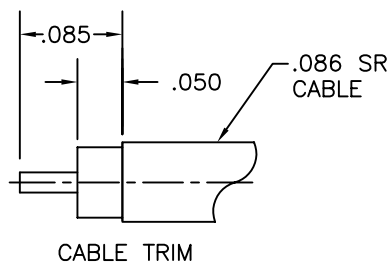
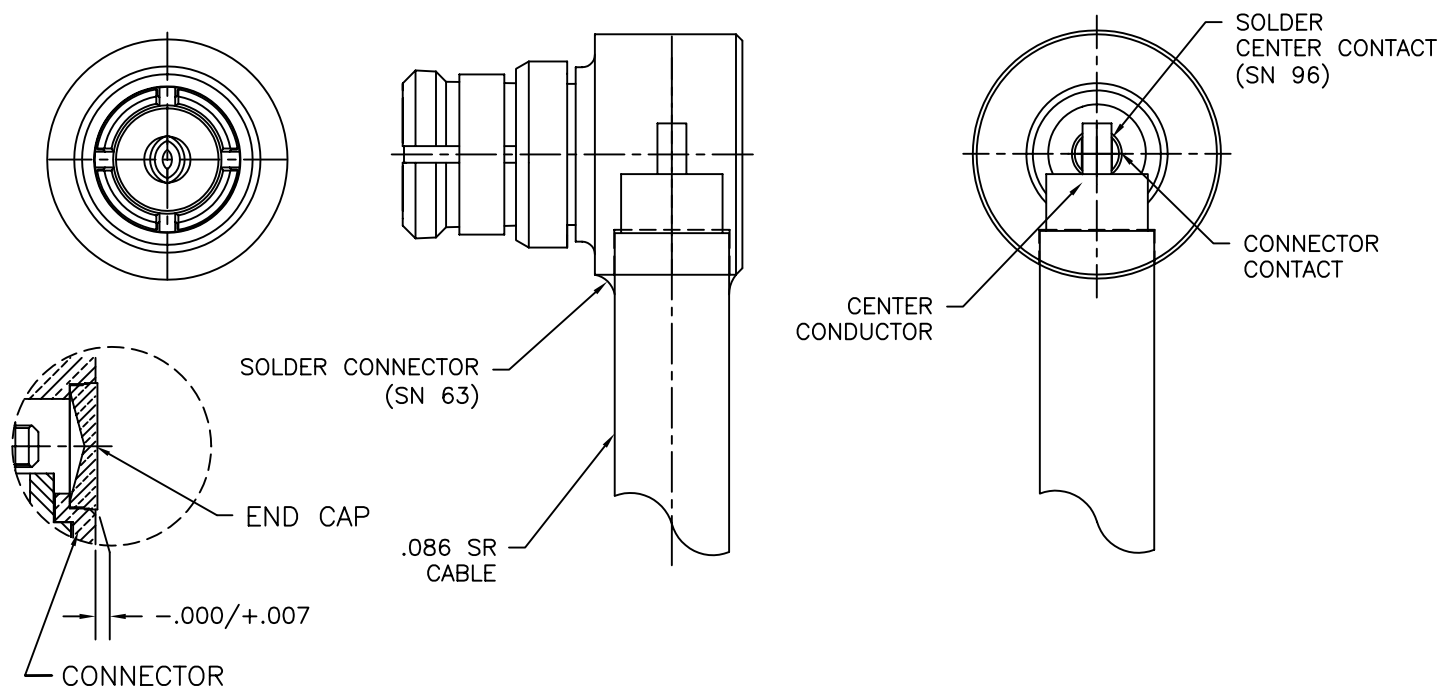


CABLE SERVICE AND ASSEMBLY PROCEDURES:

1. TRIM/STRIP CABLE JACKET AS SHOWN.



2. PRIOR TO INSERTION, ENSURE CONTACT SLOT IS ALIGNED TO RECEIVE CABLE CENTER CONDUCTOR
PLACE CONNECTOR SUB-ASSEMBLY ON CABLE.
NOTE: THE CABLE CENTER CONDUCTOR MUST BE PLACED IN CONTACT SLOT.
3. SOLDER CABLE CENTER CONDUCTOR ONTO CONTACT. USE SN 96 SOLDER.
SOLDERING TEMPERATURE MUST NOT EXCEED 550°F (288°C).
CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.
4. SOLDER CONNECTOR TO CABLE. USE SN 63 SOLDER.
SOLDERING TEMPERATURE MUST NOT EXCEED 550°F.
CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.
5. INSTALL PORT PLUG WITH C'SINK FACING INTO PORT HOLE. GENTLY PRESS END CAP.
PLUG INTO PLACE UNTIL FULLY SEATED.



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-7485

DEFAULT TOLERANCES:
.XXX ± .005
.XX ± .01

SHEET 1 OF 1 OL7597 8-10-04 MT

CABLE SERVICE & ASSEMBLY PROCEDURES
FOR MMSP-7485(F) RIGHT ANGLE TO .086
SR CABLE

PART NO.

MMAP-7597

REVISION

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