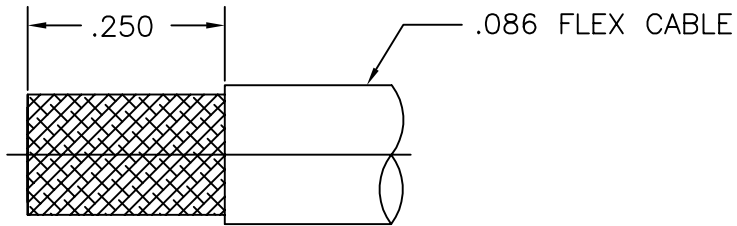


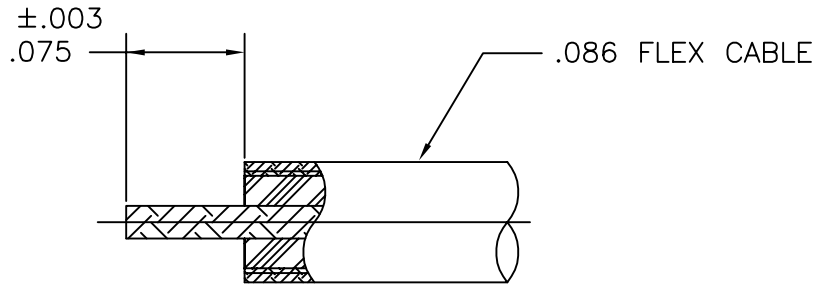
**MICRO-MODE PRODUCTS INC.**  
**CABLE SERVICE & ASSEMBLY PROCEDURES FOR MMSP-5187 (F)**  
**RIGHT ANGLE TO .086 FLEX CABLE**

CABLE SERVICE/PREPARATION

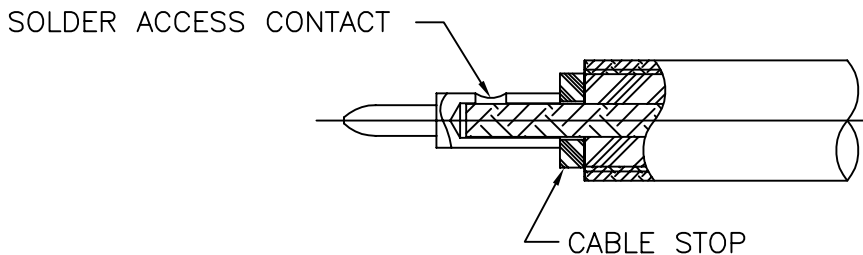
1. TRIM/STRIP CABLE JACKET TO EXPOSE BRAID AS SHOWN.
2. TIN OUTER BRAID USING A SOLDER POT OR EQUIVALENT METHOD.



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.



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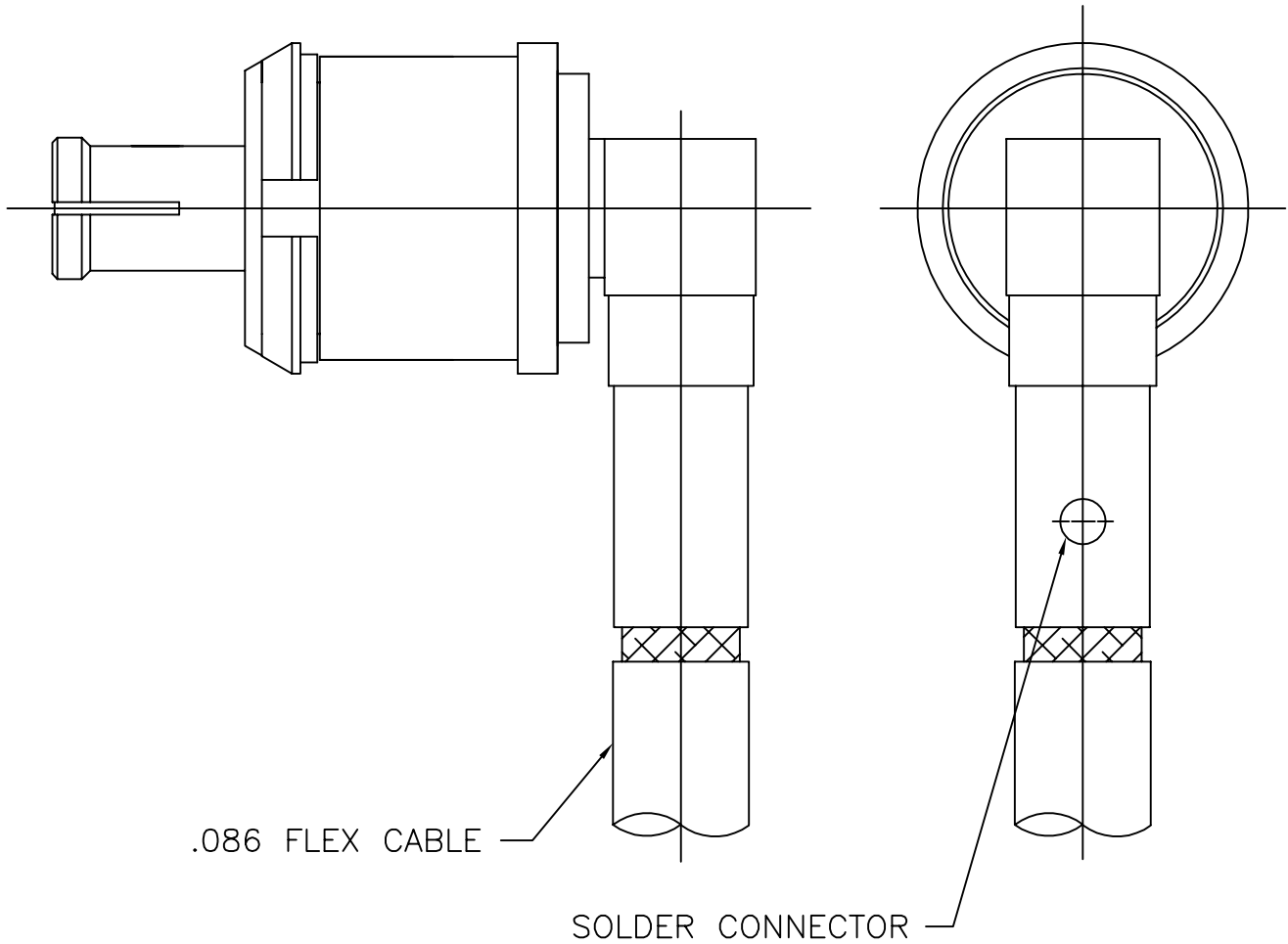
El Cajon, CA 92020  
 (619) 449-3844  
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CAGE CODE  
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SHEET 1 OF 2	OL5215	4-26-02 MP RF	PART NO. <b>MMAP-5215</b>	REVISION —
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**MICRO-MODE PRODUCTS INC.**  
**CABLE SERVICE & ASSEMBLY PROCEDURES FOR MMSP-5187 (F) R/A**  
**TO .086 FLEX CABLE**

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.



MMAP-5215

CABLE SERVICE & ASSEMBLY PROCEDURE



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SHEET 2 OF 2	OL5215	2-8-02 MP RF	PART NO. <b>MMAP-5215</b>	REVISION —
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