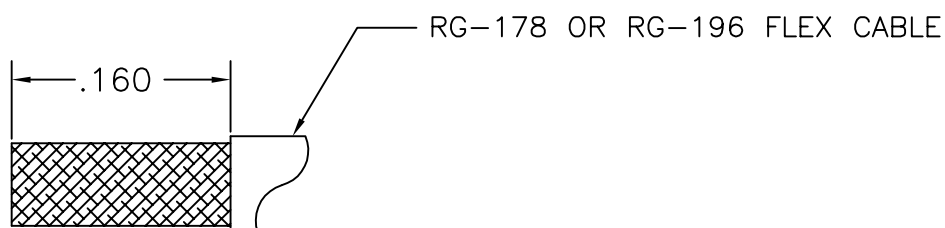


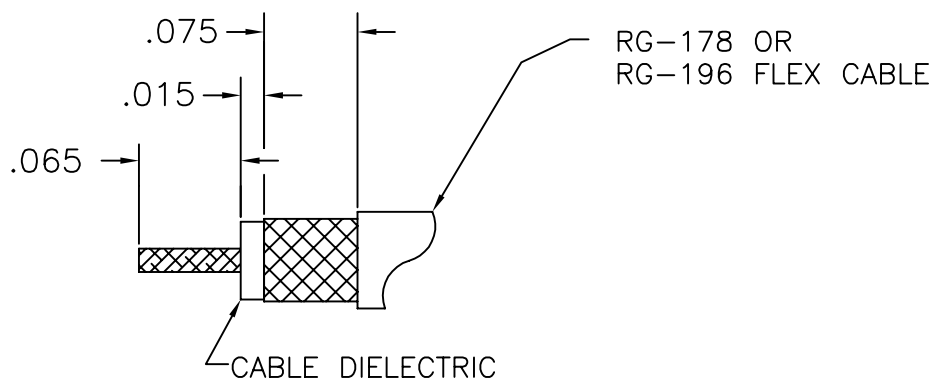
MICRO-MODE PRODUCTS INC.
CABLE SERVICE & ASSEMBLY PROCEDURES FOR MMSP-2596 (F)
AND MMSP-6660 (F) RIGHT ANGLE TO RG-178 OR RG-196 FLEX CABLE

CABLE SERVICE/PREPARATION

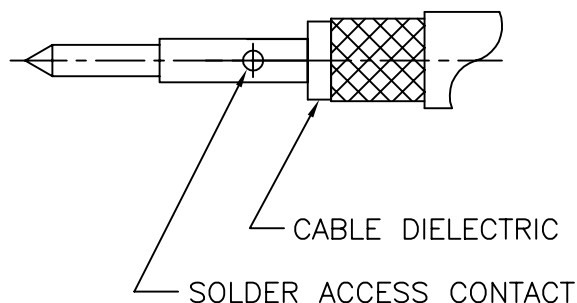
1. TRIM/STRIP CABLE JACKET TO EXPOSE BRAID AS SHOWN.
2. TIN OUTER BRAID USING A SOLDER POT OR EQUIVALENT METHOD.



3. TRIM TINNED BRAID TO EXPOSE CENTER CONDUCTOR AND CABLE DIELECTRIC AS SHOWN. USE CAUTION, DO NOT NICK OR SLICE CABLE CENTER CONDUCTOR.
4. PRE-TIN CENTER CONDUCTOR OF CABLE USING A SOLDER POT OR EQUIVALENT METHOD.



5. PLACE CENTER CONTACT INTO APPROPRIATE LOCATOR/HOLDING TOOL, HEAT CENTER CONTACT AND PUSH OVER CENTER CONDUCTOR OF CABLE UNTIL IT FIRMLY RESTS AGAINST EXPOSED CABLE DIELECTRIC. SOLDER CONTACT IN PLACE.



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ph 619.449.3844
www.micromode.com

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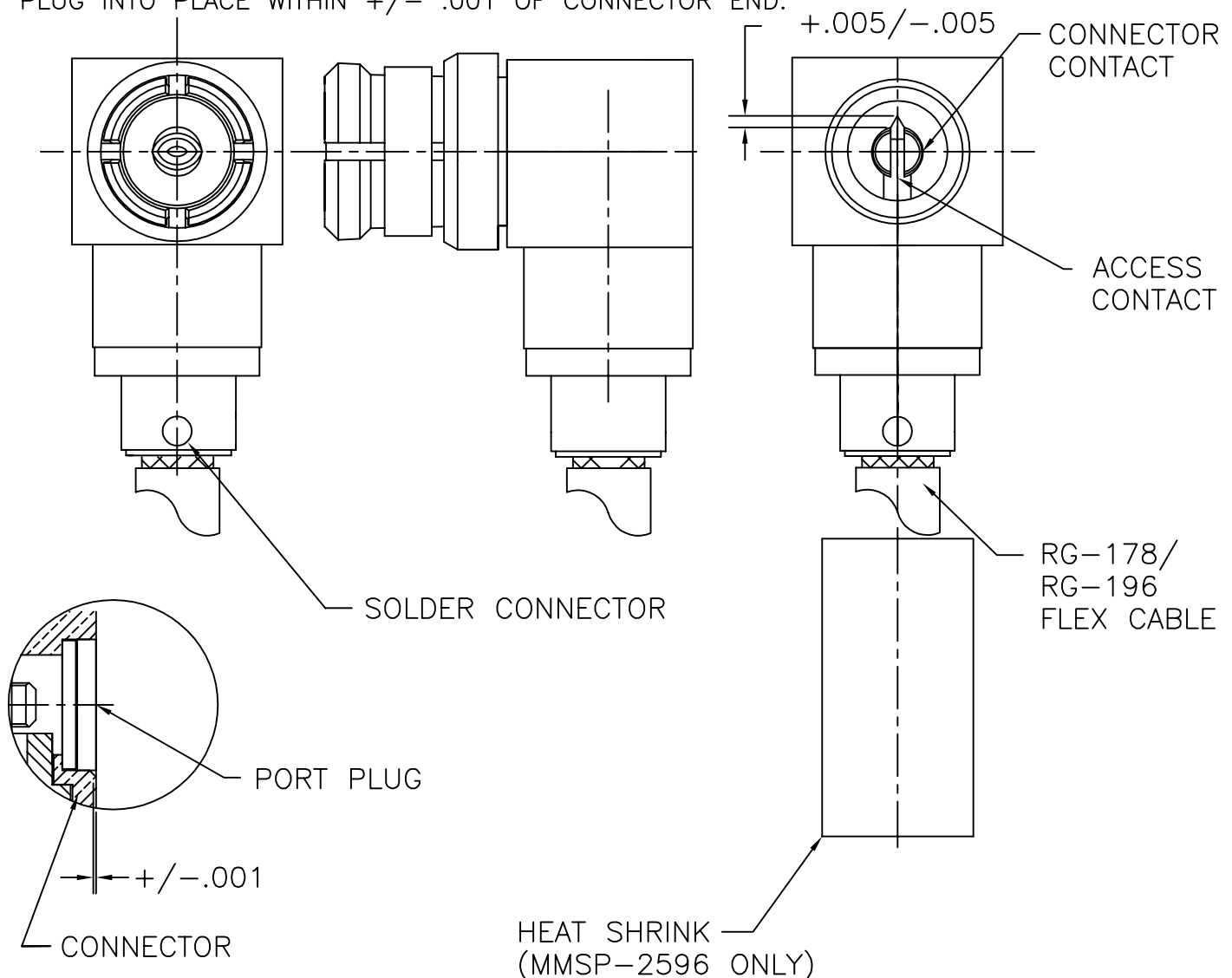
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MICRO-MODE PRODUCTS INC.
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AND MMSP -6660 (F) TO RG-178 OR RG-196 FLEX CABLE

6. PLACE CONNECTOR SUB-ASSEMBLY ONTO ACCESS CONTACT/CABLE ASSEMBLY.
 NOTE; THE CABLE ACCESS CONTACT MUST ENGAGE CENTER CONTACT OF CONNECTOR;
 VISUALLY INSPECT BIFURCATED JUNCTION THRU PORT HOLE AT REAR OF CONNECTOR.
 ENSURE ACCESS CONTACT IS ONLY .005 MAX ABOVE BIFURCATED CONTACT
7. SOLDER CONNECTOR TO CABLE; SOLDERING TEMPERATURE MUST NOT EXCEED 550° F.
 CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.
8. PLACE PROVIDED HEAT SHRINK SLEEVE OVER CABLE/CONNECTOR JUNCTION;
 APPLY HEAT AND SHRINK INTO PLACE. THIS STEP APPLIES TO MMSP-2596 ONLY.
9. INSTALL PORT PLUG WITH C'SINK FACING INTO PORT HOLE. GENTLY PRESS PORT
 PLUG INTO PLACE WITHIN $\pm .001$ OF CONNECTOR END.



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