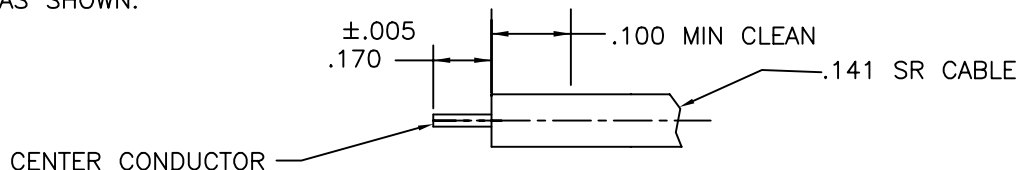
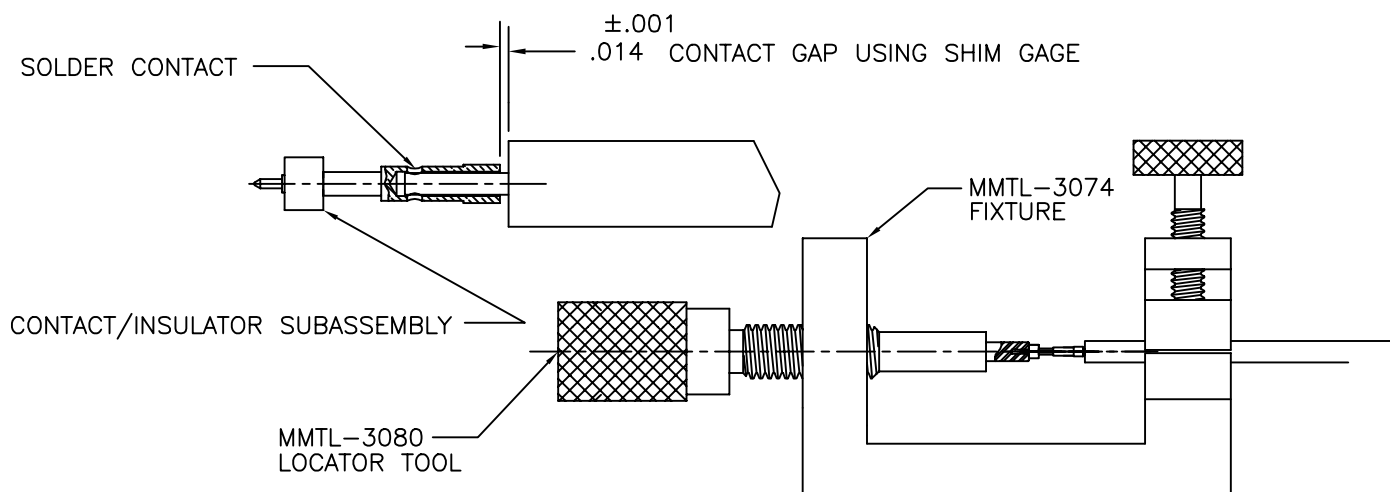


## CABLE SERVICE AND ASSEMBLY PROCEDURES:

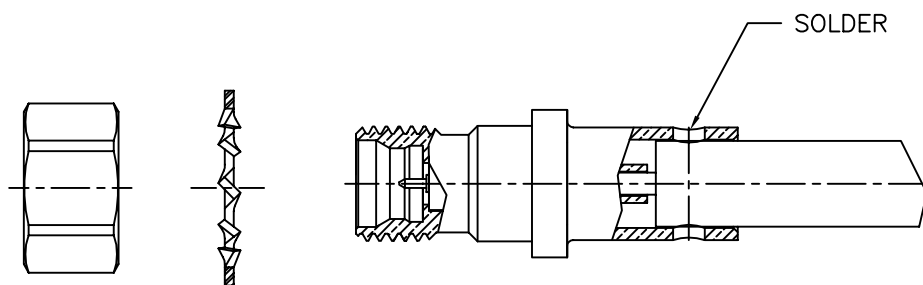
1. TRIM CABLE OUTER CONDUCTOR AND DIELECTRIC TO DIMENSION SHOWN, DO NOT NICK CENTER CONDUCTOR.
2. CLEAN CABLE OUTER CONDUCTOR USING FINE GRAIN SANDPAPER OR STEEL WOOL AS SHOWN.



3. PRE-TIN CENTER CONDUCTOR OF CABLE USING A SOLDER POT OR EQUIVALENT METHOD.
4. PLACE A .014  $\pm .001$  SHIM GAGE ON CABLE INNER CONDUCTOR.
5. PLACE CONTACT/INSULATOR SUBASSEMBLY ON CENTER CONDUCTOR AND SEAT AGAINST SHIM GAGE.
6. SOLDER CONTACT SUBASSEMBLY IN PLACE. (WARNING: SOLDERING TEMPERATURE MUST NOT EXCEED 550°F.)
7. REMOVE SHIM GAGE AND CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.



8. CAREFULLY INSERT CONTACT/CABLE SUB-ASSEMBLY INTO CONNECTOR SUB-ASSEMBLY. NOTE: CONTACT MUST BE FLUSH TO BELOW REFERENCE PLANE OF MMSP HOUSING.
9. APPLY GENTLE PRESSURE AND SOLDER CONNECTOR TO CABLE; SOLDERING TEMPERATURE MUST NOT EXCEED 550°F. CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.



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REF: MMSP-3390

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

CABLE SERVICE & ASSEMBLY PROCEDURES FOR  
MMSP-3390 FD BULKHEAD TO .141 SR CABLE

PART NO.

MMAP-3394

REVISION

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SHEET 1 OF 1 OL3394 7-12-99 EB PC