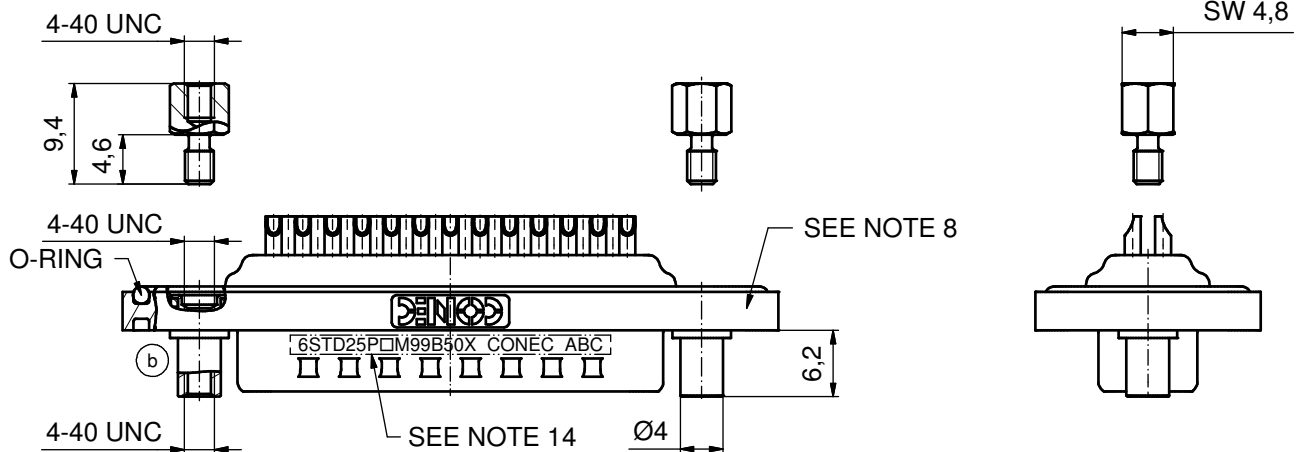
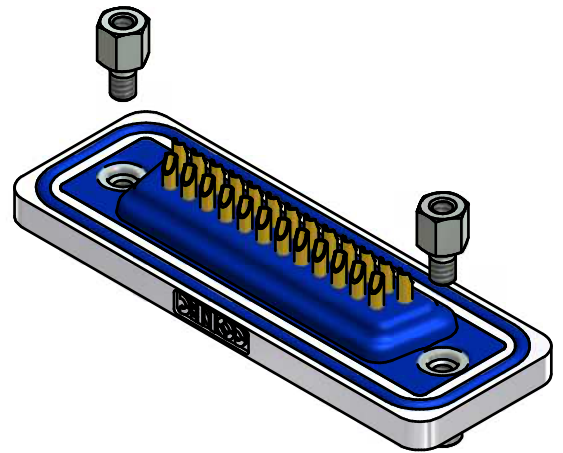
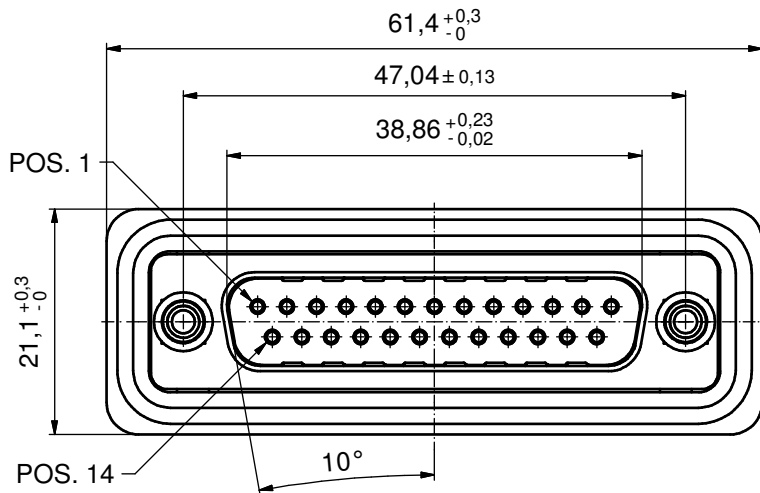
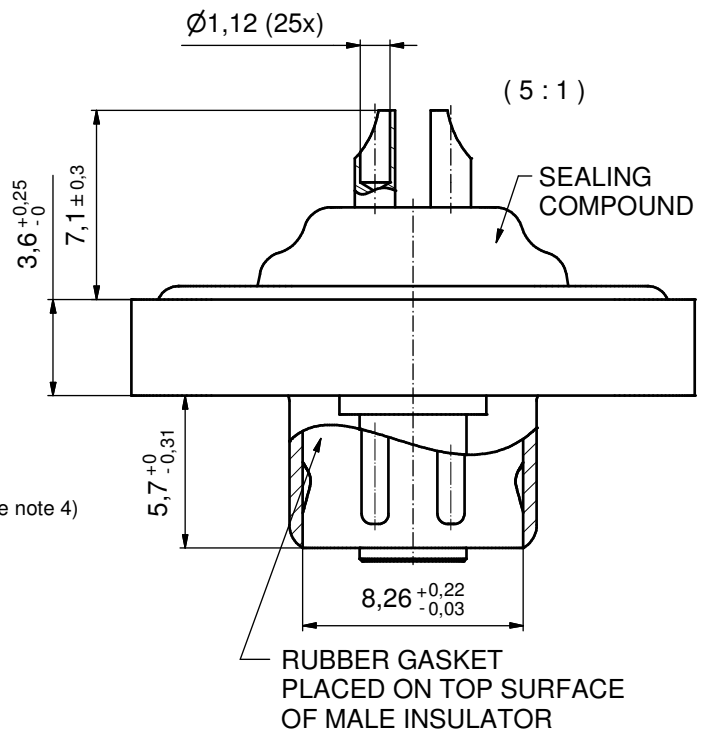


NOTES: (b)

1. RECOMMENDED SOLDER INSTRUCTION ON SHEET 2
2. METALSHELLS: COPPER ALLOY; min. 315µin TIN over 40-80µin NICKEL
3. INSULATORS: PBT GF UL 94 V-0; BLACK
4. 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
5. THREADED LOCKS: COPPER ALLOY; min. 200µin TIN over 80µin NICKEL
6. COLLARS: COPPER ALLOY; min. 200µin TIN over 80µin NICKEL
7. HEXLOCKING SCREWS: STAINLESS STEEL
8. FRAME: ZINC DIE CAST; NICKEL PLATED
9. O-RING: SILICONE; BLUE
10. RUBBER GASKET: TPE; BLACK
11. SEALING COMPOUND: PUR; BLUE
12. RECOMMENDED PANEL CUT-OUT ON SHEET 2
13. RECOMMENDED TORQUE FOR MOUNTING SCREW 35Ncm (3.1 in.LB) / max. 40Ncm (3.5 in.LB)
14. CONNECTOR IS PART MARKED: **6STD25P□M99B50X CONEC ABC** (see note 4)

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



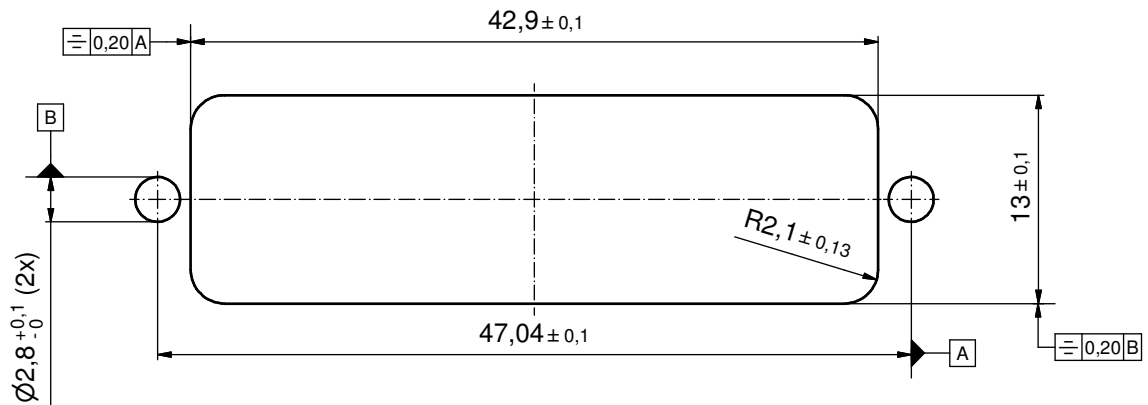
THIS DRAWING MAY NOT BE COPIED OR REPRODUCED IN ANY WAY, AND MAY NOT BE PASSED ON TO A THIRD PARTY WITHOUT WRITTEN PERMISSION. OWNERSHIP AND COPYRIGHT OF CONEC GmbH DO NOT ALTER CAD DRAWING BY HAND	tolerance		dim. in mm		scale:	2:1 (5:1)	
					material:	SEE NOTES	
	date	name		title:			
	drawn	13.02.14	Henneboel		D-SUB MALE 25pos. SOLDER CUP with threaded lock and hexlocking screw		
	appd.	20.02.14	Lehmenkühler				
norm			d-old	18K1A437/18K2A437	dwg no:		
3 x b	Ä5099	13.02.2014	K.H.	15K1A1449 (b)		DIN-A3	
a	Original					sh: 1/2	
rev.	description	date	name	part no: <b>6STD25P□M99B50X</b> (see note 4)			

Directive 2002/95/EC RoHS compliant

## 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	13.02.14 Henneboel	title: RECOMMENDED PANEL CUT-OUT D-SUB 25pos. Male SOLDER CUP with threaded lock and hexlocking screw
				appd.	20.02.14 Lehmenkühler	
				norm		
				d-old		dwg no:
	a	Original		<b>CONEC</b> <sup>®</sup>		15K1A1449
rev.	description	date	name			part no: SEE SHEET 1