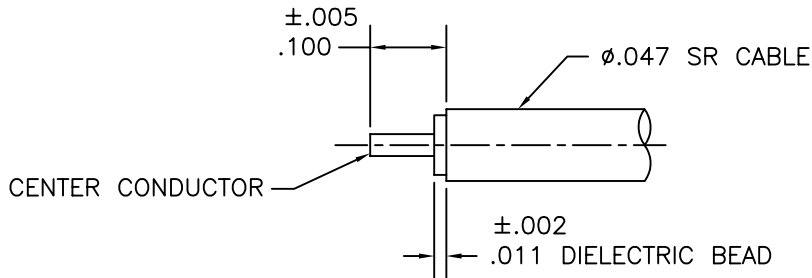


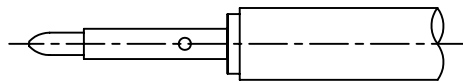
CABLE SERVICE AND ASSEMBLY PROCEDURES FOR MSSM-6235:

PART NO. MMAP-6427
CABLE SERVICE/ASSEMBLY PROCEDURES

1. PRETIN CONTACT WITH Sn96 SOLDER.
2. CLEAN CABLE OUTER JACKET ON AREA TO BE SOLDERED USING SCOTCHBRITE OR ABRASIVE PAPER.
3. CLEAN OUTER JACKET WITH ISOPROPYL ALCOHOL.
4. PRETIN CABLE OUTER JACKET WITH Sn63 SOLDER.
5. TRIM CABLE JACKET AND DIELECTRIC BACK $.100 \pm .005$.
6. SLIDE DIELECTRIC BEAD OVER CENTER CONDUCTOR AND SEAT AGAINST FACE OF CABLE.



7. SOLDER CONTACT ONTO CABLE CENTER CONDUCTOR, APPLYING LIGHT FORCE TO SEAT AGAINST DIELECTRIC BEAD.
8. CAREFULLY CLEAN FLUX AND EXCESS SOLDER FROM CONTACT.



9. THREAD SSMA INTERFACE TOOL INTO COUPLING NUT/BODY SUBASSEMBLY.
10. INSERT CONTACT/BEAD/CABLE SUBASSY INTO BODY. WRAP 2-3 TURNS OF $\phi.015$ SOLDER AROUND CABLE OUTER JACKET (USE Sn63 SOLDER).
11. SOLDER BODY TO CABLE, APPLYING LIGHT FORCE TO SEAT CONTACT SHOULDER AGAINST SSMA INTERFACE TOOL.
12. CLEAN FLUX AND EXCESS SOLDER FROM BODY.
13. REMOVE SSMA INTERFACE TOOL.
14. CHECK INSULATOR AND CONTACT STACKUP.



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REF: MSSM-6235		CABLE SERVICE & ASSEMBLY PROCEDURES FOR MSSM-6235 SSMA PLUG TO .047 SR CABLE	
DEFAULT TOLERANCES: .XXX \pm .005 .XX \pm .01			
SHEET 1 OF 1		PART NO.	REVISION
OL6427	12-14-04	MD EB	MMAP-6427 —