CASA Assembly Instruction for:- "16SMA-16SMA-RG316-xxxmm-180d(HS)"

Installation Steps:-

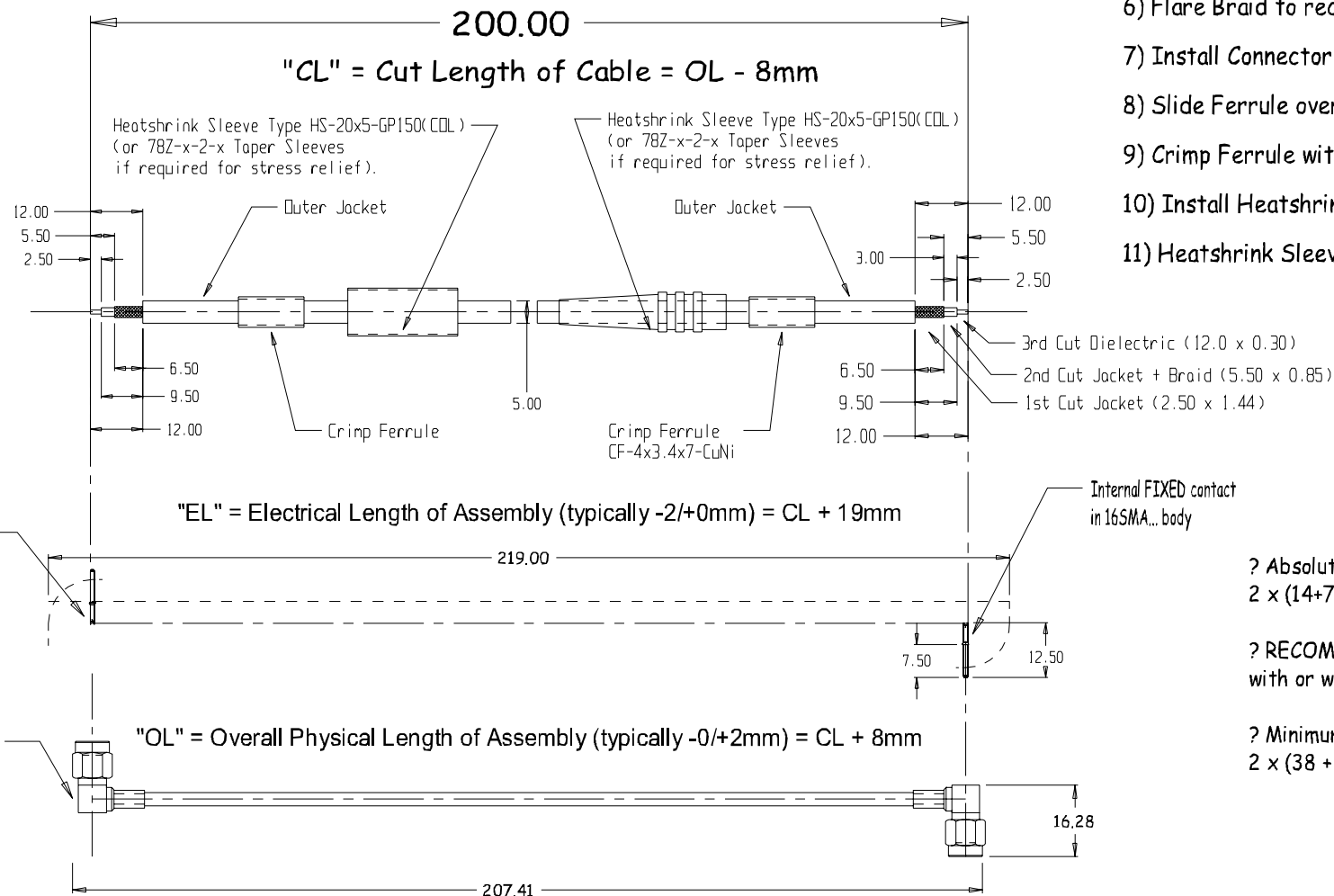Assembly & Cable Preperation details for the following CASA Crimp Coaxial Connectors:-
Note - Single screened cables RG17/RG3164 etc. may be used provided the
single screen crimp ferrule substituted with the double screen part.
16SMA-50-2-RG316 (may be already fitted to supplied cable
16SMA-50-2-RG316 (Suhner or equivalent)
etc.

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 mm

200.00

"CL" = Cut Length of Cable = OL - 8mm

Heatshrink Sleeve Type HS-20x5-GP150(COL)
(or 78Z-x-2-x Taper Sleeves
if required for stress relief).

Heatshrink Sleeve Type HS-20x5-GP150(COL)
(or 78Z-x-2-x Taper Sleeves
if required for stress relief).

Outer Jacket

Outer Jacket

12.00
5.50
2.50

12.00
5.50
3.00
2.50

6.50
9.50
5.00
12.00

Crimp Ferrule

Crimp Ferrule
CF-4x3.4x7-CuNi

6.50
9.50
12.00

3rd Cut Dielectric (12.0 x 0.30)
2nd Cut Jacket + Braid (5.50 x 0.85)
1st Cut Jacket (2.50 x 1.44)

Schleuniger 207
Cable # 17 (24BNC-50-2-KC19-93)
Step 1 = 08.3 x 3.00
Step 2 = 13.1 x 1.84
Step 3 = 17.1 x 0.90

"EL" = Electrical Length of Assembly (typically -2/+0mm) = CL + 19mm

Solder-Pin in 16SMA Body

219.00

Internal FIXED contact
in 16SMA... body

7.50   12.50

? Absolute MINIMUM Cable Length =
2 x (14+7.7) = 43.4mm without heatshrink

? RECOMENDED Pracital Minimum = 50mm
with or without Heatshrink.

Angular/Radial orientation
to suit client requirements
(specify 0~180 degrees)

"OL" = Overall Physical Length of Assembly (typically -0/+2mm) = CL + 8mm

16.28

? Minimum Cable length WITH Taper Sleeves
2 x (38 + 7.7) + 14 = 105.4mm

207.41

JOB No.
2649

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 (o.063") square + 5.5mm (o.217") AF hexagonal for the Ferrule
The centre pin is crimped unless soldering is being specified by the customer.

CUSTOMER : CASA Modular Systems
DESCRIPTION : 16SMA-16SMA @ 180 deg Assembly Instruction
DRAWN : A.W.D
DATE : 10/04/07
APPROVED : ?
DWG. SCALE : 1:1

SIZE A4

DRAWING Reference No. 16SM-16SM-180d

ISSUE A