

CASA Assembly Instruction for:- "11 TNC-16SMAR-KO2252D-xxmm(HS)"

Assembly & Cable Preparation 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

11 TNC-50-2-RG316(J01010A0039)

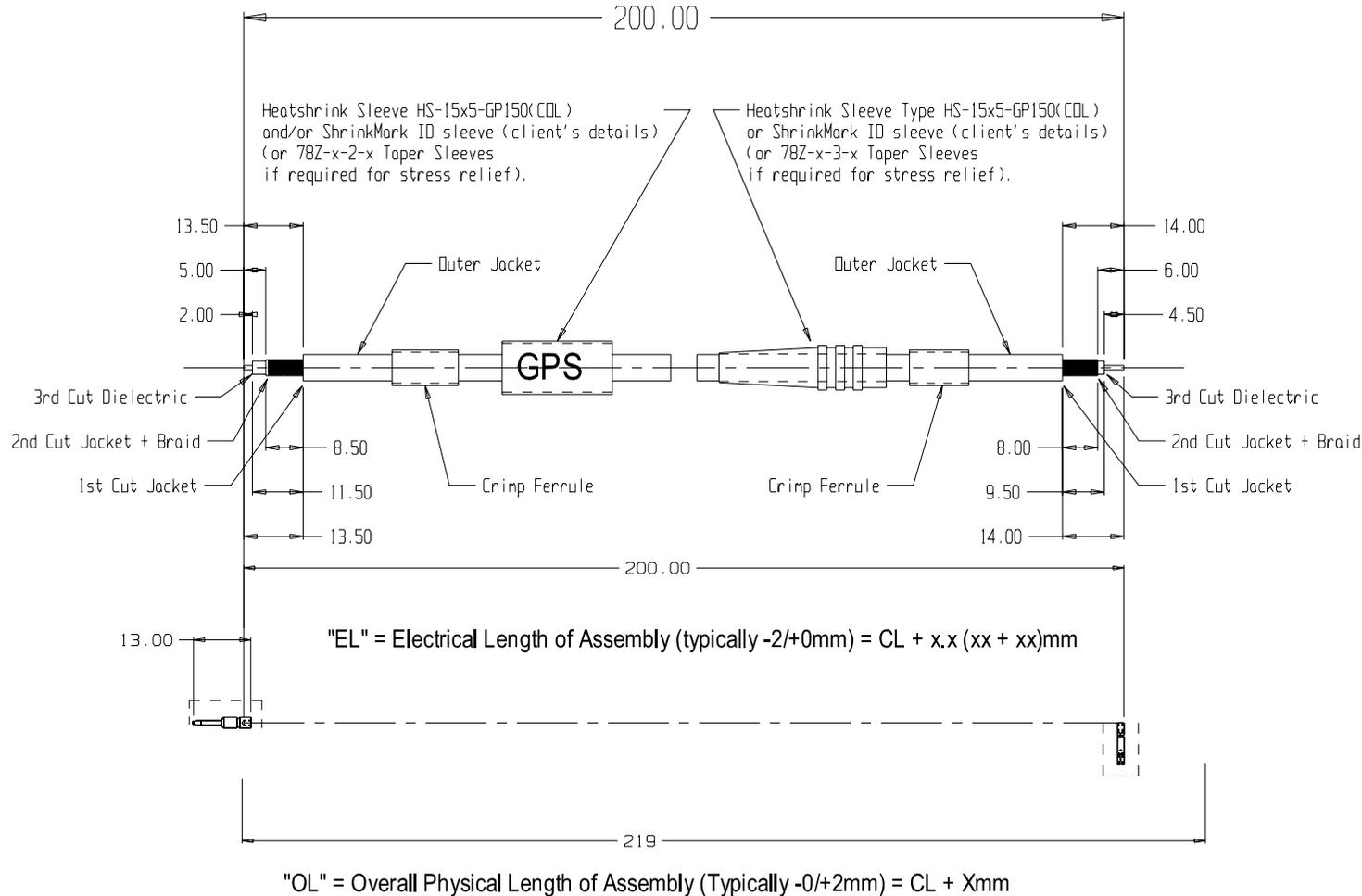
etc..

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16SMAR-50-2-RG316(J1150R0031)

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

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 : "11TNC-16SMAR" (reverse) Cable Assembly Instruction

DRAWN : AWD

DATE : 15/10/08

APPROVED : ?

DWG. SCALE : 1:1

SIZE : A4

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