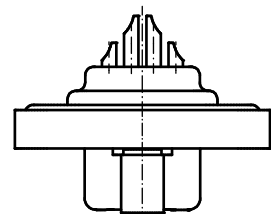
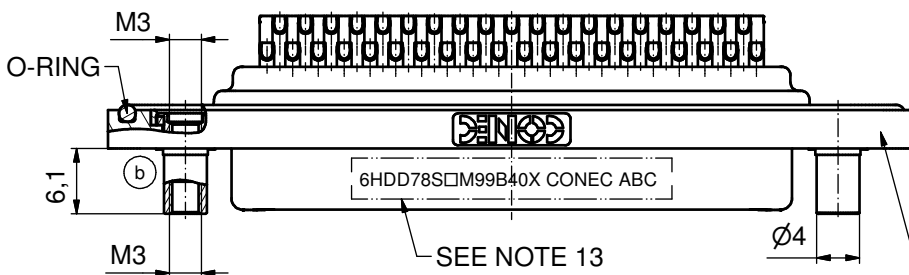
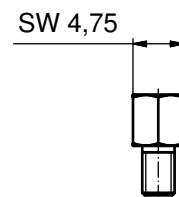
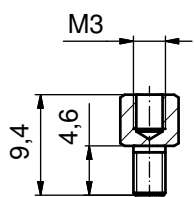
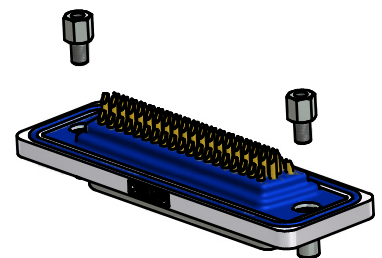
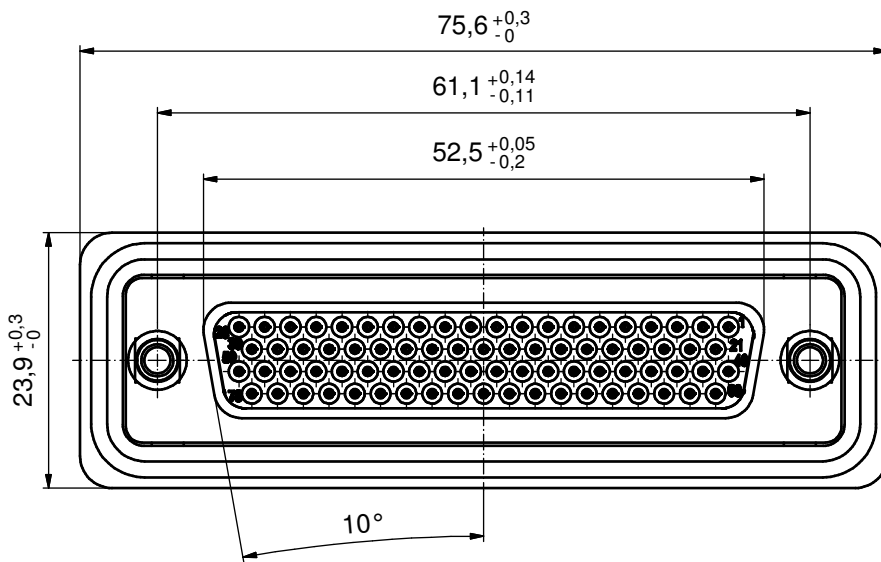
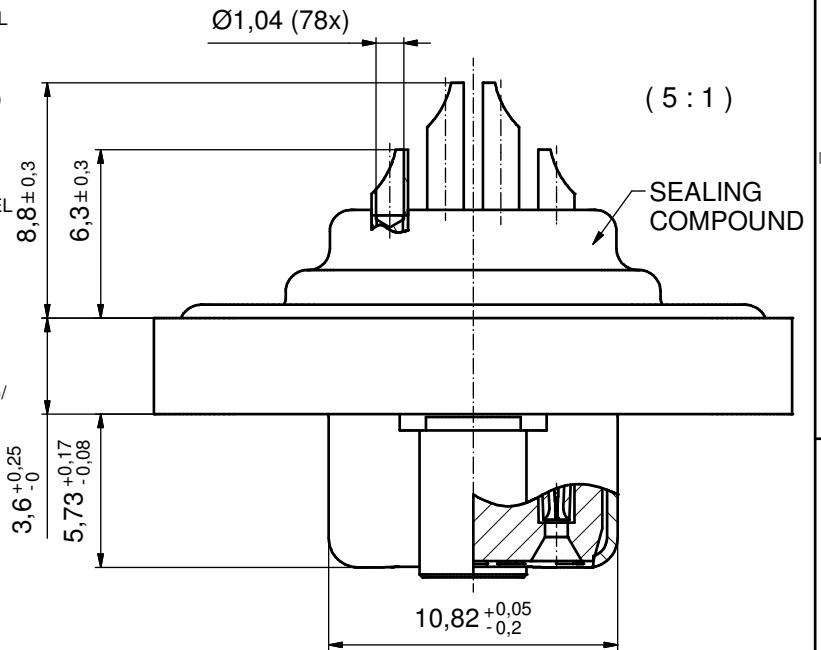


**NOTES:**

1. RECOMMENDED SOLDER INSTRUCTION SEE SHEET 2
2. METALSHELLS: COPPER ALLOY; min. 320µin 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: SILICON; BLUE
10. SEALING COMPOUND: PUR; BLUE
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: **6HDD78S□M99B40X CONEC ABC**

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



RoHS compliant

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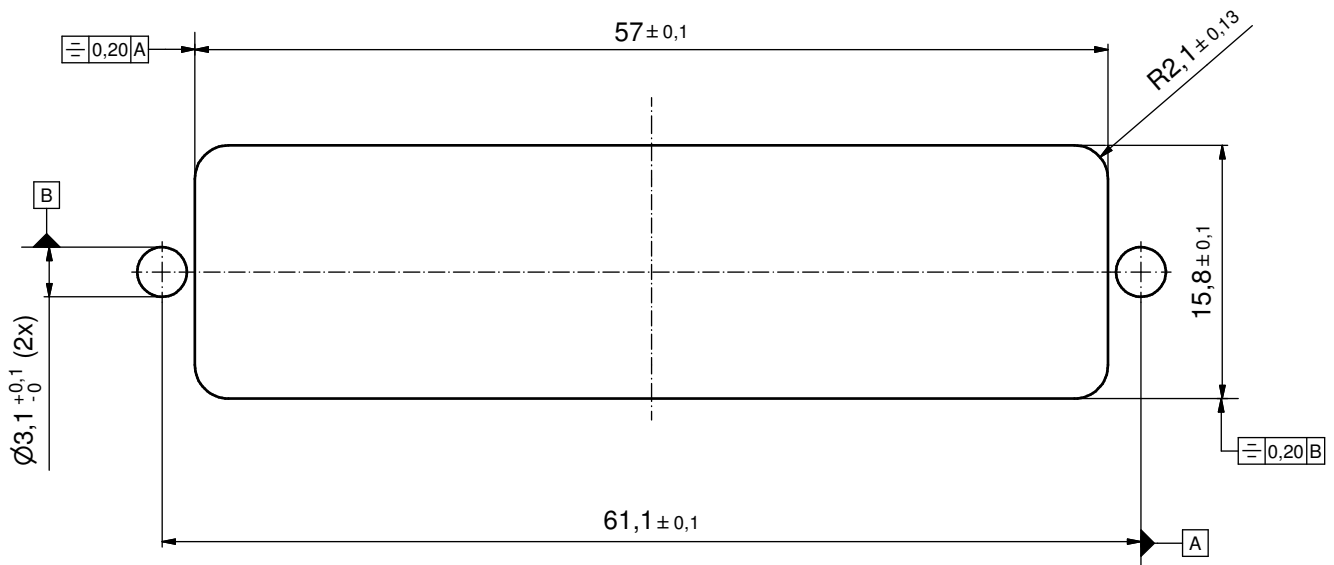
tolerance				dim. in mm	
		date	name	drawn	08.02.13 Henneboel
				appd.	08.02.13 Koch
				norm	
				d-old	
1 x b	A5973	09.02.2016	K.H.		
a	Original				
rev.	description	date	name	<b>CONEC</b>	

scale:	2:1 (5:1)	
material:	SEE NOTES	
title:	D-SUB HD FEMALE 78pos. SOLDER CUP with threaded lock and hexlocking screw	
dwg no:	15K1A1269	DIN-A3
part no:	6HDD78S□M99B40X	sh: 1/2
part no: 6HDD78S□M99B40X (see note 4)		

# 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. 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.

## RECOMMENDED PANEL CUT-OUT



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				date	name	material: SEE SHEET 1
				drawn	08.02.13	Henneboel
				appd.	08.02.13	Koch
				norm		
				d-old		
				rev.	a Original	
rev.	description	date	name	<b>CONEC</b> <sup>®</sup>		title: <b>PANEL CUT-OUT</b> D-SUB HD FEMALE 78pos. SOLDER CUP with threaded lock and hexlocking screw
						dwg no: 15K1A1269
				part no: SEE SHEET 1		