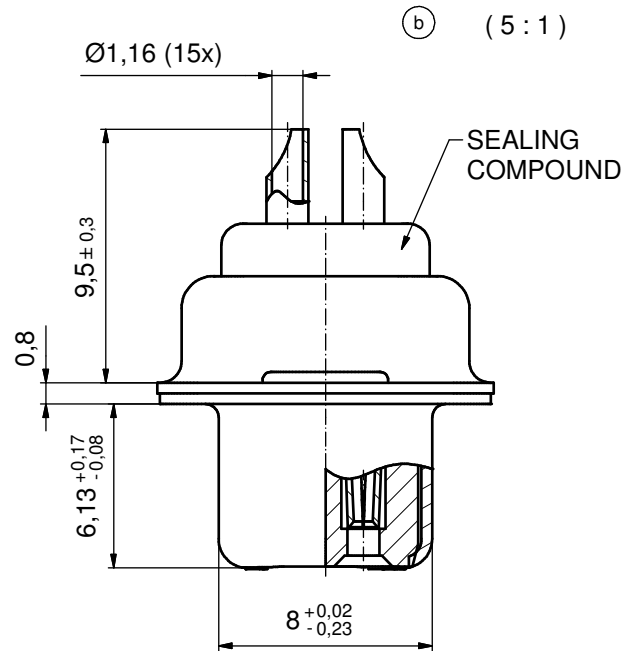
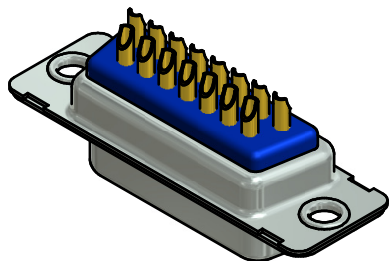
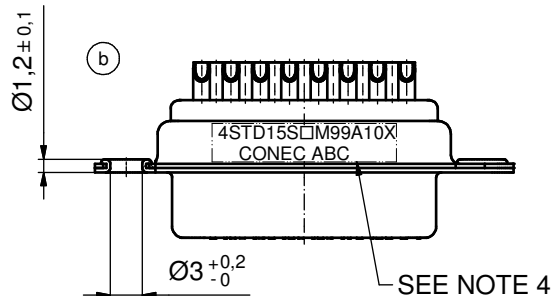
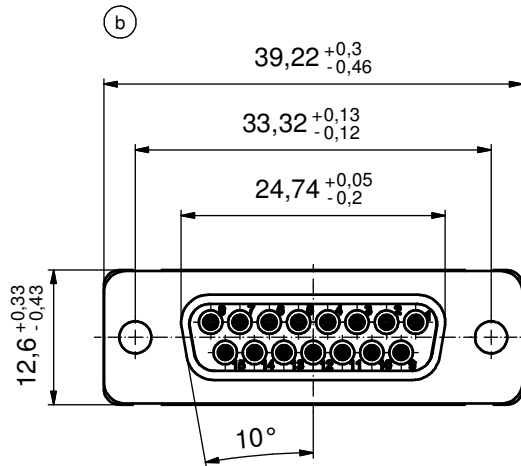


Solder Instruction b

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. METALSHELLS: COPPER ALLOY; min.315µin TIN over 40-80µin NICKEL
2. INSULATORS: PBT GF UL 94 V-0; BLACK
- b 3. CONTACTS: COPPER ALLOY; PLATING (SEE PART NO.):
 - PLEASE ADD C for 30µin HARD GOLD over min. 50µin NICKEL
 - PLEASE ADD B for 20µin HARD GOLD over min. 50µin NICKEL
 - PLEASE ADD A for GOLD FLASH over NICKEL (PREFERRED TYPE)
4. CONNECTOR IS PART MARKED: 4STD15S□M99A10X CONEC ABC (see note 3)

Directive 2002/95/EC RoHS compliant

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							material: SEE NOTES				
						date		name		title: D-SUB FEMALE 15pos. SOLDER CUP for installation into water resistant hood	
						drawn 03.08.12		Henneboel			
		appd. 03.08.12		Fischer							
		norm		d-old 18K11B2A/18K21B2A		dwg no:					
6 x b		Ä4411		03.08.2012		K.H.					
a		Original									
rev.		description		date		name					
						part no: 4STD15S□M99A10X (see note 3)					
						DIN-A3 sh: 1					