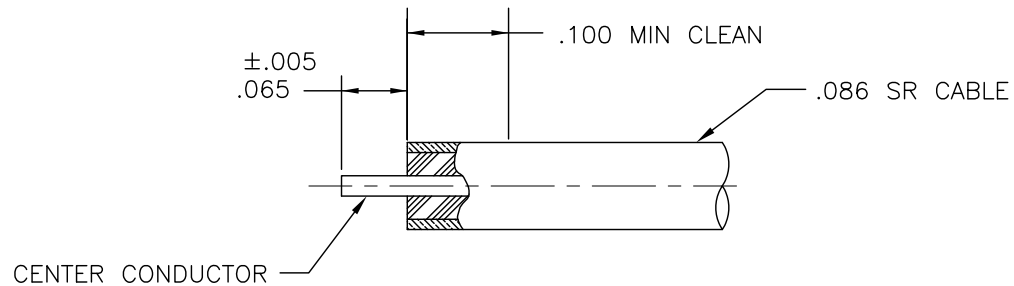
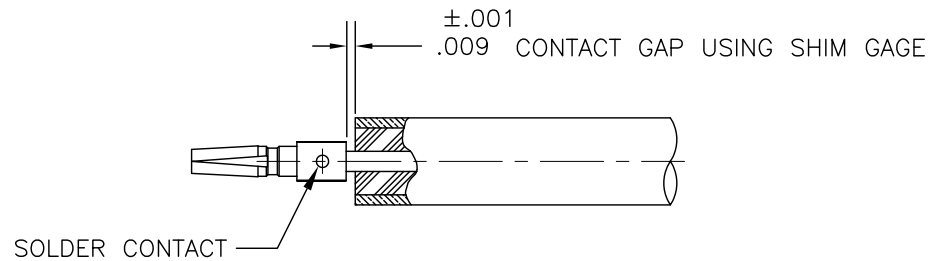


CABLE PREP AND ASSEMBLY FOR MMSP-2508 TO .086SR CABLE

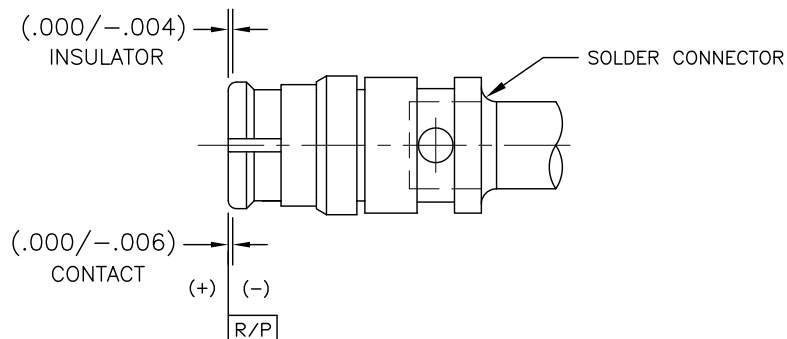
1. TRIM CABLE OUTER CONDUCTOR AND DIELECTRIC TO DIMENSION SHOWN;
DO NOT NICK CENTER CONDUCTOR.
2. CLEAN CABLE OUTER CONDUCTOR AS INDICATED USING SCOTCH BRITE OR FINE GRAIN ABRASIVE PAPER



3. PRE-TIN CENTER CONDUCTOR OF CABLE USING A SOLDER POT OR EQUIVALENT METHOD.
4. PLACE A $.009 \pm .001$ SHIM GAGE ON CABLE CENTER CONDUCTOR AND SEAT AGAINST CABLE DIELECTRIC.
5. PLACE CONTACT ON CENTER CONDUCTOR AND SEAT AGAINST SHIM GAGE.
6. SOLDER CONTACT IN PLACE. (WARNING: SOLDERING TEMPERATURE MUST NOT EXCEED $288^{\circ}\text{C}/550^{\circ}\text{F}.$)
7. REMOVE SHIM GAGE AND CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.



8. PLACE CONNECTOR SUB-ASSEMBLY ONTO CONTACT/CABLE ASSEMBLY.
NOTE: INSULATOR/CONTACT FLUSH TO BELOW REFERENCE PLANE OF OUTER CONDUCTOR.
9. SOLDER CONNECTOR TO CABLE. (WARNING: SOLDERING TEMPERATURE MUST NOT EXCEED $288^{\circ}\text{C}/550^{\circ}\text{F}.$)
CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.



THE ABOVE DIMENSIONS ARE
GUIDELINES ONLY. CHANGES
MAY BE REQUIRED DUE TO
DIFFERING MATERIALS,
PROCESSES, TYPE OF BRAZE,
SOLDER OR EPOXY.



MICRO-MODE PRODUCTS, INC.
The Reliable Connection to the Future

El Cajon, CA 92020
ph 619.449.3844
www.micromode.com

CAGE CODE
15907

REF: MMSP-2508

CABLE SERVICE & ASSEMBLY PROCEDURES
FOR MMSP-2508 TO .086 SR CABLE

DEFAULT TOLERANCES: .XXX \pm .005 .XX \pm .01

PART NO.

MMAP-2679

REVISION

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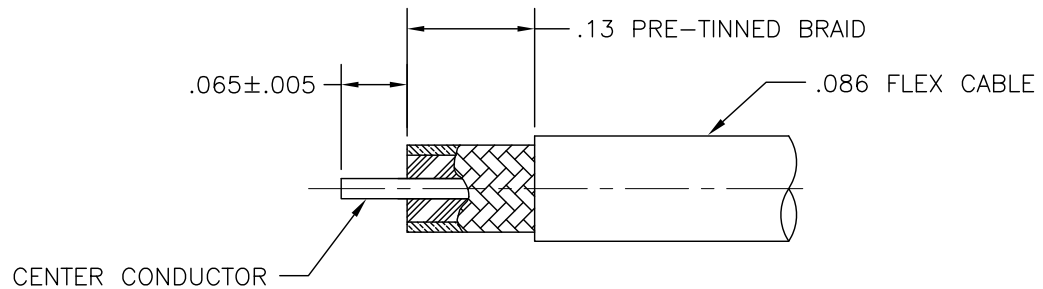
SHEET 1 OF 2 OL2679 1-30-07 EB

PART NO. MMAP-2679

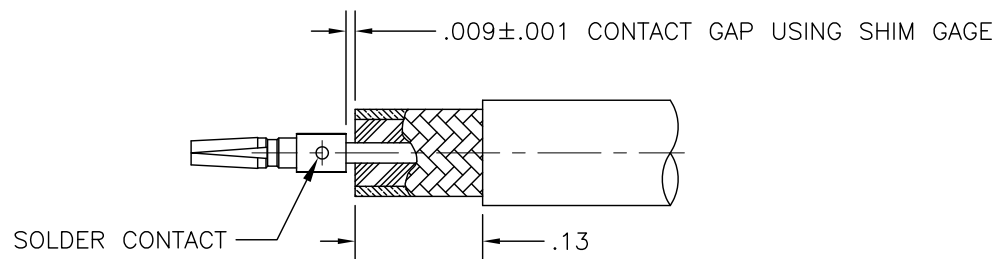
CABLE PREP AND ASSEMBLY

CABLE PREP AND ASSEMBLY FOR MMSP-2508 TO .086 FLEX CABLE

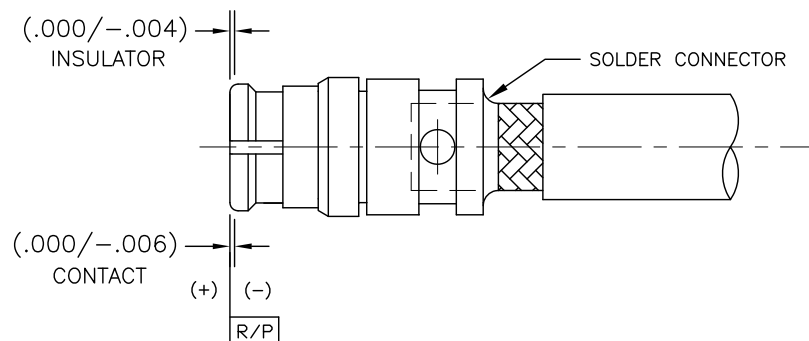
1. PRETIN BRAID IN SOLDER POT
2. TRIM JACKET, BRAID AND DIELECTRIC AS SHOWN. DO NOT NICK CENTER CONDUCTOR.
3. PRE-TIN CENTER CONDUCTOR OF CABLE USING A SOLDER POT OR EQUIVALENT METHOD.



4. PLACE A $.009 \pm .001$ SHIM GAGE ON CABLE CENTER CONDUCTOR AND SEAT AGAINST CABLE DIELECTRIC.
5. PLACE CONTACT ON CENTER CONDUCTOR AND SEAT AGAINST SHIM GAGE.
6. SOLDER CONTACT IN PLACE. (WARNING: SOLDERING TEMPERATURE MUST NOT EXCEED $288^{\circ}\text{C}/550^{\circ}\text{F}.$)
7. REMOVE SHIM GAGE AND CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.



8. PLACE CONNECTOR SUB-ASSEMBLY ONTO CONTACT/CABLE ASSEMBLY.
NOTE: INSULATOR/CONTACT FLUSH TO BELOW REFERENCE PLANE OF OUTER CONDUCTOR.
9. SOLDER CONNECTOR TO CABLE. (WARNING: SOLDERING TEMPERATURE MUST NOT EXCEED $288^{\circ}\text{C}/550^{\circ}\text{F}.$)
CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.



THE ABOVE DIMENSIONS ARE GUIDELINES ONLY. CHANGES MAY BE REQUIRED DUE TO DIFFERING MATERIALS, PROCESSES, TYPE OF BRAZE, SOLDER OR EPOXY.



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DEFAULT TOLERANCES: .XXX \pm .005 .XX \pm .01

PART NO.

REVISION

SHEET 2 OF 2 OL2679 1-30-07 EB

MMAP-2679

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