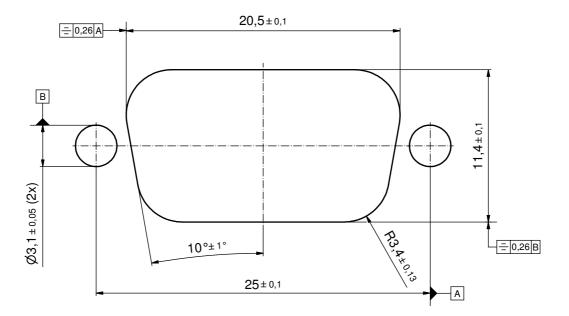


Solder Instruction

- 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 ℃, 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



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