

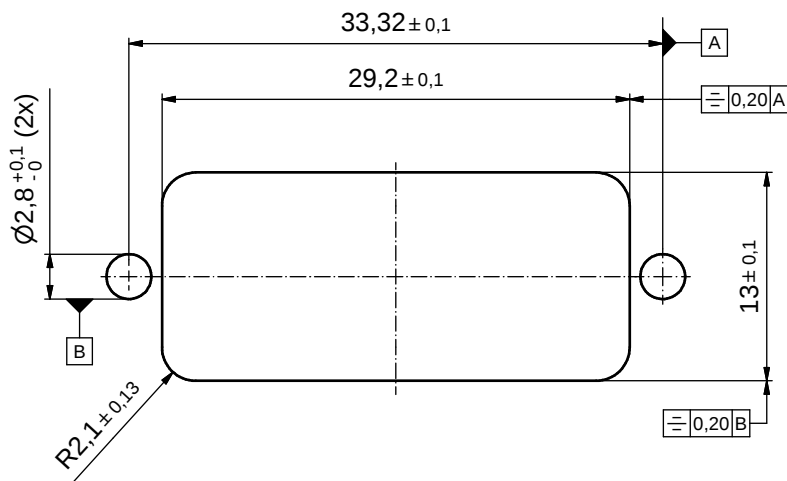
THIS DRAWING MAY NOT BE COPIED OR REPRODUCED IN ANY WAY, AND MAY NOT BE PASSED ON TO A THIRD PARTY WITHOUT WRITTEN PERMISSION. OWNERSHIP AND COPYRIGHT OF CONEC GMBH	DO NOT ALTER CAD DRAWING BY HAND				tolerance		 dim. in mm	scale: 2:1 (5:1)			
						date	name		material: SEE NOTES		
					drawn	01.07.13	Lehmenkühler		title: D-SUB MALE 15pos. SOLDER CUP with threaded lock and 4-40 UNC stud bolt		
					appd.	02.07.13	Fischer				
					norm						
					d-old 18K1A272						
	5 x b	Ä4815	01.07.2013	Lehm.					dwg no:	Inventor	DIN-A3
	a	Original							15K1A1331		sh: 1
	rev.	description	date	name					part no: 6STD15P□M99B70X (see note 4)		

⑥

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



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			scale: 3:1						
							material: SEE SHEET 1						
				dim. in mm		title: PANEL CUT-OUT D-SUB MALE 15pos. SOLDER CUP with threaded lock and 4-40 UNC stud bolt							
				date	name								
				drawn 01.07.13	Lehmenkühler								
				appd. 02.07.13	Fischer								
				norm									
d-old													
DO NOT ALTER CAD DRAWING BY HAND								dwg no:		Inventor		DIN-A3	
								15K1A1331		sh: 2			
				1 x b	Ä4815	01.07.2013	Lehm.	part no: SEE SHEET 1					
				a	Original								
rev.	description	date	name										