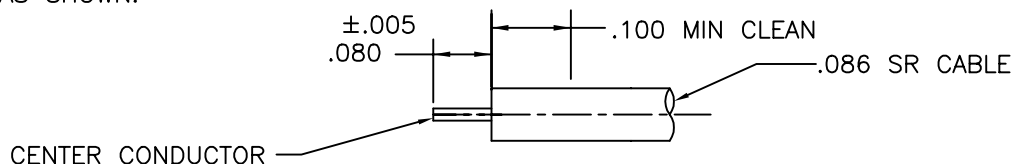
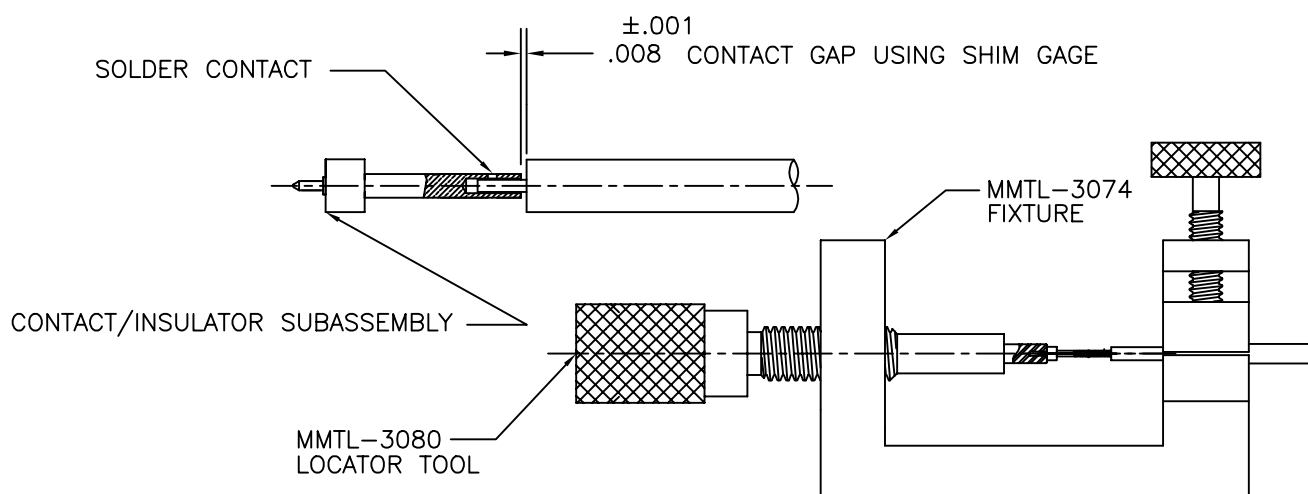


CABLE SERVICE AND ASSEMBLY PROCEDURES:

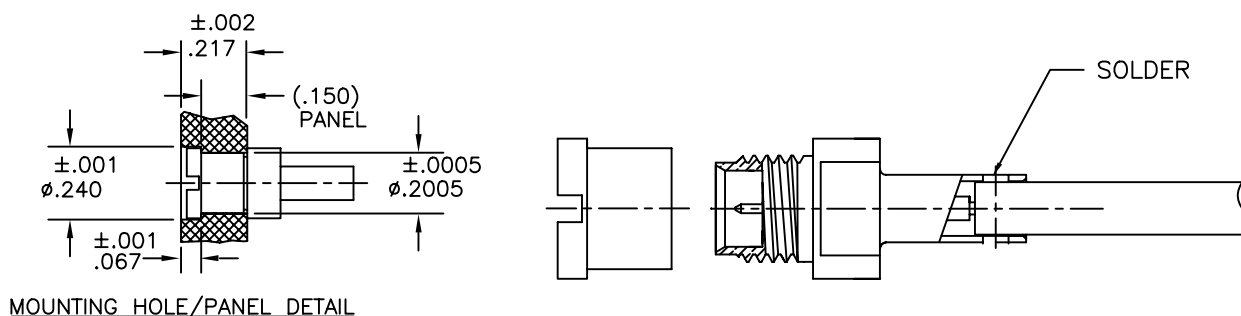
1. TRIM CABLE OUTER CONDUCTOR AND DIELECTRIC TO DIMENSION SHOWN;
DO NOT NICK CENTER CONDUCTOR.
2. CLEAN CABLE OUTER CONDUCTOR USING FINE GRAIN SANDPAPER OR
STEEL WOOL AS SHOWN.



3. PRE-TIN CENTER CONDUCTOR OF CABLE USING A SOLDER POT OR EQUIVALENT METHOD.
4. PLACE A $.008 \pm .001$ 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-6565 & MMSP-6566		CABLE SERVICE & ASSEMBLY PROCEDURES FOR MMSP-6565 (SBCM) & MMSP-6566 (FDCM) MALE BULKHEAD MOUNT TO .086 SR CABLE	
DEFAULT TOLERANCES: <div>.XXX ± .005 .XX ± .01</div>			
SHEET 1 OF 1	OL6568 9-13-99 PC	PART NO. MMAP-6568	REVISION —