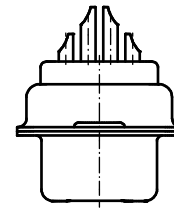
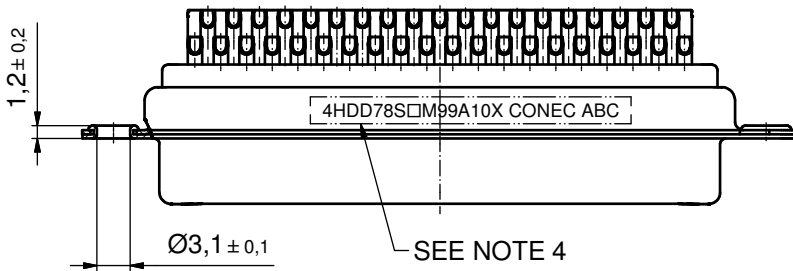
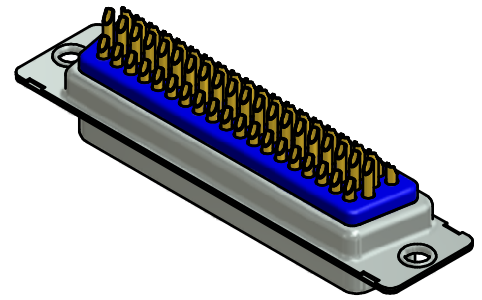
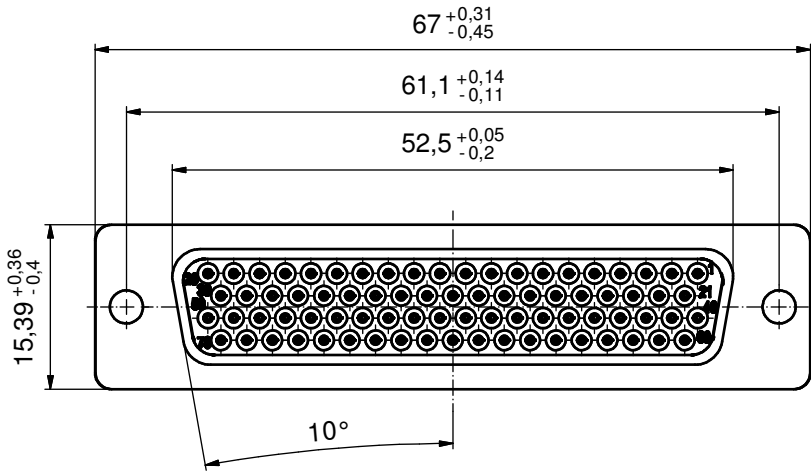
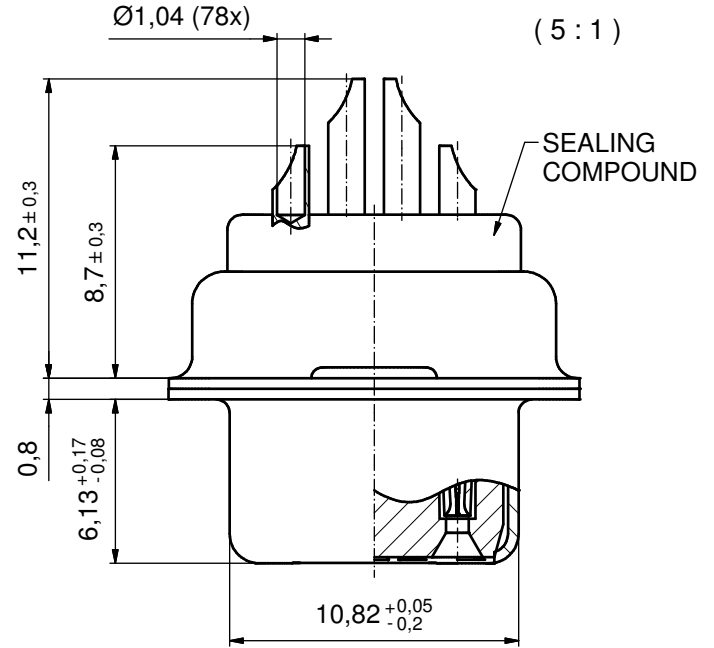


Solder Instruction

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. METALSHIELDS: COPPER ALLOY; min. 315µm TIN over 40-80µm NICKEL
2. INSULATOR: PBT GF UL 94 V-0; BLACK
3. SIGNAL CONTACTS: COPPER ALLOY; PLATING (SEE PART NO.):
 PLEASE ADD for GOLD FLASH over NICKEL (PREFERRED TYPE)
 PLEASE ADD for 20µm HARD GOLD over min. 50µm NICKEL
 PLEASE ADD for 30µm HARD GOLD over min. 50µm NICKEL
 SOLDER CUP ACCEPTS CABLE AWG 22
4. CONNECTOR IS PART MARKED: 4HDD78S□M99A10X CONEC ABC (see note 3)

Directive 2002/95/EC RoHS compliant

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				material: SEE NOTES		
	drawn	19.08.13	Henneboel	title: D-SUB HD FEMALE 78pos. SOLDER CUP for installation into water resistant hood		
	appd.	19.08.13	Fischer			
	norm					
d-old			dwg no:		DIN-A3	
a	Original				sh: 1	
rev.	description	date			name	part no: 15K1A1359
			part no: 4HDD78S□M99A10X (see note 3)			