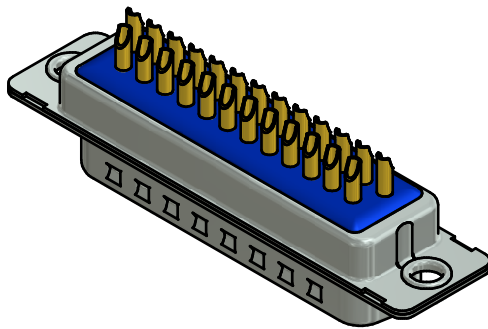
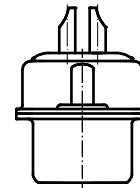
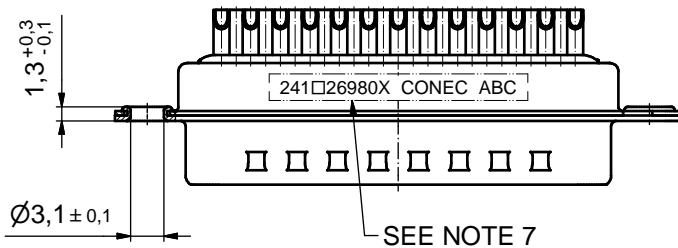
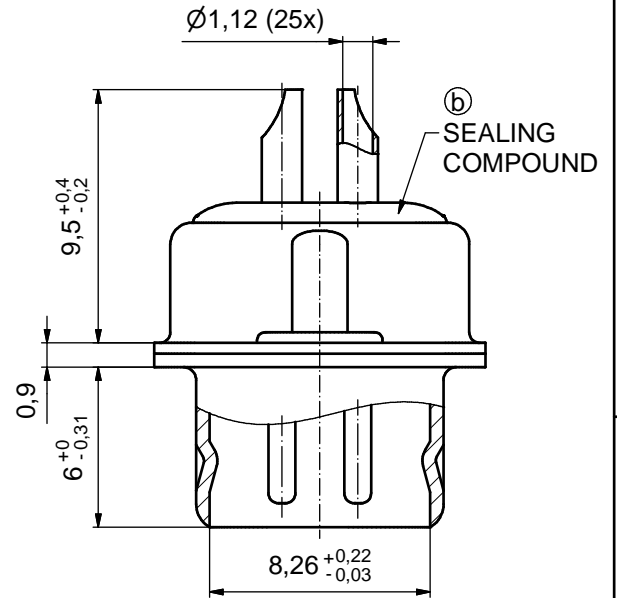
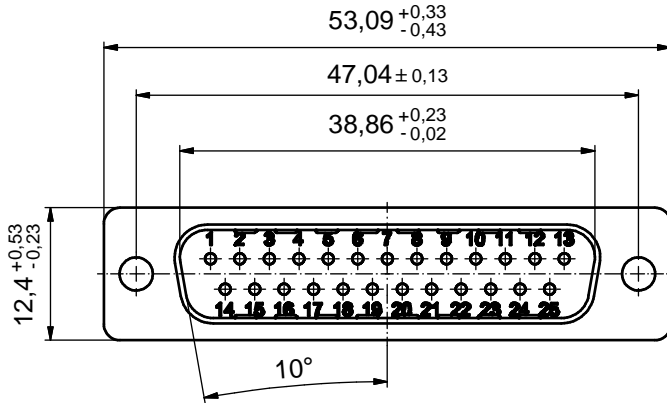


**Solder Instruction**

( 5 : 1 )

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.



(b)

**NOTES:**

1. METALSHIELDS: STEEL; min. 315µin TIN over 40-80µin 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 20µin HARD GOLD over min. 50µin NICKEL  
 PLEASE ADD C for 30µin HARD GOLD over min. 50µin 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□26980X CONEC ABC (see note 3)

RoHS compliant

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				date			material: SEE NOTES	
				name		title: D-SUB FILTER MALE		
				drawn 21.06.16 Lehmenkühler		25pos. SOLDER CUP		
appd. 21.06.16 Schmidt		norm: DIN 41652						
d-old: 24K1A761		dwg no: (b) 24K1A1707						
3 x b Ä6200 21.06.2016 Lehm.		DIN-A3						
a Original		sh: 1						
rev. description date name		part no: 241□26980X (see note 3)						

