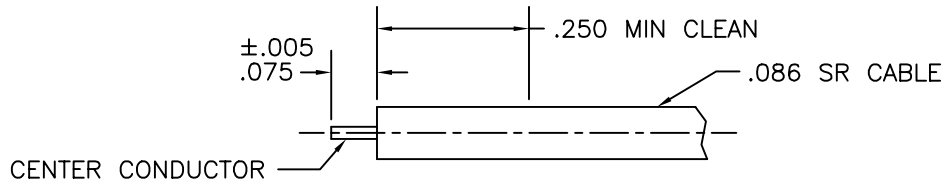
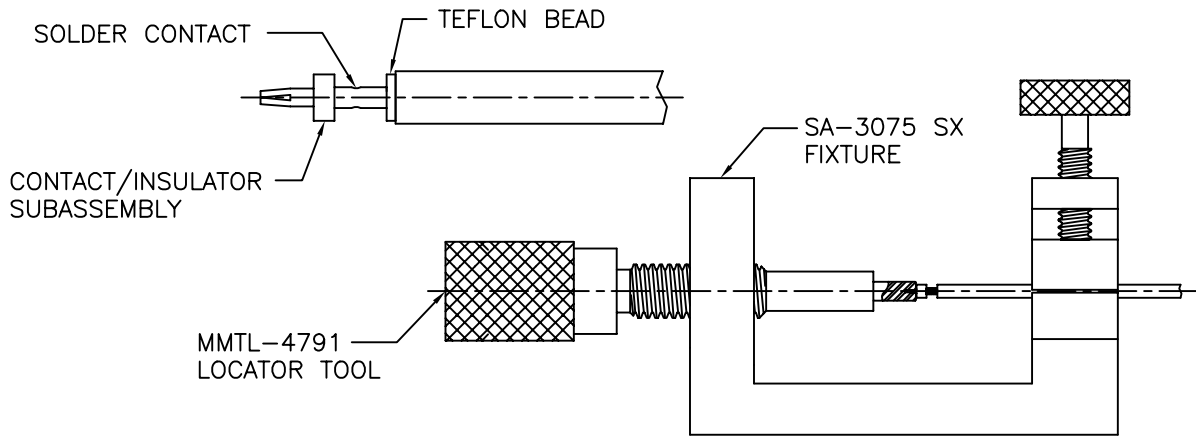


CABLE SERVICE AND ASSEMBLY PROCEDURES:

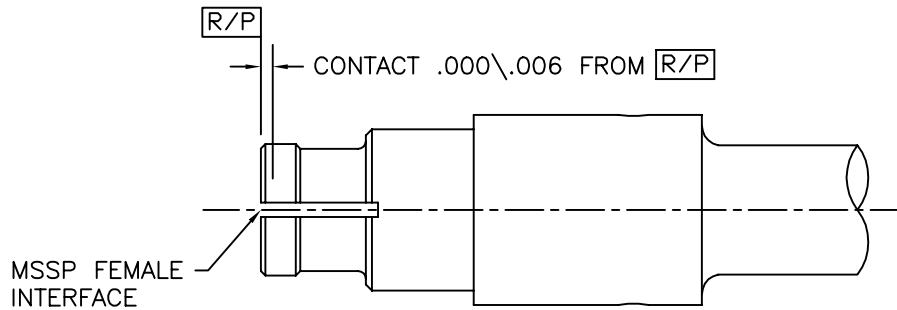
1. CLEAN CABLE OUTER CONDUCTOR USING FINE GRAIN ABRASIVE PAPER, THEN TRIM OUTER CONDUCTOR AND DIELECTRIC TO DIMENSION SHOWN. DO NOT NICK CENTER CONDUCTOR.



2. PRE-TIN CENTER CONDUCTOR OF CABLE USING A SOLDER POT OR EQUIVALENT METHOD.
3. PLACE TEFLON BEAD ON CABLE CENTER CONDUCTOR.
4. PLACE CONTACT/INSULATOR SUBASSEMBLY ON CENTER CONDUCTOR AND SEAT AGAINST TEFLON BEAD.
5. SOLDER CONTACT SUBASSEMBLY IN PLACE (WARNING: SOLDERING TEMPERATURE MUST NOT EXCEED 550°F).
6. REMOVE SHIM GAGE AND CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.



7. CAREFULLY INSERT CONTACT/CABLE SUBASSEMBLY INTO CONNECTOR BODY.
NOTE: CONTACT MUST BE FLUSH TO BELOW REFERENCE PLANE OF MSSP BODY. (SEE FIGURE BELOW)
8. 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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DEFAULT TOLERANCES:
.XXX \pm .005
.XX \pm .01

CABLE SERVICE & ASSEMBLY PROCEDURES FOR
MSSP-4772 FEMALE TO .086 SR CABLE

PART NO.

MMAP-4790

REVISION

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SHEET 1 OF 1 | M4790 9-25-01 RF MP