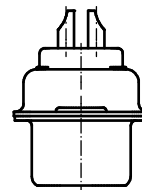
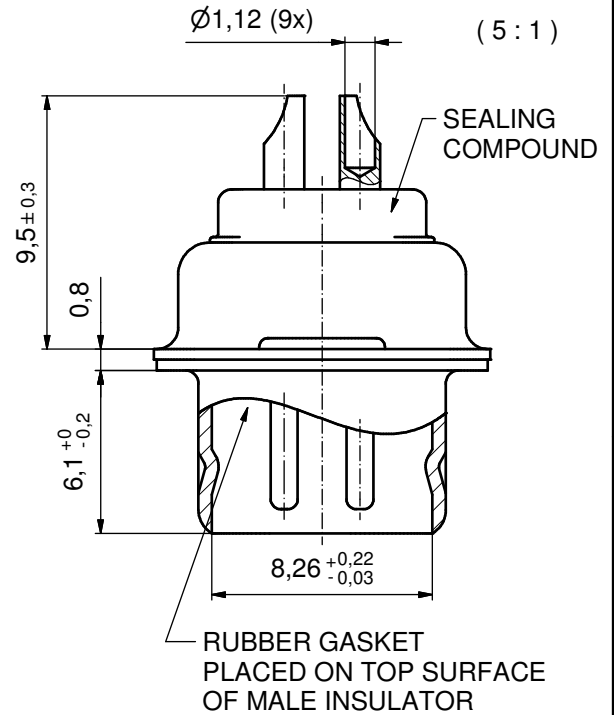
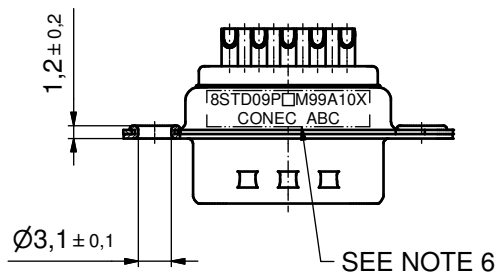
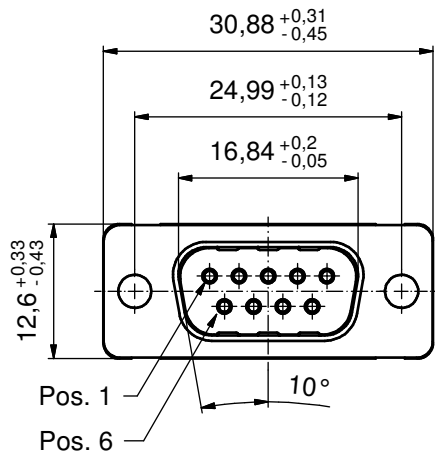


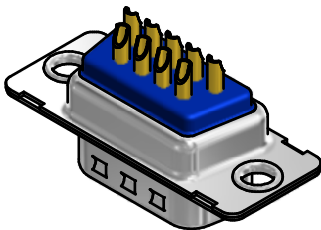
Solder Instruction (b)

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.



(b) NOTES:

1. METAL SHELLS: STAINLESS STEEL
2. INSULATORS: PBT GF UL 94 V-0; BLACK
3. SIGNAL CONTACTS: COPPER ALLOY; PLATING (SEE PART NO.)
 - PLEASE ADD J for 50µin HARD GOLD over min. 50µin NICKEL
 - 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)SOLDER CUP ACCEPTS CABLE AWG 20
4. SEALING COMPOUND: PUR; BLUE
5. RUBBER-GASKET: TPE; BLACK
6. CONNECTOR IS PART MARKED: 18STD09P□M99A10X CONEC ABC (see note 3)



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				tolerance		 dim. in mm	scale: 2:1 (5:1)					
							material: SEE NOTES					
								date	name	title: D-SUB MALE 9pos. SOLDER CUP for installation into water resistant hood		
								drawn 02.06.10	Lehmenkühler			
								appd. 02.06.10	Fischer			
								norm				
				d-old	18K1A655/18K2A655	dwg no:						
DO NOT ALTER CAD DRAWING BY HAND				3 x b	Ä4438	23.08.2012	K.H.	15K1A650 (b)		DIN- A3		
				a	Original					sh: 1		
				rev.	description	date	name			part no: 8STD09P□M99A10X		(see note 3)

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