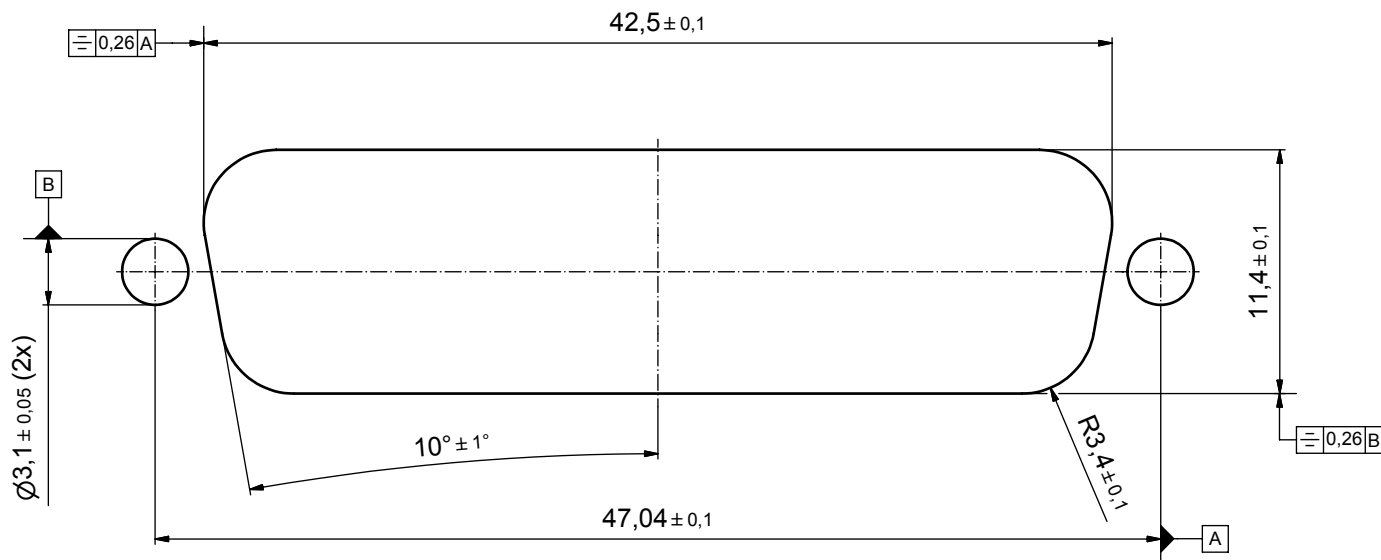


Solder Instruction

1. Cable should be prepared for soldering. The cable/wires must be pretinned.
2. Insert cable/wire into solder cup.
3. Operate the soldering iron at 350°C, 50 Watt max. and use a pencil tip.
4. Put tip to wire in solder cup.
5. After 1 second bring in solder.
6. Heat for 3 seconds longer. Do not heat contact more than 4 seconds in total.
7. Remove soldering iron.
8. Wait until solder gets rigid again.
9. Do not solder adjacent contacts consecutively,
alternate position within the connector to minimize heat build up.

RECOMMENDED PANEL CUT-OUT



APPROVAL # FREIGABE # DEBLOCAGE # AUTORIZACION # APPROVAL
CUSTOMER APPROVAL DATE:
NAME: TITLE:
COMPANY NAME:
APPROVAL # FREIGABE # DEBLOCAGE # AUTORIZACION # APPROVAL

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rev.	description	date	name
a	Origin		

tolerance		dim. in mm	
drawn	17.10.08	date	Petker
appd.	23.10.08	name	Fischer
norm			
d-old			

CONEC®

scale:	4:1		
material:	see sheet 1		
title:	PANEL CUT-OUT D-SUB MALE HD 44pos. SOLDER CUP with hexlocking screw		
dwg no:	Inventor 10	DIN-A3	
	15K1A296	sh: 2	
part no:	see sheet 1		