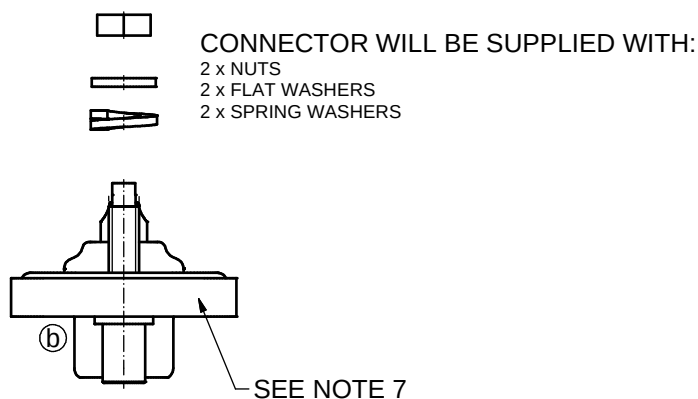
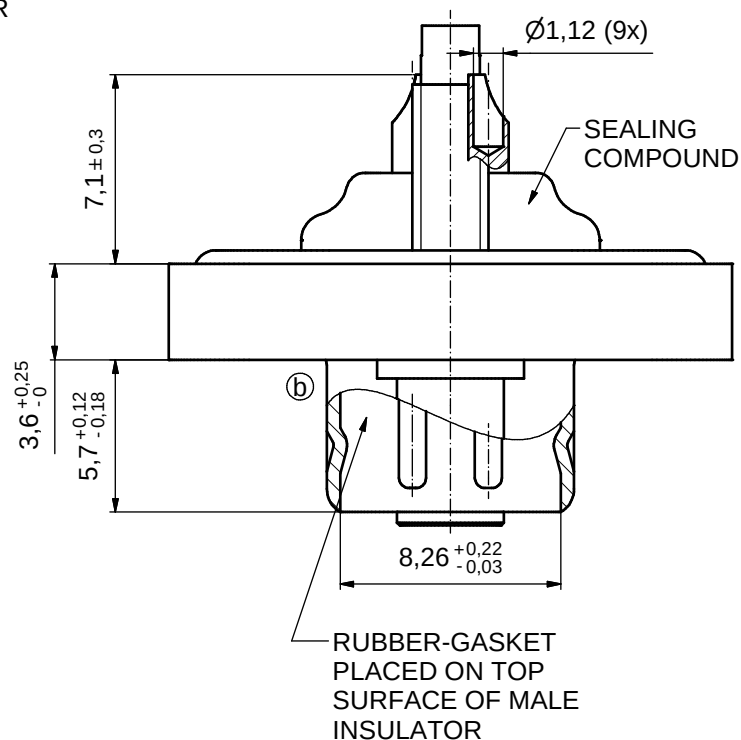
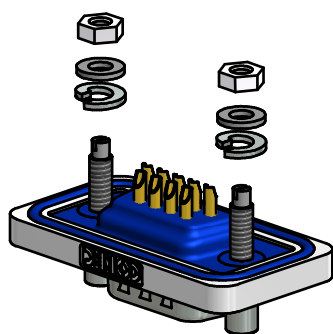


(5 : 1)



1. RECOMMENDED SOLDER INSTRUCTION SEE SHEET 2
2. METAL SHELLS: COPPER ALLOY; min. 320µin TIN over 40-80µin NICKEL
3. INSULATORS: PBT GF UL 94 V-0; BLACK
4. SIGNAL 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)SOLDER CUP ACCEPTS CABLE AWG 20
5. THREADED LOCKS: COPPER ALLOY; min. 200µin TIN over 80µin NICKEL
6. COLLARS: COPPER ALLOY, min. 200µin TIN over 80µin NICKEL
7. FRAME: ZINC DIE CAST; NICKEL PLATED
8. STUD BOLTS / 4-40 UNC: STEEL; TIN PLATED
9. O-RING: SILICON; BLUE
10. SEALING COMPOUND: PUR; BLUE
11. RUBBER GASKET: TPE; BLACK
12. RECOMMENDED PANEL CUT-OUT ON SHEET 2
13. RECOMMENDED TORQUE FOR STUD BOLT 35Ncm (3,1 in.LB) / max. 40Ncm (3,5 in.LB)
14. CONNECTOR IS PART MARKED: 6STD09P□M99B70X CONEC ABCI (see note 4)



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DO NOT ALTER CAD DRAWING BY HAND

				tolerance		 dim. in mm	
					date	name	
				drawn	11.05.12	Henneboel	
				appd.	14.05.12	Fischer	
				norm			
				d-old 18K1A272			
6 x b	Ä4815	28.06.2013	Lehm.				
a	Original						
rev.	description	date	name				

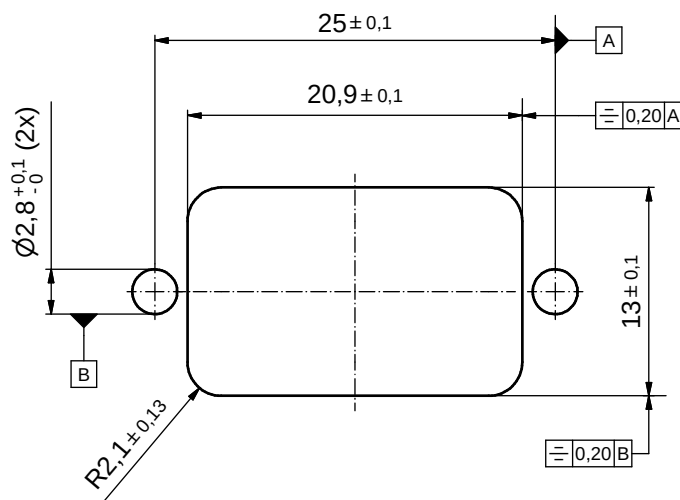


scale:	2:1 (5:1)	
material:	SEE NOTES	
title:	D-SUB MALE 9pos. SOLDER CUP with threaded lock and 4-40 UNC stud bolt	
dwg no:	15K1A1042 (b)	DIN- A3 sh: 1
part no: 6STD09P□M99B70X (see note 4)		

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



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								material: SEE SHEET 1	
					date	name	title: PANEL CUT-OUT D-SUB MALE 9pos. SOLDER CUP with threaded lock and 4-40 UNC stud bolt		
					drawn 11.05.12	Henneboel			
					appd. 14.05.12	Fischer			
					norm				
					d-old		dwg no:		DIN-A3
	a	Original						15K1A1042	
								sh: 2	
	rev.	description	date	name				part no: SEE SHEET 1	