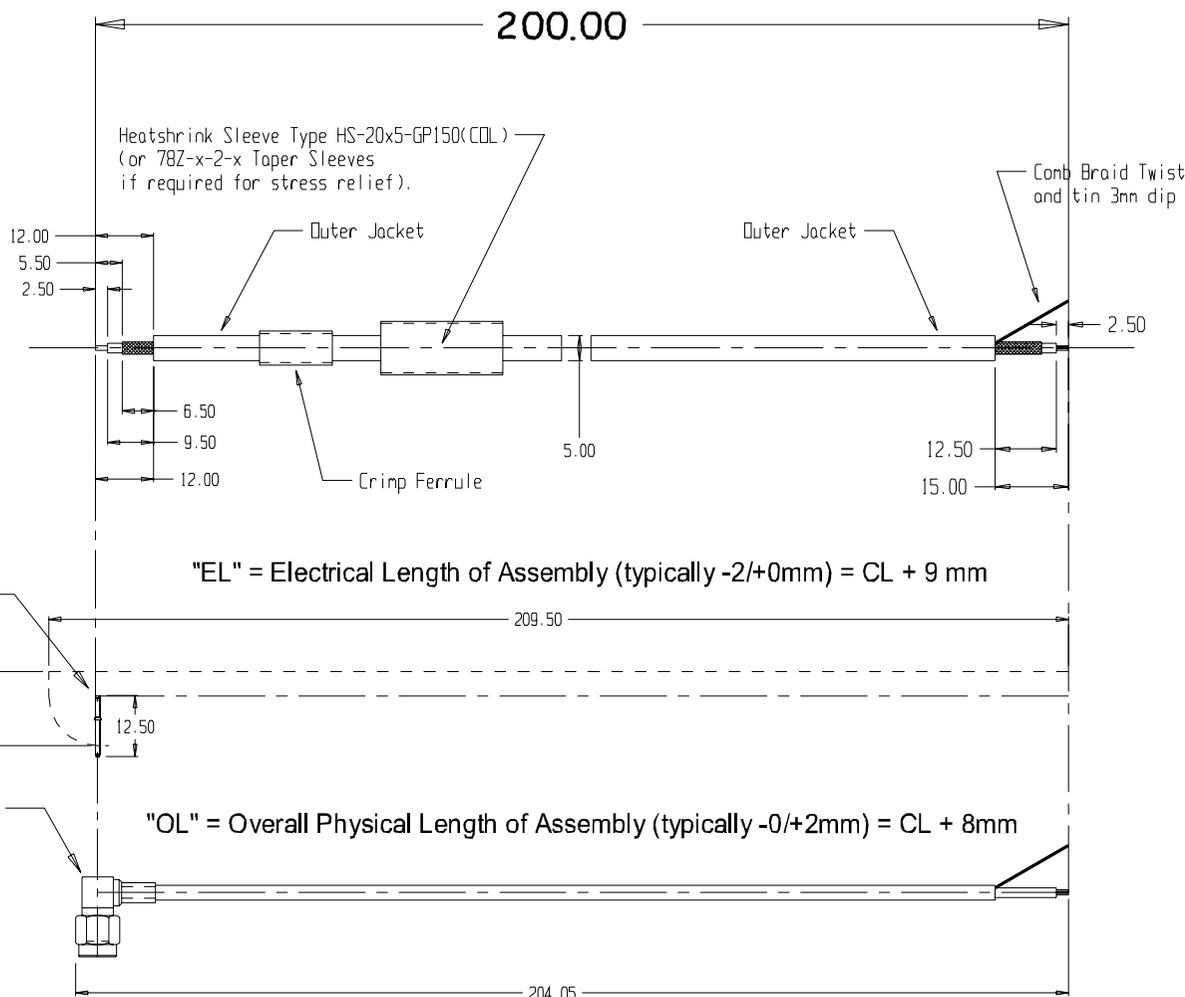
Assembly & Cable Preparation details for the following CASA Crimp Coaxial Connectors:-

Note - Single screened cables RG17/RG316 etc. may be used provided the single screen crimp ferrule substituted with the double screen part.

16SMA-50-2-RG316 (may be already fitted to supplied cable etc.

$$\text{CUT Length} = \text{"CL"} = \text{OL} - 4 \text{ mm}$$

Schleuniger 207
Cable # xx
Step 1 = 02.5 x 1.44
Step 2 = 5.50 x 0.84
Step 3 = 12.0 x 0.30



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
- 12) Strip Prepared end jacket to drawing
- 13) Comb braid and fold back over jacket
- 14) Strip dielectric to drawing
- 15) Flair and twist braid to single tail
- 16) Tin dip braind and dilectric to 2mm deep

? 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 "RED" 75Z-0-2-4 (1B) Hand Tool or "Red" Die-Sets 76Z-0-2-1 or xx Crimp Cavity Size 1.6mm (0.063") 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

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CUSTOMER : CASA Modular Systems

DESCRIPTION : 16SMA to Prepared End Cable Assembly Instruction

DRAWN : A.W.D DATE : 10/04/07 APPROVED : ? DWG. SCALE : 1:1

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