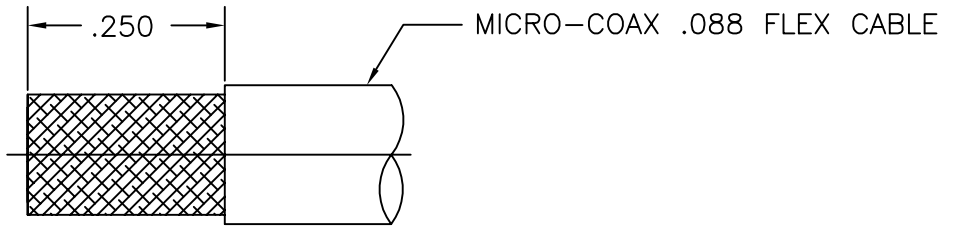


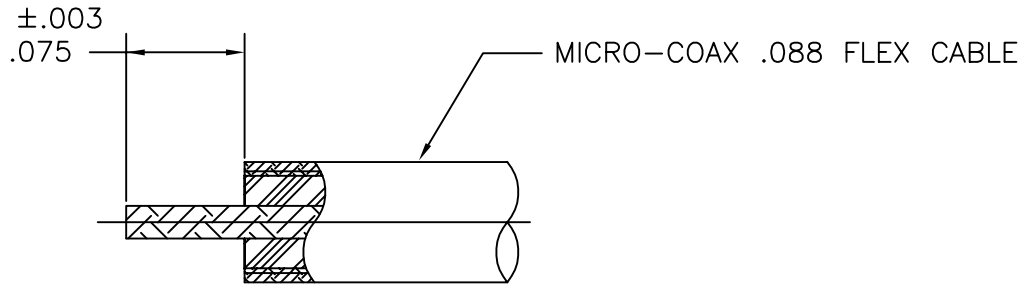
MICRO-MODE PRODUCTS INC.
CABLE SERVICE & ASSEMBLY PROCEDURES FOR MMSP-5185 (F)
RIGHT ANGLE TO MICRO-COAX .088 FLEX CABLE

CABLE SERVICE/PREPARATION

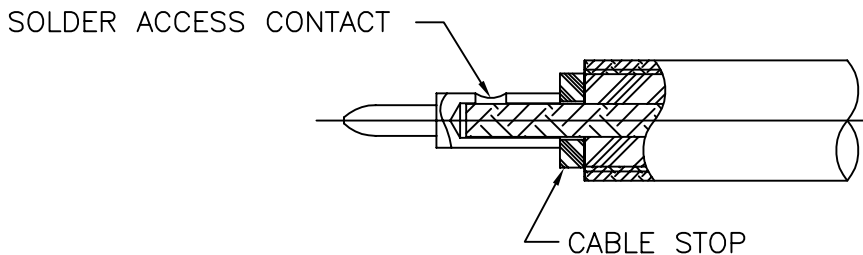
1. TRIM/STRIP CABLE JACKET TO EXPOSE BRAID AS SHOWN.
2. TIN OUTER BRAID USING A SOLDER POT OR EQUIVALENT METHOD.



3. TRIM TINNED BRAID TO EXPOSE CENTER CONDUCTOR AS SHOWN.
 USE CAUTION, DO NOT NICK OR SLICE CABLE CENTER CONDUCTOR.
4. PRE-TIN CENTER CONDUCTOR OF CABLE USING A SOLDER POT OR EQUIVALENT METHOD.



5. PRETIN I.D. OF ACCESS CONTACT.
 SLIDE CABLE STOP ONTO CENTER CONDUCTOR UNTIL IT SEATS AGAINST CABLE.
 PLACE ACCESS CONTACT INTO APPROPRIATE LOCATOR/HOLDING TOOL, HEAT ACCESS CONTACT AND PUSH OVER CENTER CONDUCTOR OF CABLE UNTIL IT FIRMLY RESTS AGAINST CABLE STOP. SOLDER CONTACT IN PLACE.



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

El Cajon, CA 92020
 (619) 449-3844
 www.micromode.com

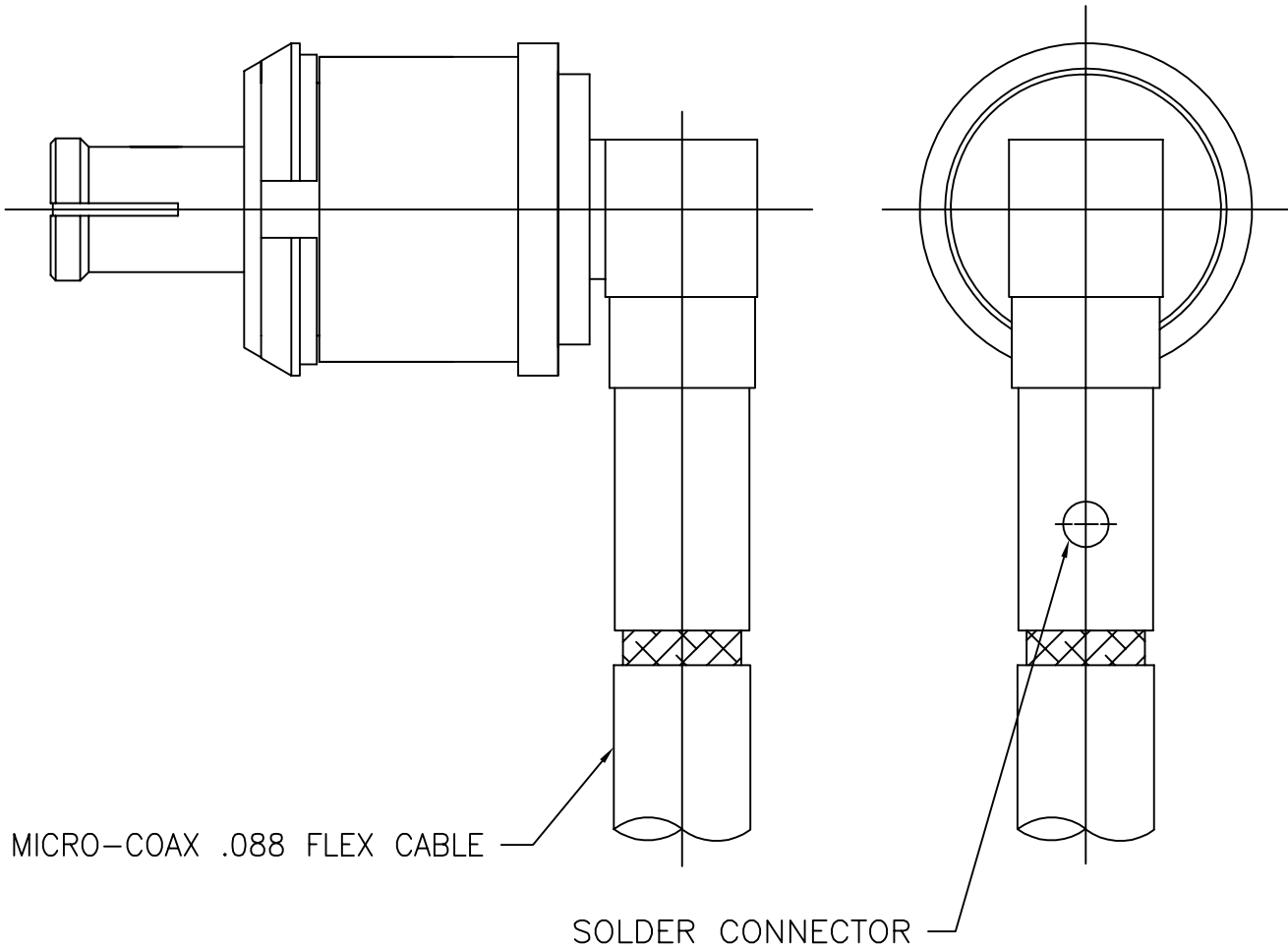
CAGE CODE
 15907

SHEET 1 OF 2	OL5214	4-26-02 MP RF	PART NO. MMAP-5214	REVISION —
--------------	--------	---------------	------------------------------	---------------

MICRO-MODE PRODUCTS INC.
CABLE SERVICE & ASSEMBLY PROCEDURES FOR MMSP-5185 (F) R/A
TO MICRO-COAX .088 FLEX CABLE

MMAP-5214

6. INSTALL ACCESS CONTACT/CABLE SUBASSEMBLY IN CONNECTOR SUBASSEMBLY.
SEAT CABLE ON CABLE STOP IN CONNECTOR BODY.
7. SOLDER CONNECTOR TO CABLE; SOLDERING TEMPERATURE MUST NOT EXCEED 550°F(288°C).
CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.



CABLE SERVICE & ASSEMBLY PROCEDURE



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

El Cajon, CA 92020
 (619) 449-3844
www.micromode.com

CAGE CODE
 15907

SHEET 2 OF 2	OL5214	4-26-02 MP RF	PART NO. MMAP-5214	REVISION —
--------------	--------	---------------	------------------------------	---------------