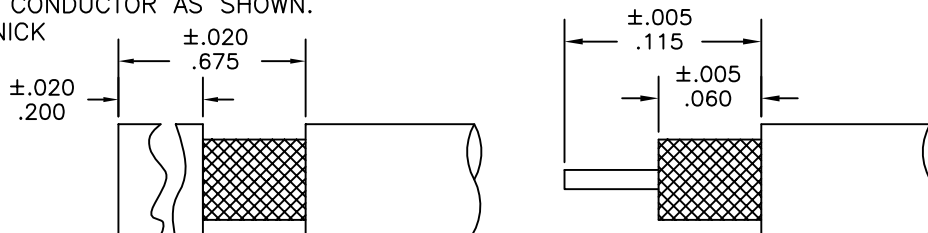
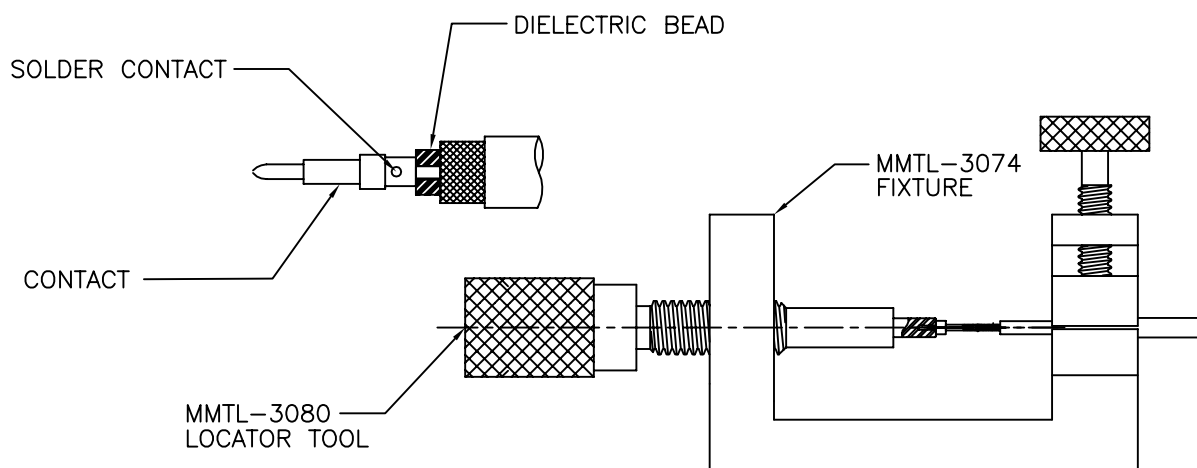


## CABLE SERVICE AND ASSEMBLY PROCEDURES:

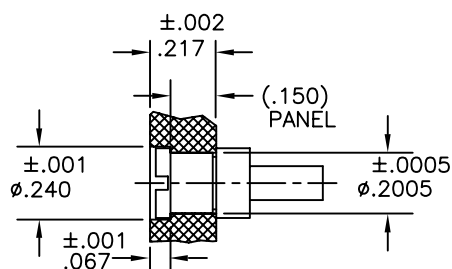
1. TRIM/STRIP CABLE JACKET TO EXPOSE BRAID AS SHOWN.  
TIN OUTER BRAID USING A SOLDER POT OR EQUIVALENT METHOD.  
TRIM BRAID TO CENTER CONDUCTOR AS SHOWN.  
USE CAUTION NOT TO NICK CENTER CONDUCTOR.



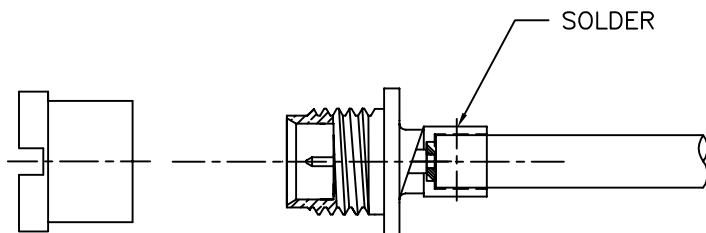
2. PRE-TIN CENTER CONDUCTOR OF CABLE USING A SOLDER POT OR EQUIVALENT METHOD.
3. PLACE DIELECTRIC BEAD ON CABLE INNER CONDUCTOR.
4. PLACE CONTACT ON CENTER CONDUCTOR AND SEAT AGAINST DIELECTRIC BEAD.
5. SOLDER CONTACT IN PLACE. (WARNING: SOLDERING TEMPERATURE MUST NOT EXCEED 550°F.)
6. CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.



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



MOUNTING HOLE/PANEL DETAIL



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-5900				CABLE SERVICE & ASSEMBLY PROCEDURES FOR MMSP-5900 (SBCM) MALE BULKHEAD MOUNT TO .065 FLEX CABLE			
DEFAULT TOLERANCES: <div>.XXX ± .005 .XX ± .01</div>							
SHEET 1 OF 1		OL5901 3-13-03		PART NO. MMAP-5901		REVISION —	