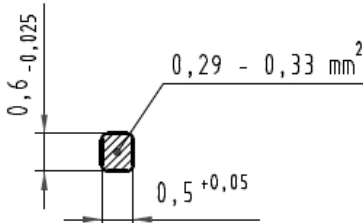
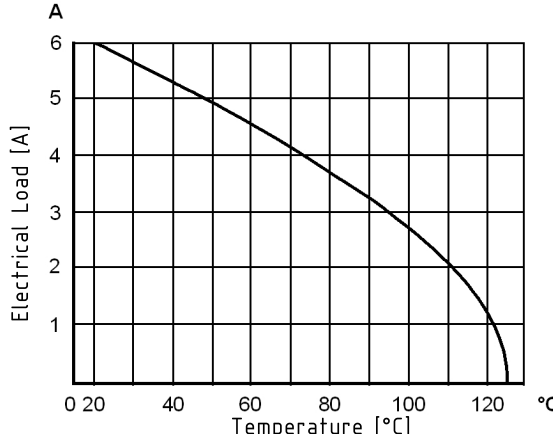


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HARTING DIN power male connector RoHS compliant				Soldering instructions The connectors should be protected when being soldered in a dip, flow or film soldering bath. Otherwise, they might become contaminated as a result of soldering operations or 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.																																																						
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HARTING All rights reserved Department EC PD - DE HARTING Electronics GmbH D-32339 Espelkamp				Scale 1:1 Free size tol.		Ref. Sub.		Created by STORCK		Inspected by LEHNERT		Standardisation HOFFMANN		Date 2017-02-03		State Final Release																																										
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Офис по работе с юридическими лицами:

105318, г.Москва, ул.Щербаковская д.3, офис 1107, 1118, ДЦ «Щербаковский»

Телефон: +7 495 668-12-70 (многоканальный)

Факс: +7 495 668-12-70 (доб.304)

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