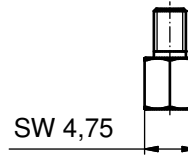
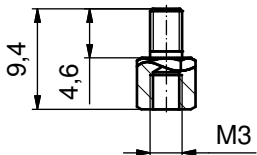
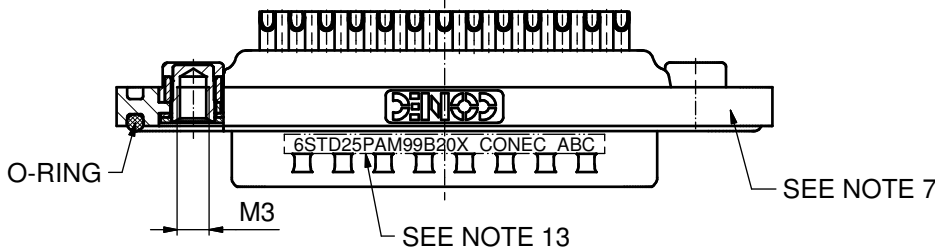
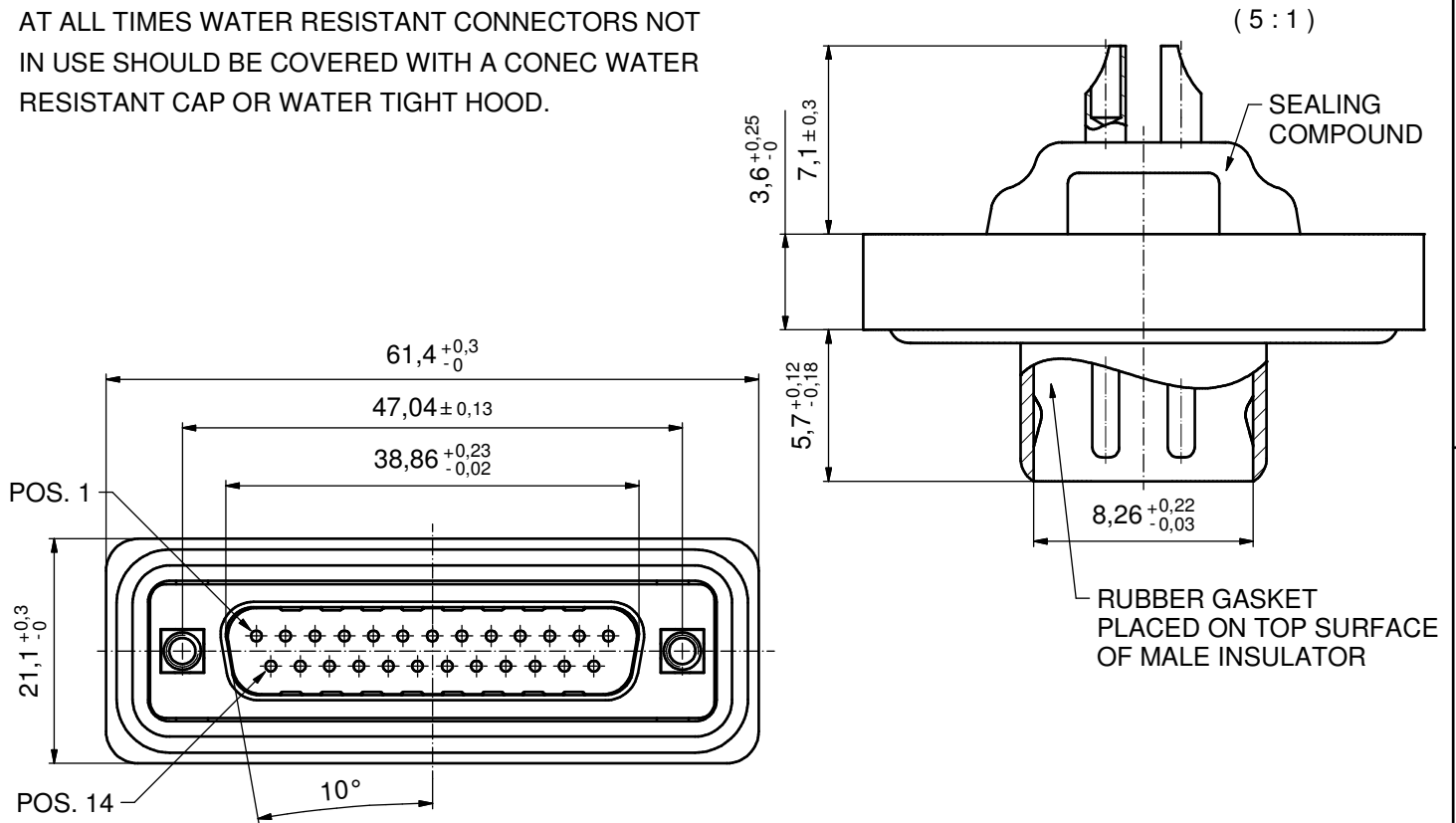
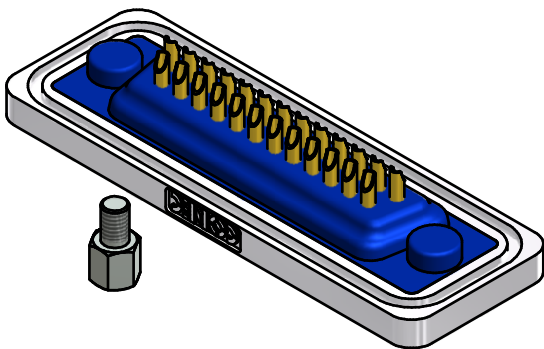


AT ALL TIMES WATER RESISTANT CONNECTORS NOT IN USE SHOULD BE COVERED WITH A CONEC WATER RESISTANT CAP OR WATER TIGHT HOOD.



NOTES:

1. RECOMMENDED SOLDER INSTRUCTION SEE SHEET 2
2. METALSHELLS: COPPER ALLOY; min. $315\mu\text{m}$ TIN over $40\text{-}80\mu\text{m}$ NICKEL
3. INSULATORS: PBT GF UL 94 V-0, BLACK
4. CONTACTS: COPPER ALLOY
PLATING: GOLD FLASH over NICKEL
SOLDER CUP ACCEPTS CABLE AWG 20
5. THREADED INSERTS: COPPER ALLOY; min. $200\mu\text{m}$ TIN over $80\mu\text{m}$ NICKEL
6. COLLARS: COPPER ALLOY; min. $200\mu\text{m}$ TIN over $80\mu\text{m}$ NICKEL
7. FRAME: ZINC DIE CAST; NICKEL PLATED
8. O-RING: SILICON; BLUE
9. RUBBER GASKET: TPE
10. HEXLOCKING SCREWS: STAINLESS STEEL
11. RECOMMENDED PANEL CUT-OUT ON SHEET 2
12. RECOMMENDED TORQUE FOR MOUNTING SCREW 35Ncm (3.1 in.LB) / max. 40Ncm (3.5 in.LB)
13. CONNECTOR IS PART MARKED: **6STD25PAM99B20X CONEC ABC**



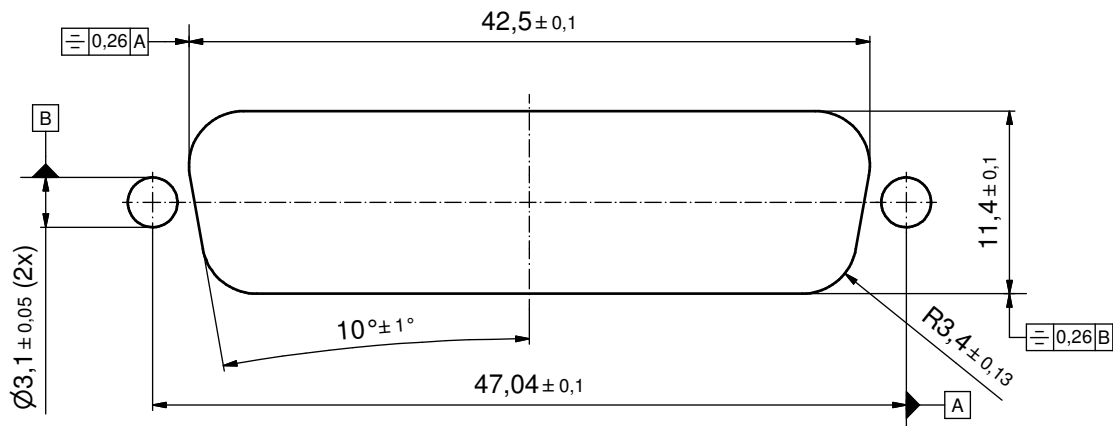
Directive 2002/95/EC RoHS compliant

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	
				title:		D-SUB MALE 25pos. SOLDER PIN STRAIGHT with threaded insert and hexlocking screw
				drawn 10.02.11 Henneboel appd. 10.02.11 Fischer		
				norm		
			d-old		dwg no:	
			a Origin		15K1A791	DIN-A3
					sh: 1	
rev. description date name			part no: 6STD25PAM99B20X			

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	10.02.11	Henneboel	title: P.C.B HOLE DRILLINGS PANEL CUT-OUT D-SUB Male 44pos. HD Solder pin straight
				appd.	10.02.11	Fischer	
				norm			
			d-old			dwg no:	
a	Origin		CONEC ®			15K1A791	DIN-A3
rev.	description	date				name	part no: SEE SHEET 1