

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 4 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.

Technical drawing of a mechanical part, likely a bracket or support, showing dimensions and tolerances. The part is symmetrical about a vertical centerline (indicated by a dashed line).

Key dimensions and tolerances:

- Overall width: $42,5 \pm 0,1$
- Overall height: $11,4 \pm 0,1$
- Distance from left edge to centerline: $47,04 \pm 0,1$
- Distance from right edge to centerline: $47,04 \pm 0,1$
- Radius of the rounded end: $R3,4 \pm 0,13$
- Angle of the sloped side: $10^\circ \pm 1^\circ$
- Distance from left edge to the start of the rounded end: $\varnothing 3,1 \pm 0,05 (2x)$
- Distance from right edge to the start of the rounded end: $\varnothing 3,1 \pm 0,05 (2x)$
- Distance from left edge to the start of the rounded end (dimension line): $0,26 A$
- Distance from right edge to the start of the rounded end (dimension line): $0,26 B$

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				tolerance		 dim. in mm		scale: 4:1	
				date		name		material: SEE SHEET 1	
				drawn 21.09.2015		Heinrich		title: RECOMMENDED PANEL CUT-OUT D-SUB FEMALE HD 44pos. SOLDER CUP with open 4-40 UNC thread	
				appd. 22.09.2015		Fischer			
				norm					
				d-old					
								dwg no: 15K1A1673	
a	Original								
rev.	description	date	name					DIN-A3 sh: 2	
								part no: SEE SHEET 1	

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