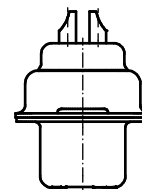
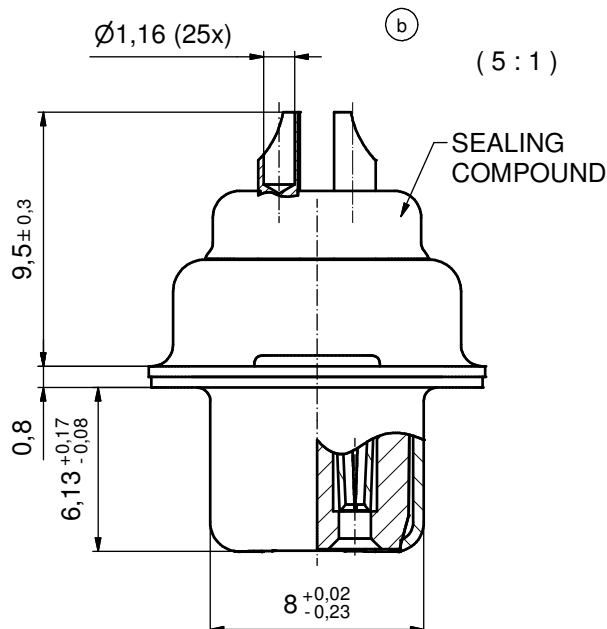
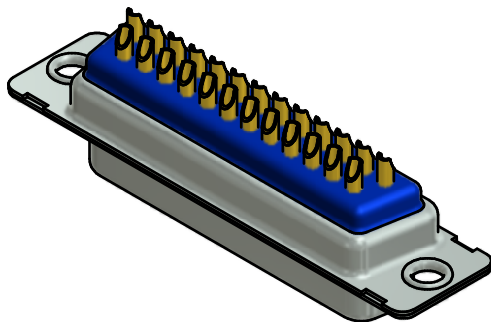
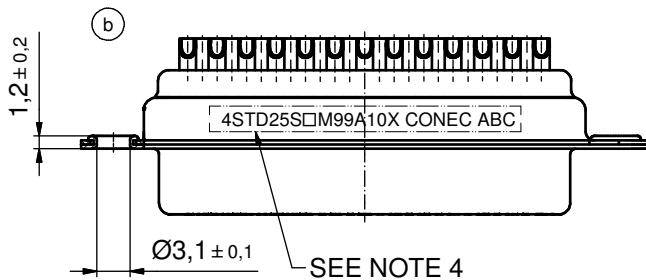
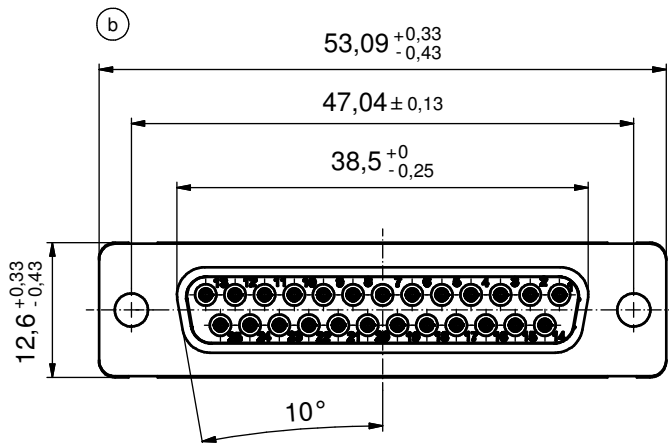


Solder Instruction (b)

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.



NOTES:

1. METAL SHELLS: COPPER ALLOY; min. 315µm TIN over 40-80µm NICKEL
2. INSULATORS: PBT GF UL 94 V-0; BLACK
3. CONTACTS: COPPER ALLOY; PLATING (SEE PART NO.):
 - PLEASE ADD C for 30µm HARD GOLD over min. 50µm NICKEL
 - PLEASE ADD B for 20µm HARD GOLD over min. 50µm NICKEL
 - PLEASE ADD A for GOLD FLASH over NICKEL (PREFERRED TYPE)SOLDER CUP ACCEPTS CABLE AWG 20
4. CONNECTOR IS PART MARKED: 4STD25S□M99A10X CONEC ABC (see note 3)

Directive 2002/95/EC RoHS compliant

THIS DRAWING MAY NOT BE COPIED OR REPRODUCED IN ANY WAY, AND MAY NOT BE PASSED ON TO A THIRD PARTY WITHOUT WRITTEN PERMISSION. OWNERSHIP AND COPYRIGHT OF CONEC GmbH				tolerance		 dim. in mm	scale: 2:1 (5:1)				
							material: SEE NOTES				
								date	name	title: D-SUB FEMALE 25pos. SOLDER CUP for installation into water resistant hood	
								drawn 03.08.12	Henneboel		
								appd. 03.08.12	Fischer		
				norm			dwg no: 15K1A1111  part no: 4STD25S□M99A10X (see note 3)				
				d-old	18K11B2A/18K21B2A						
6 x b	Ä4411	03.08.2012	K.H.			DIN-A3 sh: 1					
a	Original										
rev.	description	date	name								