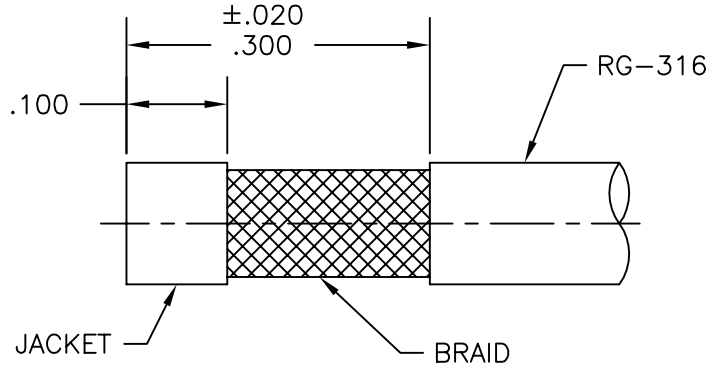
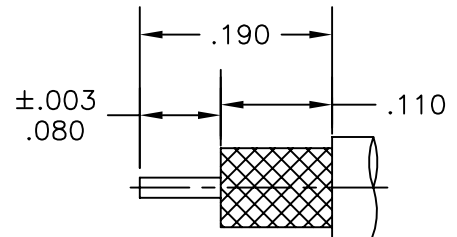


**CABLE SERVICE AND ASSEMBLY FOR MMSP-5636**

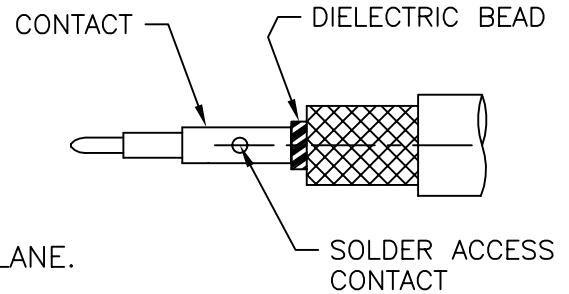
1. TRIM CABLE JACKET AS SHOWN.
2. PRE-TIN BRAID IN SOLDER POT OR EQUIVALENT METHOD.



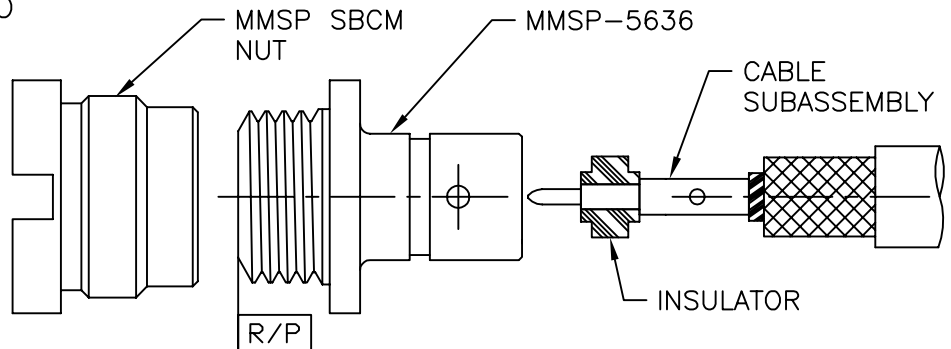
3. TRIM JACKET, BRAID, AND DIELECTRIC AS SHOWN.
4. PRE-TIN CENTER CONDUCTOR. DO NOT NICK CENTER CONDUCTOR.



5. SLIDE DIELECTRIC BEAD ONTO CENTER CONDUCTOR.
6. SEAT CONTACT AGAINST DIELECTRIC BEAD AND SOLDER IN PLACE
7. SLIDE INSULATOR ONTO CONTACT.
8. FULLY SEAT CABLE SUBASSEMBLY INTO BODY AND SOLDER IN PLACE.
9. CHECK STACKUP OF CONTACT AT REFERENCE PLANE. CONTACT SHOULDER AND INSULATOR MUST BE  $+0.000/-0.004$  RECESSED FROM REFERENCE PLANE.
10. USING MMTL-2688, INSTALL CONNECTOR SUBASSEMBLY INTO PANEL. TORQUE SBCM NUT TO 8 TO 10 IN-LBS.



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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15907

REF: MMSP-5636

CABLE SERVICE & ASSEMBLY PROCEDURES FOR MMSP-5636 (SBCM) MALE BULKHEAD MOUNT TO RG-316 CABLE

DEFAULT TOLERANCES: .XXX ± .005 .XX ± .01

PART NO.

REVISION

SHEET 1 OF 1 OL7117 10-21-03 MT

MMAP-7117

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