

**Solder instruction for  
D – SUB Combination (Power + Signal – Contacts)**

V1.0

1. Cable should be prepared for soldering. The cable / wires must be pretinned.
2. Insert cable / wire into solder cup.
3. For Signal Contact:
  - 3.1 Operate the soldering iron at 350°C, 50 Watt max. and use a pencil tip.
  - 3.2 Put tip to wire in solder cup.
  - 3.3 After 1 second bring in solder.
  - 3.4 Heat for 3 seconds longer. Do not heat contact more than 4 seconds in total.
4. For Power Contact:
  - 4.1 Operate the soldering iron at 350°C, 100 Watt max. and use a pencil tip.
  - 4.2 Put tip to wire in solder cup.
  - 4.3 After 1 second bring in solder.
  - 4.4 Heat for 5 seconds longer. Do not heat contact more than 6 seconds in total.
5. Remove soldering iron.
6. Wait until solder gets rigid again.
7. Do not solder adjacent contacts consecutively, alternate position within the connector to minimize heat build up.