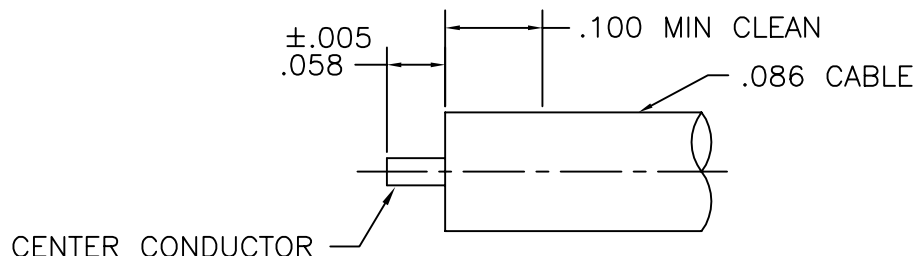
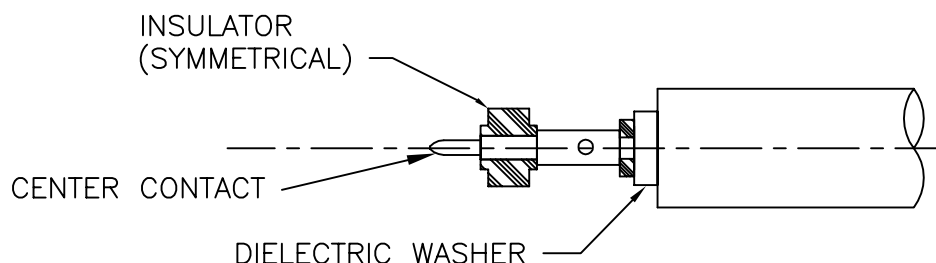


## CABLE SERVICE AND ASSEMBLY FOR MMSP-7705

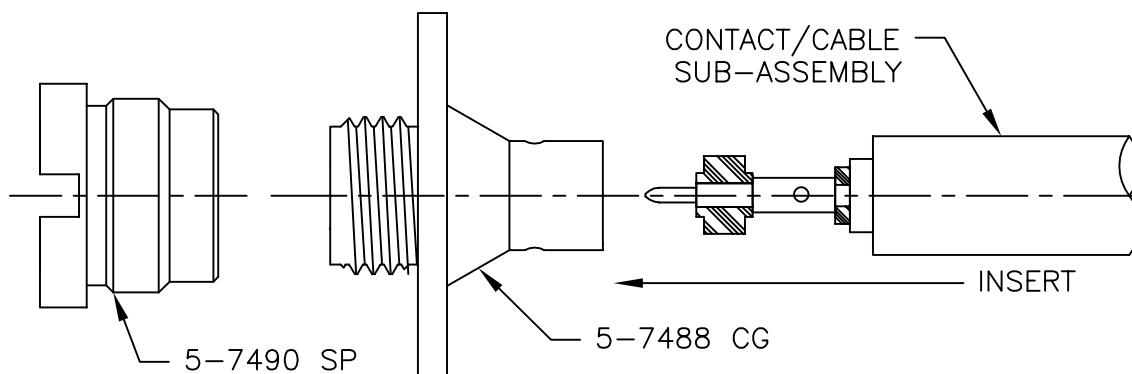
1. TRIM OUTER CONDUCTOR AND DIELECTRIC TO DIMENSION SHOWN.  
USE CAUTION, DO NOT NICK OR SLICE CABLE CENTER CONDUCTOR.
2. PRE-TIN CENTER CONDUCTOR OF CABLE USING SOLDER POT OR EQUIVALENT METHOD.
3. CLEAN OUTER CONDUCTOR AS SHOWN USING FINE GRAIN ABRASIVE PAPER  
OR SCOTCH-BRITE



4. INSTALL DIELECTRIC WASHER OVER PRE-TINNED CENTER CONDUCTOR.
5. PLACE CENTER CONTACT INTO APPROPRIATE LOCATOR/HOLDING TOOL, HEAT CENTER CONTACT AND PUSH OVER CENTER CONDUCTOR OF CABLE UNTIL IT FIRMLY RESTS AGAINST SUPPLIED DIELECTRIC WASHER. SOLDER CONTACT IN PLACE.
6. SLIDE INSULATOR OVER TIP OF CONTACT AND SEAT AGAINST SHOULDER OF CONTACT.



7. CAREFULLY INSERT CONTACT/CABLE SUB-ASSEMBLY INTO CONNECTOR .
8. APPLY GENTLE PRESSURE AND SOLDER CONNECTOR TO CABLE; SOLDERING TEMPERATURE MUST NOT EXCEED 550°F (288 C°). CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.



THE ABOVE DIMENSIONS ARE GUIDELINES ONLY. CHANGES MAY BE REQUIRED DUE TO DIFFERING MATERIALS, PROCESSES, TYPE OF BRAZE, SOLDER OR EPOXY.



MICRO-MODE PRODUCTS, INC.  
*The Reliable Connection to the Future*

El Cajon, CA 92020  
ph 619.449.3844  
www.micromode.com

CAGE CODE  
15907

INSERTION/EXTRACTION TOOL: N/A

CABLE SERVICE & ASSEMBLY  
PROCEDURES FOR MMSP-7487

PART NO.

MMAP-7705

REVISION

—

SHEET 1 OF 1 OL7705 10-7-04 MT

PART NO. MMAP-7705

CABLE SERVICE AND ASSEMBLY