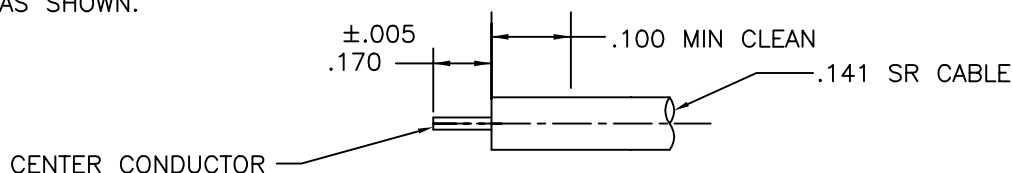
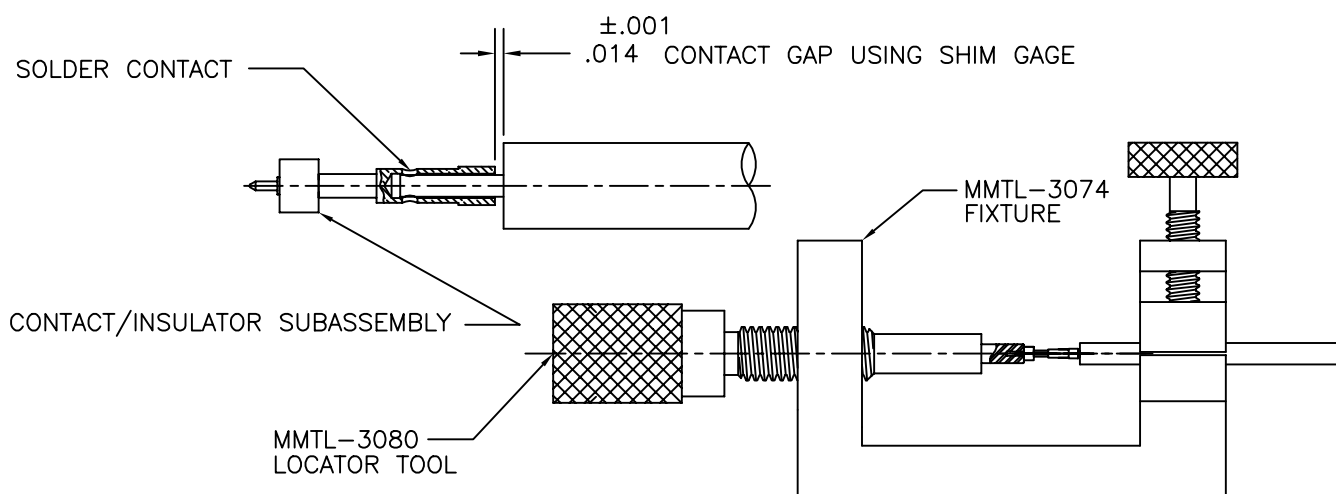


CABLE SERVICE AND ASSEMBLY PROCEDURES:

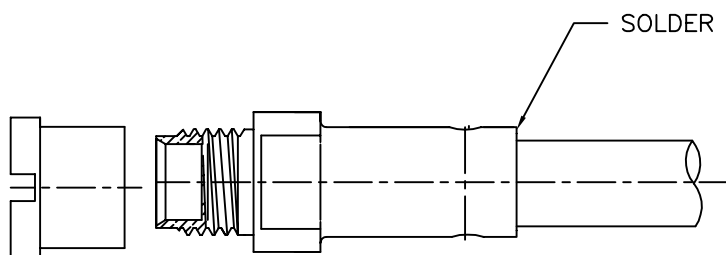
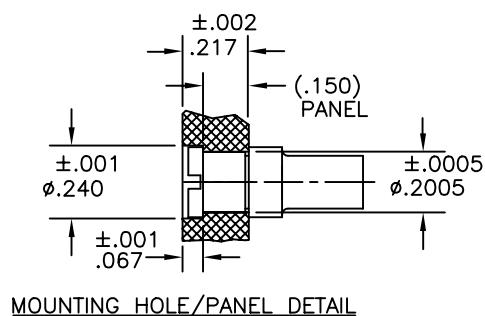
1. TRIM CABLE OUTER CONDUCTOR AND DIELECTRIC TO DIMENSION SHOWN;
DO NOT NICK CENTER CONDUCTOR.
2. CLEAN CABLE OUTER CONDUCTOR USING FINE GRAIN SANDPAPER OR
STEEL WOOL AS SHOWN.



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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CAGE CODE
15907

REF: MMSP-6567

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

CABLE SERVICE & ASSEMBLY PROCEDURES FOR
MMSP-6567 SBCM BULKHEAD TO .141 SR CABLE

PART NO.

MMAP-6569

REVISION

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SHEET 1 OF 1 OL6569 9-3-99 PC