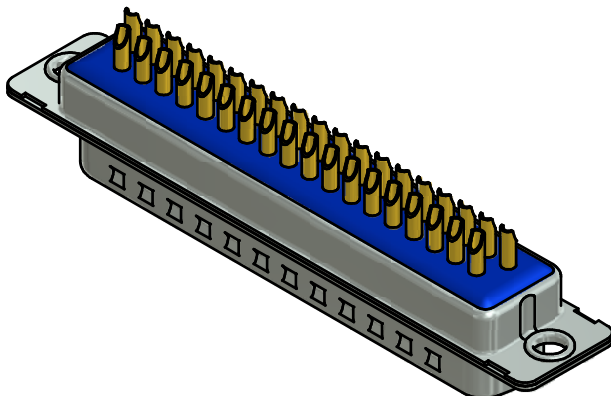
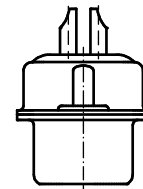
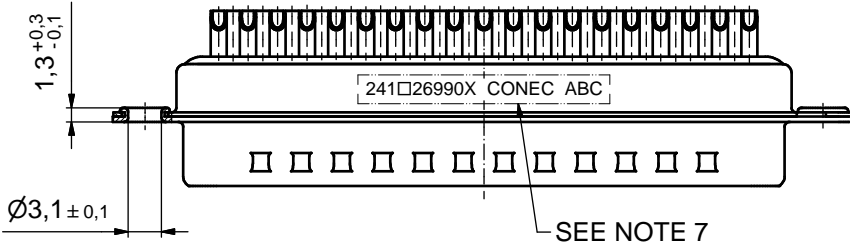
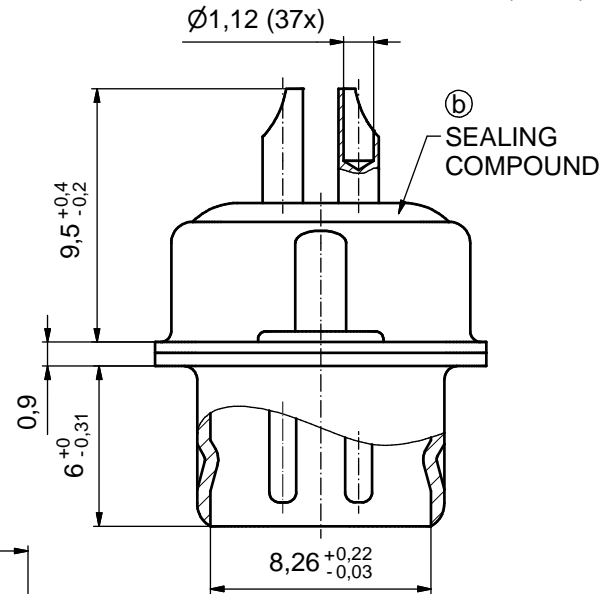
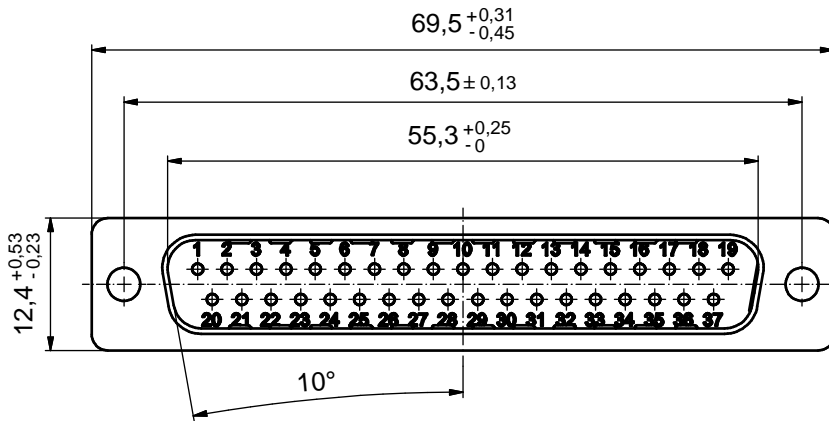


Solder Instruction

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. Apply some solder to the solder tip of the soldering iron.
5. Put tip to wire in solder cup
6. After 1 second bring in solder.
7. Heat for 3 seconds longer. Do not heat contact more than 6 seconds in total.
8. Remove soldering iron.
9. Wait until solder gets rigid again.
10. Do not solder adjacent contacts consecutively, alternate position within the connector to minimize heat build up.

(5:1)



(b) NOTES:

1. METALSHELLS: STEEL; min. 315µm TIN over 40-80µm NICKEL
2. INSULATOR: HIGH TEMPERATURE PLASTIC UL 94 V-0; BLACK
3. CONTACTS: COPPER ALLOY; PLATING (SEE PART-NO.):
 PLEASE ADD A for GOLD FLASH over NICKEL (PREFERRED TYPE)
 PLEASE ADD B for 20µm HARD GOLD over min. 50µm NICKEL
 PLEASE ADD C for 30µm HARD GOLD over min. 50µm NICKEL
 SOLDER CUP ACCEPTS CABLE AWG 20
4. SEALING COMPOUND: PUR; BLUE
5. CAPACITANCE: 1300pF ± 20%
6. DIELECTRIC WITH STANDING VOLTAGE: 424 VDC
7. CONNECTOR IS PART MARKED: [241□26990X CONEC ABC] (see note 3)

RoHS compliant

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					material: SEE NOTES	
	drawn	21.06.16	Lehmenkühler		title: D-SUB FILTER MALE 37pos. SOLDER CUP	
	appd.	21.06.16	Schmidt			
	norm	DIN 41652				
	d-old	24K1A761				
	3 x b	Ä6200	21.06.2016	Lehm.	dwg no:	DIN-A3
a	Original			(b) 24K1A1708	sh: 1	
rev.	description	date	name	part no: 241□26990X (see note 3)		

