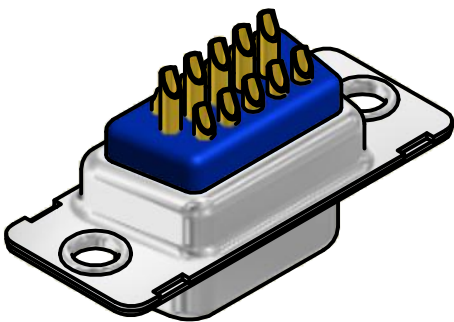
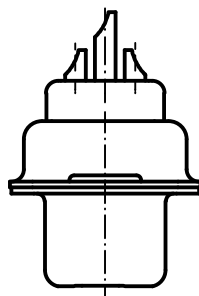
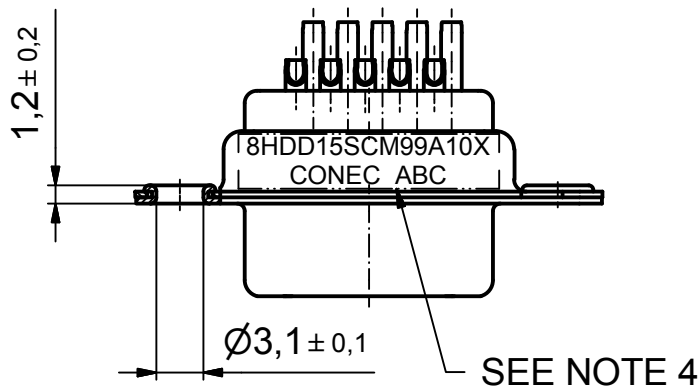
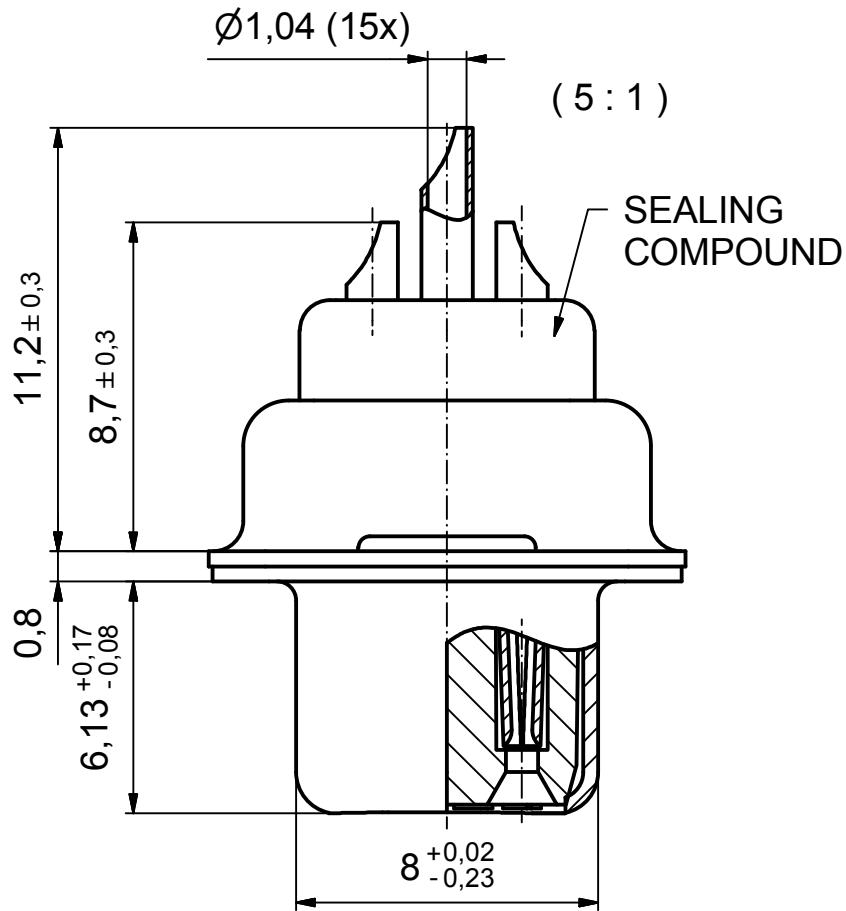
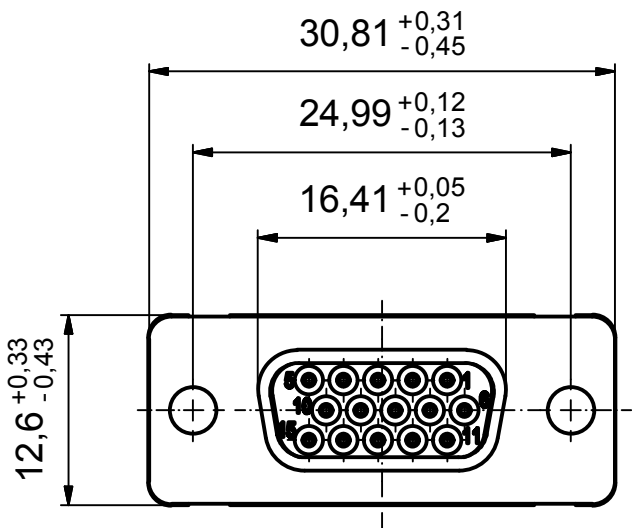


Solder Instruction

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.



NOTES:

1. METALSHELLS: STAINLESS STEEL
2. INSULATORS: PBT GF UL 94 V-0; BLACK
3. CONTACTS: COPPER ALLOY
PLATING: 30µin HARD GOLD over min. 50µin NICKEL
SOLDER CUP ACCEPTS CABLE AWG 22
4. CONNECTOR IS PART MARKED: 8HDD15SCM99A10X CONEC ABC

Directive 2002/95/EC RoHS compliant

APPROVAL # FREIGABE # DEBLOCAGE # AUTORIZACION # APPROVAL	
CUSTOMER APPROVAL DATE:	
NAME:	TITLE:
COMPANY NAME:	
APPROVAL # FREIGABE # DEBLOCAGE # AUTORIZACION # APPROVAL	

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DO NOT ALTER CAD DRAWING BY HAND

rev.	description	date	name
a	Origin		

tolerance	dim. in mm
date	name
drawn	08.10.10
appd.	08.10.10
norm	
d-old	
CONEC	

scale:	2:1 (5:1)	
material:	SEE NOTES	
title:	D-SUB HD FEMALE 15pos. SOLDER CUP for installation into water resistant hood	
dwg no:	Inventor 10	DIN-A3
part no:	15K1A731 8HDD15SCM99A10X	