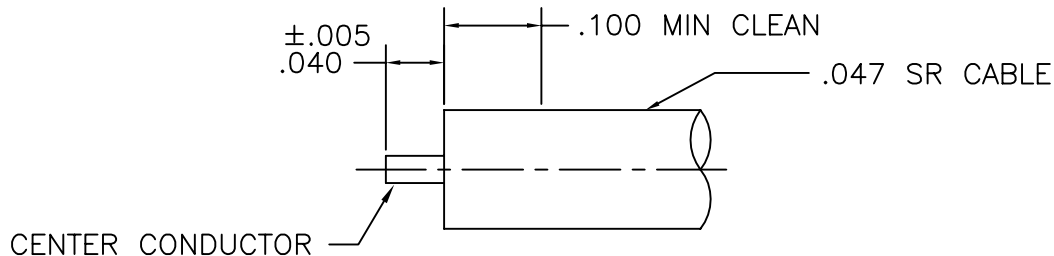
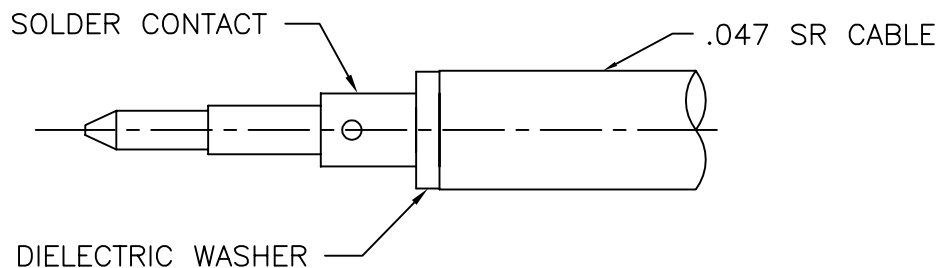


CABLE SERVICE AND ASSEMBLY FOR MSSS-7090

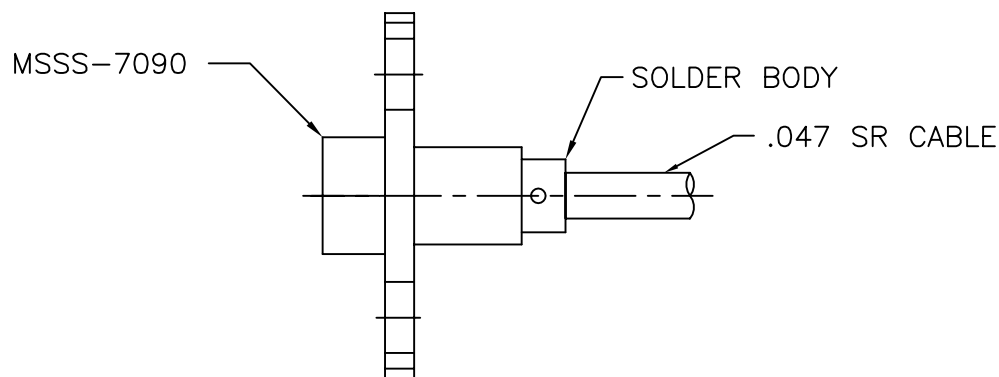
1. TRIM OUTER CONDUCTOR AND DIELECTRIC TO DIMENSION SHOWN.
USE CAUTION, DO NOT NICK OR SLICE CABLE CENTER CONDUCTOR.
2. PRE-TIN CENTER CONDUCTOR OF CABLE USING SOLDER POT OR EQUIVALENT METHOD.
3. CLEAN OUTER CONDUCTOR AS SHOWN USING FINE GRAIN ABRASIVE PAPER OR SCOTCH-BRITE



4. INSTALL DIELECTRIC WASHER OVER PRE-TINNED CENTER CONDUCTOR.
5. PLACE CENTER CONTACT INTO APPROPRIATE LOCATOR/HOLDING TOOL, HEAT CENTER CONTACT AND PUSH OVER CENTER CONDUCTOR OF CABLE UNTIL IT FIRMLY RESTS AGAINST SUPPLIED DIELECTRIC WASHER. SOLDER CONTACT IN PLACE.



6. CAREFULLY INSERT CONTACT/CABLE SUB-ASSEMBLY INTO CONNECTOR SUB-ASSEMBLY.
7. APPLY GENTLE PRESSURE AND SOLDER CONNECTOR TO CABLE; SOLDERING TEMPERATURE MUST NOT EXCEED 550°F (288°C). CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.



THE ABOVE DIMENSIONS ARE GUIDELINES ONLY. CHANGES MAY BE REQUIRED DUE TO DIFFERING MATERIALS, PROCESSES, TYPE OF BRAZE, SOLDER OR EPOXY.



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CABLE SERVICE & ASSEMBLY PROCEDURES
FOR MSSS-7090

PART NO.

MMAP-7091

REVISION

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PART NO. MMAP-7091

CABLE SERVICE AND ASSEMBLY