CABLE TRIM AND ASSEMBLY FOR MMSP-13609, 13610, 13667 TO .086 SR CABLE
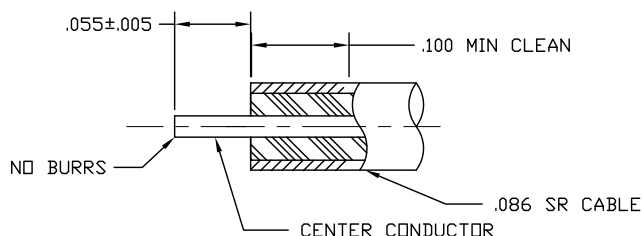
1. TRIM CABLE OUTER CONDUCTOR AND DIELECTRIC TO DIMENSION SHOWN; DO NOT NICK CENTER CONDUCTOR.

2. CLEAN CABLE OUTER CONDUCTOR AS INDICATED USING SCOTCH BRITE OR FINE GRAIN ABRASIVE PAPER

.055±.005   .100 MIN CLEAN

NO BURRS   .086 SR CABLE

CENTER CONDUCTOR

3. PRE-TIN CENTER CONDUCTOR OF CABLE USING A SOLDER POT OR EQUIVALENT METHOD

4. SLIDE DIELECTRIC BEAD ONTO CENTER CONDUCTOR AND SEAT AGAINST CABLE DIELECTRIC

5. PLACE CONTACT ON CENTER CONDUCTOR AND SEAT AGAINST DIELECTRIC BEAD

6. SOLDER CONTACT IN PLACE. (WARNING: SOLDERING TEMPERATURE MUST NOT EXCEED 288°C/550°F)

7. CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX

8. CHECK CONTACT TO CABLE JACKET DIMENSION

9. SLIDE FRONT INSULATOR ONTO CONTACT

10. PLACE CABLE SUB-ASSEMBLY (CABLE, CONTACT, DIELECTRIC BEAD, INSULATOR) INTO CONNECTOR. FULLY SEAT SUBASSY AGAINST CABLE STOP.

11. SOLDER BODY TO CABLE: SOLDERING TEMPERATURE MUST NOT EXCEED 288°C (550°F). CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.

.093±.002   (.086 SR CABLE)

SOLDER CONTACT (Sn96)

DIELECTRIC BEAD

MMSP-13609
MMSP-13610
MMSP-13667

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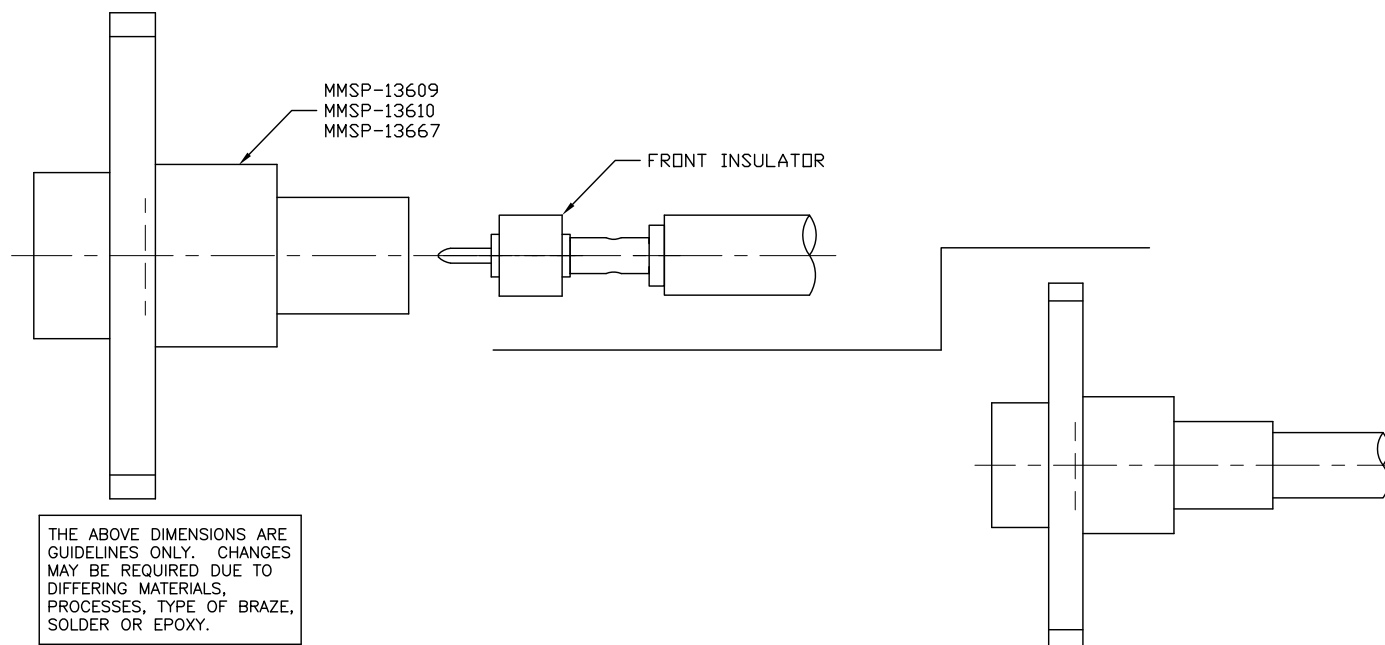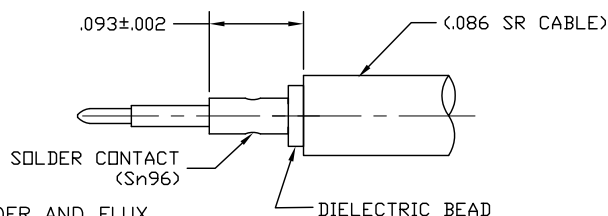
THE ABOVE DIMENSIONS ARE GUIDELINES ONLY. CHANGES MAY BE REQUIRED DUE TO DIFFERING MATERIALS, PROCESSES, TYPE OF BRAZE, SOLDER OR EPOXY.

MICRO-MODE PRODUCTS, INC.
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El Cajon, CA 92020
ph 619.449.3844
www.micromode.com

CAGE CODE
15907

REF: MMSP-13609, 13610. 13667

CABLE TRIM & ASSEMBLY PROCEDURES FOR MMSP-13609, 13610, 13667 TO .086 SR CABLE

DEFAULT TOLERANCES: .XXX ± .005   .XX ± .01

PART NO.
MMAP-13681

REVISION
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