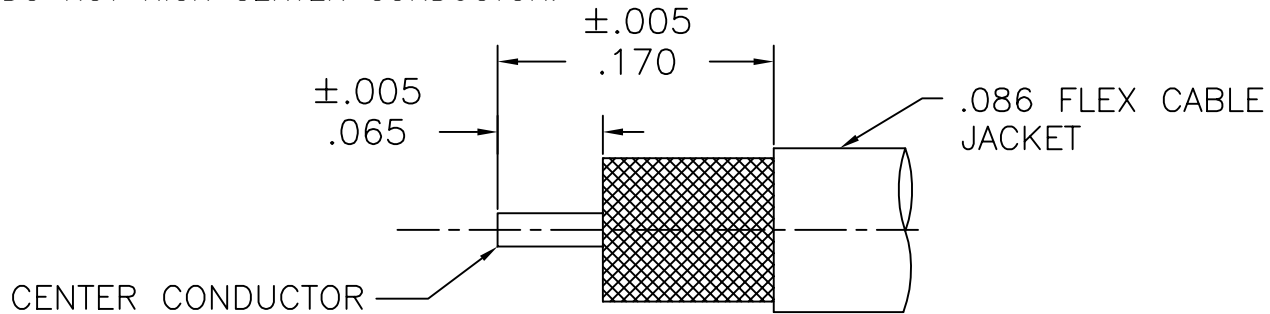


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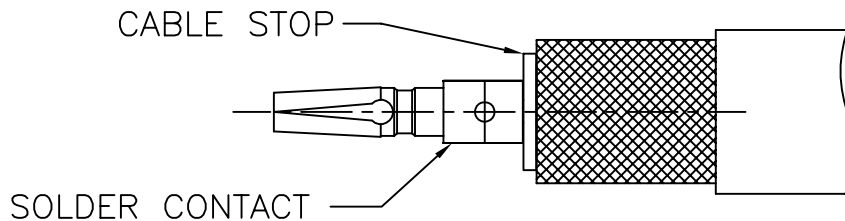
## CABLE SERVICE & ASSEMBLY PROCEDURES MMAP-6118 FOR MMSP-5989 (F) STRAIGHT TO .086 FLEX CABLE

### CABLE SERVICE AND ASSEMBLY PROCEDURES:

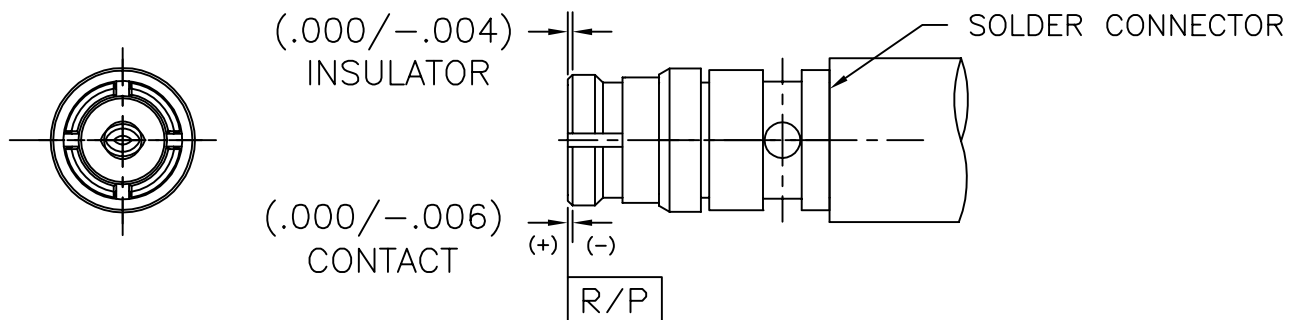
1. TRIM CABLE OUTER JACKET, BRAID AND DIELECTRIC TO DIMENSIONS SHOWN, DO NOT NICK CENTER CONDUCTOR.



3. PRE-TIN CENTER CONDUCTOR AND BRAID OF CABLE USING A SOLDER POT.
4. SLIDE CABLE STOP ONTO CENTER CONDUCTOR.
5. PLACE CONTACT ON CENTER CONDUCTOR AND FIRMLY SEAT AGAINST CABLE STOP.
6. SOLDER CONTACT IN PLACE. SOLDERING TEMPERATURE MUST NOT EXCEED 550°F.
7. CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.



8. PLACE CONNECTOR SUB-ASSEMBLY ONTO CONTACT/CABLE ASSEMBLY.  
NOTE: INSULATOR/CONTACT FLUSH TO BELOW REFERENCE PLANE OF OUTER CONDUCTOR.
9. SOLDER CONNECTOR TO CABLE; SOLDERING TEMPERATURE MUST NOT EXCEED 550°F.  
CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.



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