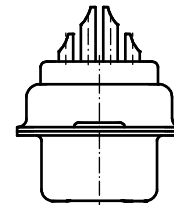
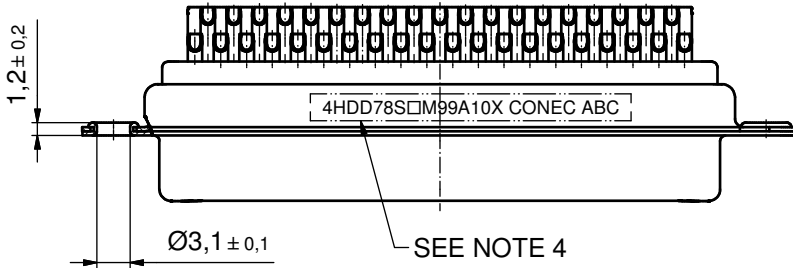
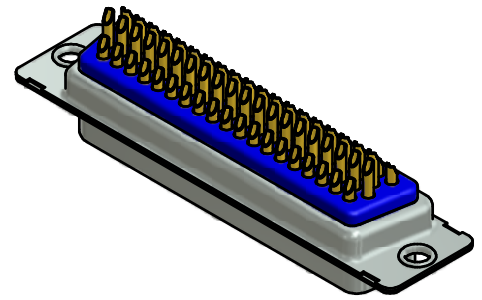
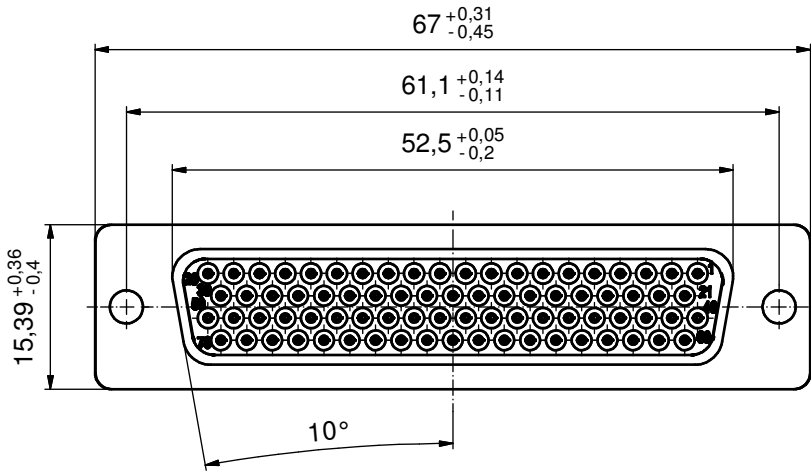
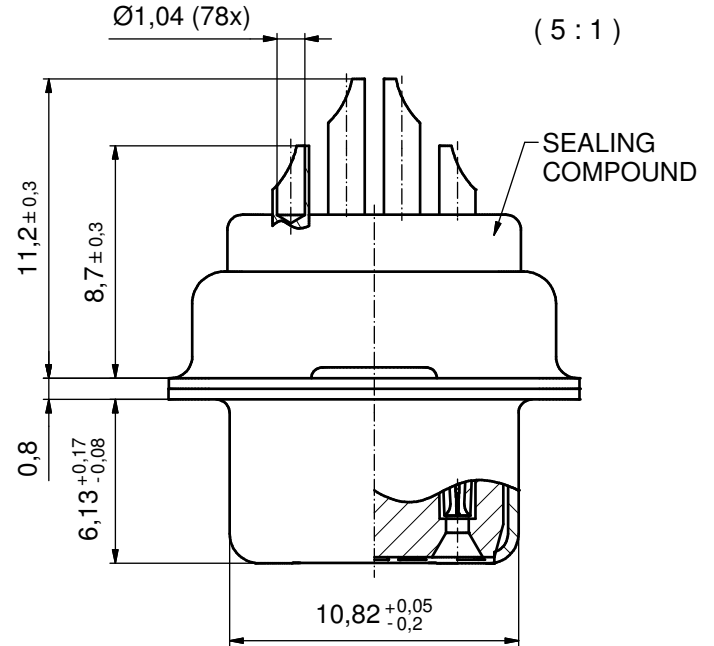


# Solder Instruction

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. METAL SHELLS: 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

THIS DRAWING MAY NOT BE COPIED OR REPRODUCED IN ANY WAY, AND MAY NOT BE PASSED ON TO A THIRD PARTY WITHOUT WRITTEN PERMISSION. OWNERSHIP AND COPYRIGHT OF CONEC GmbH  DO NOT ALTER CAD DRAWING BY HAND	tolerance		dim. in mm		scale:	2:1 (5:1)	
					material:	SEE NOTES	
	drawn	19.08.13	Henneboel		title: <b>D-SUB HD FEMALE</b> 78pos. SOLDER CUP for installation into water resistant hood		
	appd.	19.08.13	Fischer				
	norm			dwg no:			DIN-A3
	d-old			sh: 1			
a	Original			15K1A1359			
rev.	description	date	name	part no: 4HDD78S□M99A10X (see note 3)			

