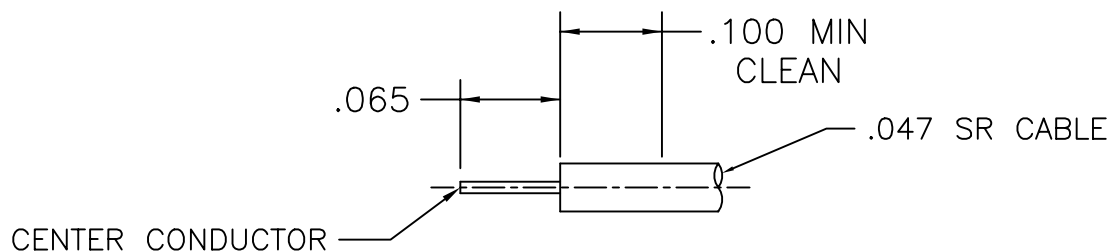


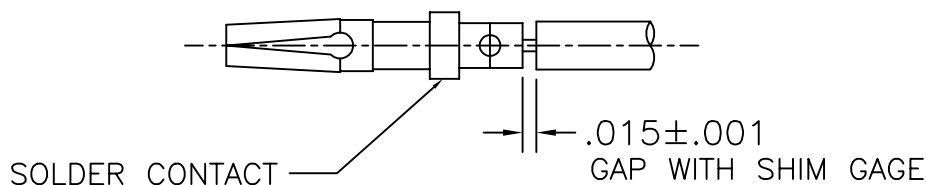
MICRO-MODE PRODUCTS INC.
CABLE SERVICE & ASSEMBLY PROCEDURES MMAP-6119
FOR MMSP-6120 (F) STRAIGHT TO .047 SR CABLE

CABLE SERVICE AND ASSEMBLY PROCEDURES:

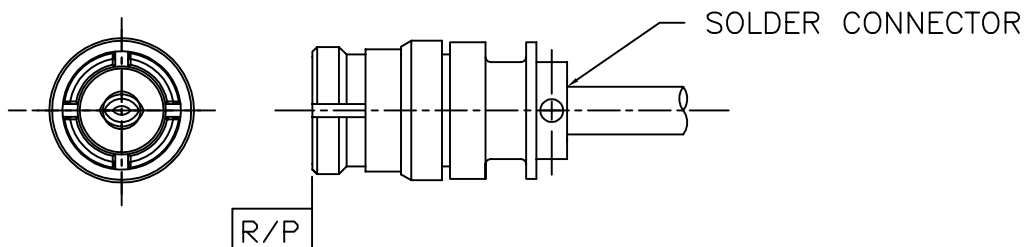
1. TRIM CABLE OUTER CONDUCTOR AND DIELECTRIC TO DIMENSION SHOWN, DO NOT NICK CENTER CONDUCTOR.
2. CLEAN CABLE OUTER CONDUCTOR USING FINE GRAIN ABRASIVE PAPER AS SHOWN.



3. PRE-TIN CENTER CONDUCTOR OF CABLE USING A SOLDER POT OR EQUIVALENT METHOD.
4. GAP CONTACT BY PLACING A $.015 \pm .001$ SHIM GAGE ON CABLE INNER CONDUCTOR AND PLACE FLUSH WITH END OF CABLE OUTER CONDUCTOR.
5. PLACE CONTACT ON CENTER CONDUCTOR AND FIRMLY SEAT AGAINST SHIM GAGE.
6. SOLDER CONTACT IN PLACE, SOLDERING TEMPERATURE MUST NOT EXCEED 550°F (288°C).
7. REMOVE SHIM GAGE AND CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.
8. VERIFY GAP.



9. PLACE CONNECTOR SUB-ASSEMBLY ONTO CONTACT/CABLE ASSEMBLY.
NOTE: CONTACT MUST BE FLUSH TO .004 BELOW REFERENCE PLANE OF OUTER CONDUCTOR.
10. SOLDER CONNECTOR TO CABLE; SOLDERING TEMPERATURE MUST NOT EXCEED 550°F.
CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.



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The Reliable Connection to the Future

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