

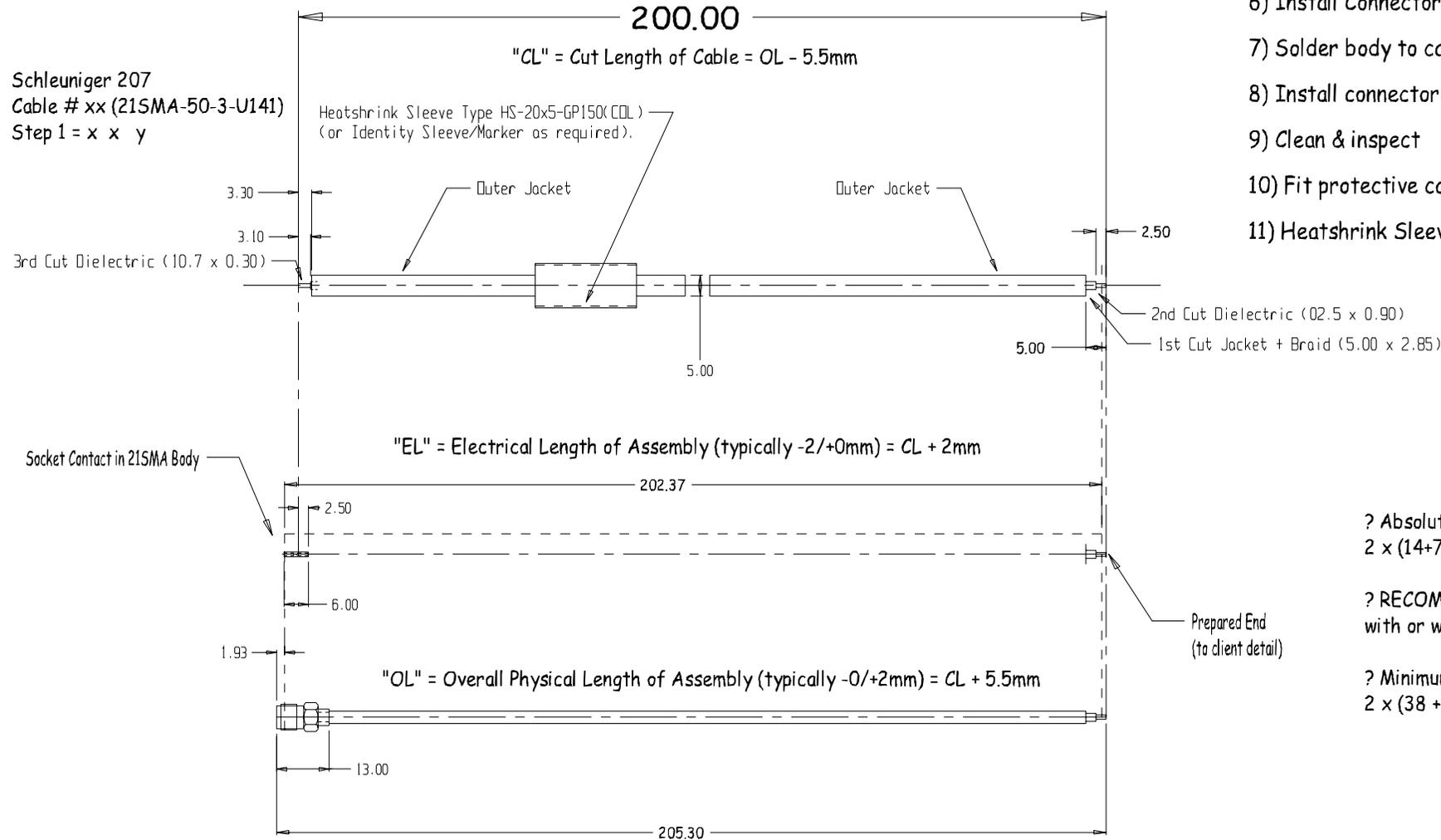
# CASA Assembly Instruction for: - "21 SMA-PE-UT141-xxxmm(xx)"

Assembly & Cable Preparation details for the following CASA Crimp Coaxial Connectors:-  
 Note - Semi-Rigid cables UT141/EZ141/SM141etc. may be used provided the appropriate connectors are deployed.

- 21SMA-50-3-UT141 (may be already fitted to supplied cable)
- 21SMA-50-3-15 (Suhner or equivalent)
- 21SMA-50-3-47
- etc.

**CUT Length = "CL" = OL - 5.5 mm**

Schleuniger 207  
 Cable # xx (21SMA-50-3-U141)  
 Step 1 = x x y



## Installation Steps:-

- 1) Prepare Cable Ends to Drawing detail shown here
- 2) Fit HS ID Marker/labels and clear HS cover tubes
- 3) Fit and solder centre pin onto centre conductor
- 4) Clean and Inspect dielectric to contact interface
- 5) Set all parts with appropriate W gauges and jigs
- 6) Install Connector Body onto contact & cable
- 7) Solder body to cable outer
- 8) Install connector dielectric insert and press with W53
- 9) Clean & inspect
- 10) Fit protective cap to connector thread.
- 11) Heatshrink Sleeves and ID markers as appropriate

Schleuniger 207  
 Cable # xx (21SMA-50-3-15/UT141 etc.)  
 Step 1 = 08.3 x 3.00  
 Step 2 = 13.1 x 1.84  
 Step 3 = 17.1 x 0.90

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

JOB No.  
**2649**

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CUSTOMER : CASA Modular Systems		SIZE	DRAWING Reference No.	ISSUE
DESCRIPTION : "21SMA to Prepared End Cable Assembly"		A4	21SM-PE	A
DRAWN : A.W.D	DATE : 11/04/07	APPROVED : ?	DWG. SCALE : 1:1	© COPYRIGHT : CASA Modular Systems ALL RIGHTS RESERVED