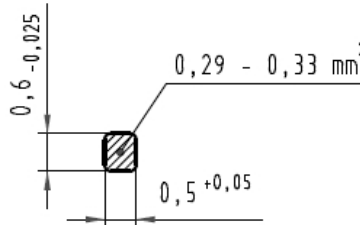
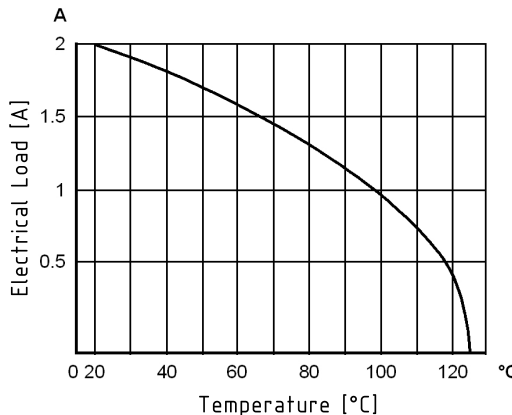


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 DIN signal male connector with special contacts RoHS compliant 				Soldering instructions The connectors should be protected when being soldered in a dip, flow or film soldering bath. Otherwise, they might become contaminated as a result of soldering operations or deformed as a result of overheating. (1) For prototypes and short runs protect the connectors with an industrial adhesive tape, e.g. Tesaband 4331 (www.tesa.de). Cover the underside of the connector moulding and the adjacent parts of the pcb as well as the open sides of the connector. This will prevent heat and gases of the soldering apparatus from damaging the connector. About 140 + 5 mm of the tape should suffice. (2) For large series a jig is recommended. Its protective cover with a fast action mechanical locking device shields the connectors from gas and heat generated by the soldering apparatus. As an additional protection a foil can be used for covering the parts that should not be soldered. (3) We recommend to align special contacts during soldering. A mated dummy connector of the counterpart can be used to align the contacts to avoid misalignment due to angular deviations.																																																											
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 All rights reserved Department EC PD - DE HARTING Electronics GmbH D-32339 Espelkamp  All Dimensions in mm Original Size DIN A3 Scale 1:1 Free size tol. Ref. Sub. DS 09031200202 / 500000076066 / 2014-09-10 Created by TADJE Inspected by ELLERMANN Standardisation HOFFMANN Date 2015-11-17 State Final Release Title DIN signal male connector with special contacts Doc-Key / ECM-Nr. 100580373/UGD/000/B 500000097390 Type DS Number 09031200202 Rev. B Page 1/1																																																															
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