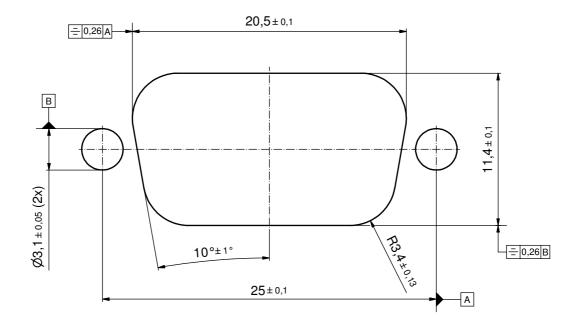


Solder Instruction

- 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



	DRAWING MAY NOT BE COPIED OR DODUCED IN AMY WAY, AND MAY NOT ASSED ON TO A THIRD PARTY WITHOUT TEN PERMISSION. ERSHIP AND COPYRIGHT OF CONEC GMBH	NOT ALTER CAD DRAWING BY HAND					tolerance		174	scale: 5:1
										material: see sheet 1
									dim. in mm	n
								date	name	title:
							drawn	17.10.08	Petker	PANEL CUT-OUT
							appd.	22.10.08	Fischer	D-SUB FEMALE 9pos. SOLDER CUP
							norm			with hexlocking screw
							d-old			dwg no: DIN-
								45 =		■ 15K1A279 A3
									1	sh: 2/2
	THIS DRA REPRODU BE PASSE WRITTEN OWNERSH	00	rev.	description	date	name	•	7/1	11-	part no: SEE SHEET 1
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