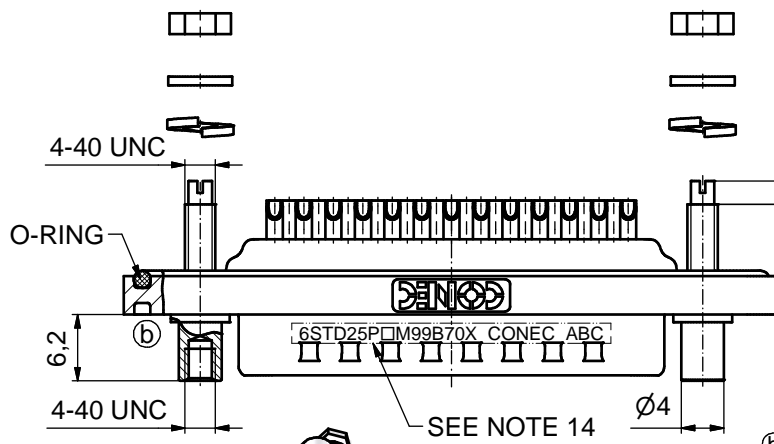
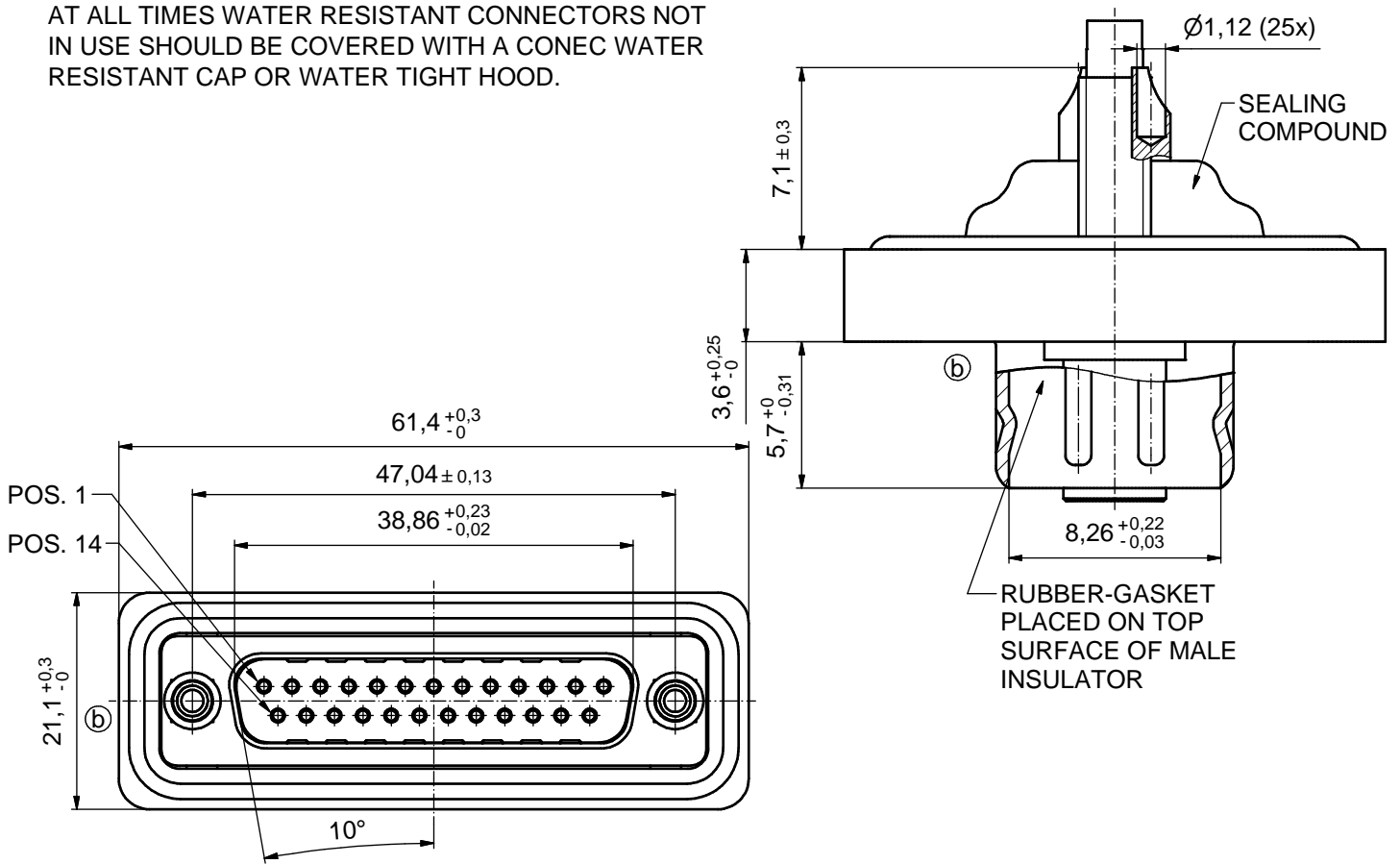
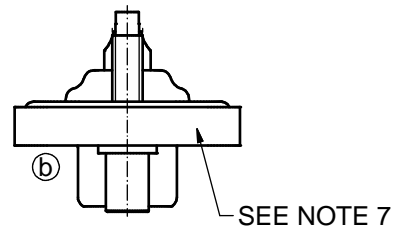


AT ALL TIMES WATER RESISTANT CONNECTORS NOT IN USE SHOULD BE COVERED WITH A CONEC WATER RESISTANT CAP OR WATER TIGHT HOOD.

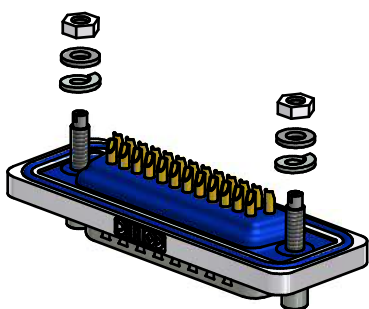
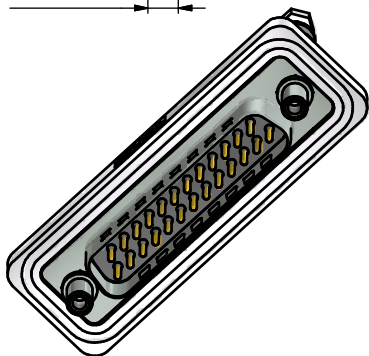


- CONNECTOR WILL BE SUPPLIED WITH:
- 2 x NUTS
 - 2 x FLAT WASHERS
 - 2 x SPRING WASHERS



NOTES:

1. RECOMMENDED SOLDER INSTRUCTION SEE SHEET 2
2. METALSHHELLS: 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)
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: 6STD25P M99B70X CONEC ABC (see note 4)



Directive 2002/95/EC RoHS compliant

tolerance				dim. in mm		scale: 2:1 (5:1)	
				material: SEE NOTES		title:	
date				name		D-SUB MALE 25pos. SOLDER CUP with threaded lock and 4-40 UNC stud bolt	
drawn 01.07.13				Lehmenkühler			
appd. 02.07.13				Fischer			
norm				d-old		dwg no:	
				18K1A272		15K1A1332	
5 x b				Ä4815		DIN-A3	
a				Original		sh: 1	
rev. description				date		part no: 6STD25P M99B70X (see note 4)	
name				date		name	

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DO NOT ALTER CAD DRAWING BY HAND

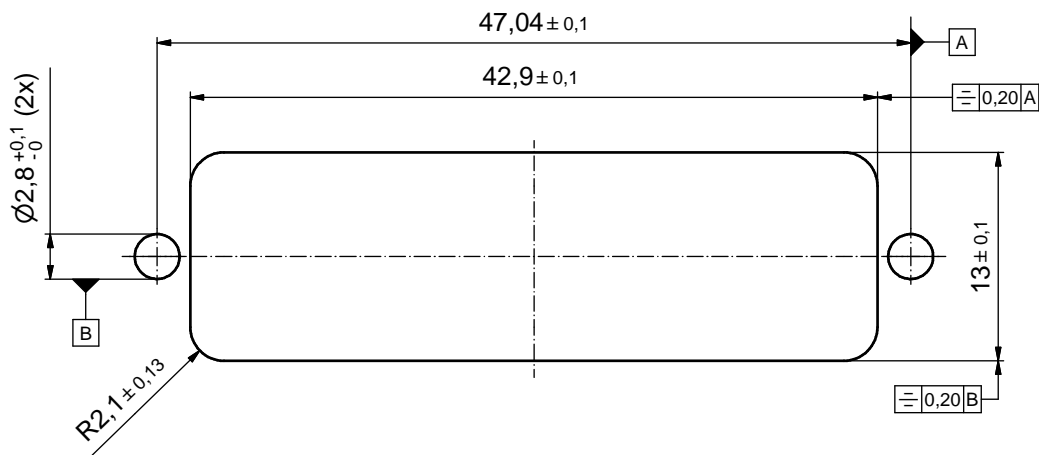


ⓑ

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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				date	name	material: SEE SHEET 1
				drawn	01.07.13	Lehmenkühler
				appd.	02.07.13	Fischer
				norm		
1 x b	Ä4815	01.07.2013	Lehm.	PANEL CUT-OUT D-SUB MALE 25pos. SOLDER CUP with threaded lock and 4-40 UNC stud bolt		
a	Original					
rev.	description	date	name			sh: 2
						part no: