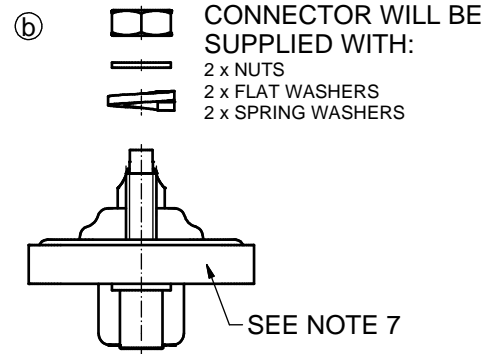
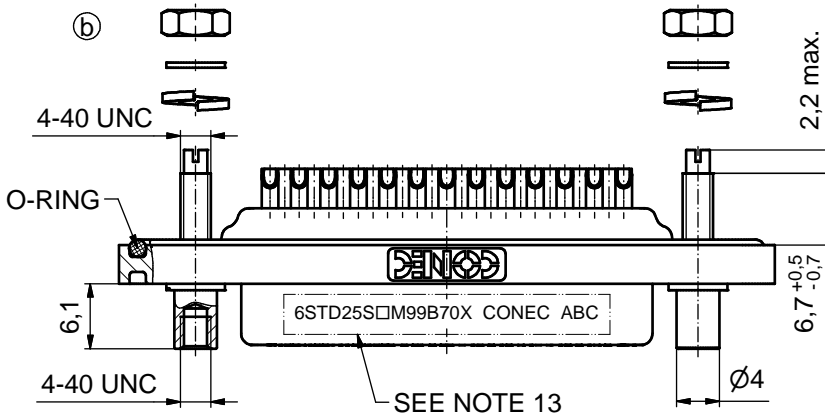
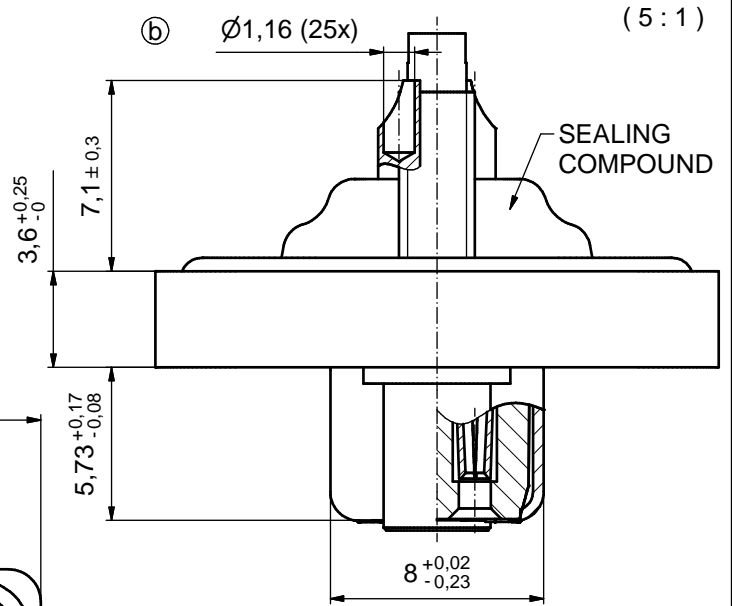
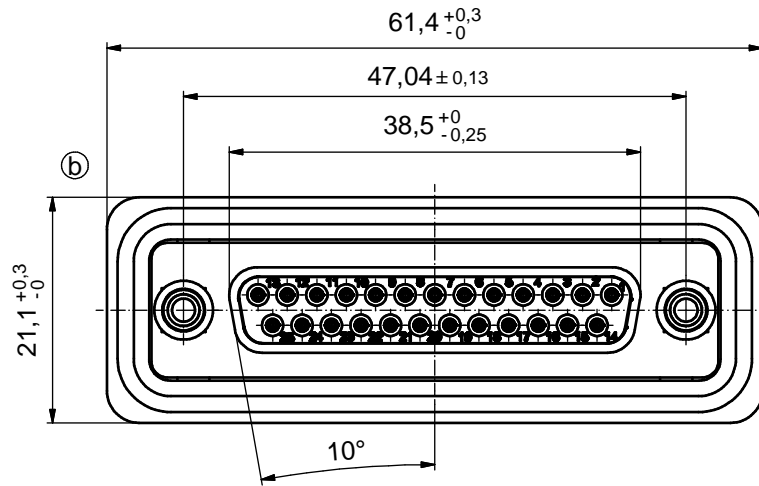
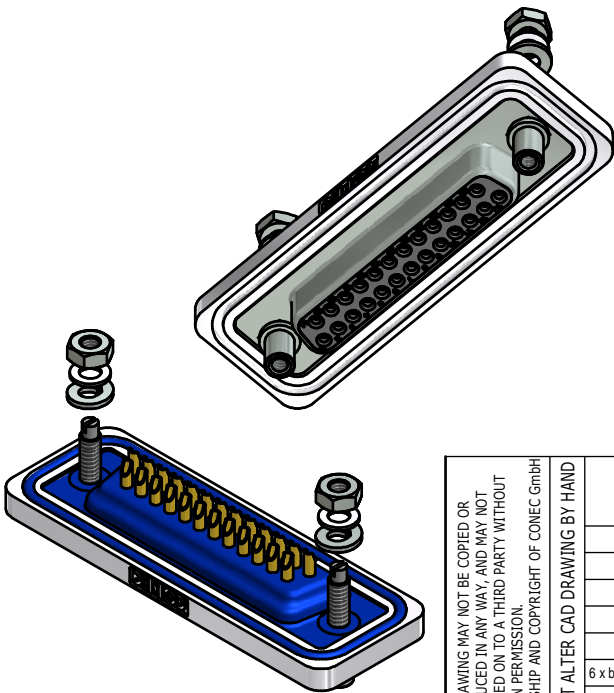


AT ALL TIMES WATER RESISTANT CONNECTORS NOT IN USE SHOULD BE COVERED WITH A CONEC WATER RESISTANT CAP OR WATER TIGHT HOOD.



NOTES:

1. RECOMMENDED SOLDER INSTRUCTION SEE SHEET 2
2. METAL SHELLS: COPPER ALLOY; min. 315µm TIN over 40-80µm NICKEL
3. INSULATORS: PBT GF UL 94 V-0; BLACK
4. SIGNAL CONTACTS: COPPER ALLOY; PLATING (SEE PART NO.):
 - PLEASE ADD C for 30µm HARD GOLD over min. 50µm NICKEL
 - PLEASE ADD B for 20µm HARD GOLD over min. 50µm NICKEL
 - PLEASE ADD A for GOLD FLASH over NICKEL (PREFERRED TYPE)
- SOLDER CUP ACCEPTS CABLE AWG 20
5. THREADED LOCKS: COPPER ALLOY; min. 200µm TIN over 80µm NICKEL
6. COLLARS: COPPER ALLOY, min. 200µm TIN over 80µm NICKEL
7. FRAME: ZINC DIE CAST; NICKEL PLATED
8. STUD BOLTS / 4-40 UNC: STEEL; TIN PLATED
9. O-RING: SILICON; BLUE
10. SEALING COMPOUND: PUR; BLUE
11. RECOMMENDED PANEL CUT-OUT ON SHEET 2
12. RECOMMENDED TORQUE FOR STUD BOLT 35Ncm (3,1 in.LB) / max. 40Ncm (3,5 in.LB)
13. CONNECTOR IS PART MARKED: [6STD25S□M99B70X CONEC ABC] (see note 4)



Directive 2002/95/EC RoHS compliant

tolerance				dim. in mm		scale: 2:1 (5:1)	
				material: SEE NOTES		title:	
date				name		D-SUB FEMALE 25pos. SOLDER CUP with threaded lock and 4-40 UNC stud bolt	
drawn 09.07.13				Lehmenkühler			
appd. 11.07.13				Fischer			
norm				d-old		dwg no:	
				18K1A365		15K1A1338	
6 x b				Ä4815		DIN-A3	
a				Original		(b) sh: 1	
rev. description				date		part no: 6STD25S□M99B70X (see note 4)	

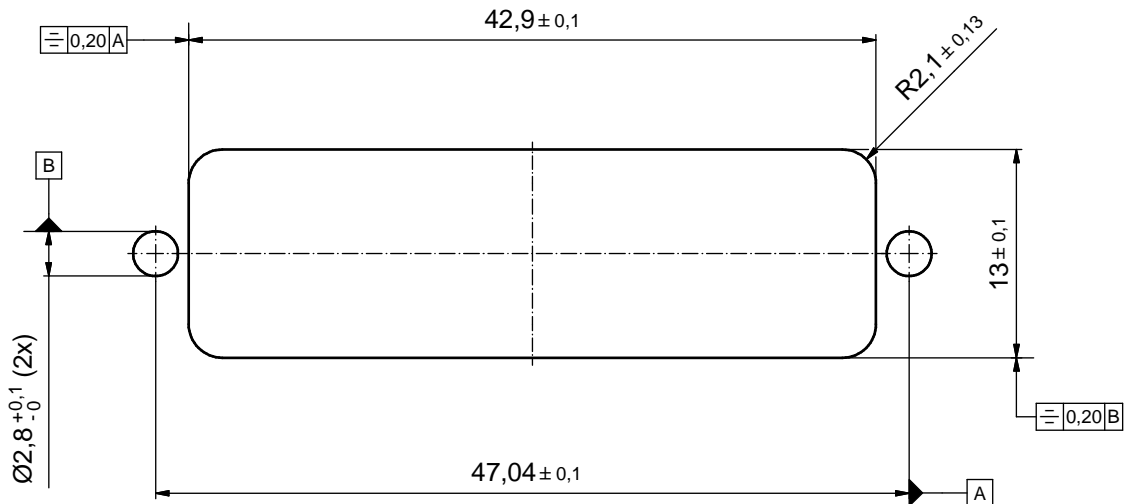


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Solder Instruction

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.

RECOMMENDED PANEL CUT-OUT



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				date	name	material: SEE SHEET 1
				drawn	09.07.13	Lehmenkühler
				appd.	11.07.13	Fischer
				norm		
				d-old		
				rev.	a	Original
rev.	description	date	name	CONEC [®]		title: RECOMMENDED PANEL CUT-OUT D-SUB FEMALE 25pos. SOLDER CUP with threaded lock and 4-40 UNC stud bolt
			dwg no: 15K1A1338			DIN-A3 sh: 2
			part no:		SEE SHEET 1	