

May 13th 2015

INSTALLATION ADVISORY IA E-04.2

Re: MINI DIN CONNECTOR SOLDER CONNECTION

THE FOLLOWING STEPS DETAIL THE RECOMMENDED TECHNIQUE USED TO SOLDER THE CONNECTING CABLE TO THE MINI DIN 4 PIN CONNECTOR P/NE-04.10.6.

1. Strip 3/4" of the outer insulation and shield from the cable
2. Strip .100" of the insulation from the three individual wires.
3. Tin both the bare ends of the wires and the connector pins Fig 1.
4. Hold each wire next to its corresponding pin on the connector and touch the joint with the soldering iron tip until the solder flows together Fig 2.
5. When all wires are connected move the shrink tube over the joint and shrink with hot air Fig 3.
6. Assemble the connector as shown in the manual using a non corrosive sealant Loctite 5187 or equivalent.

NOTE: 22 or 24 gage M27500 shielded 3 conductor cable or M22759 individual wires should be used for the cable assembly if using individual wires the RS 232 data line from the GPS should be shielded and grounded at both ends.

NOTE: 15 watt or less soldering iron should be used .

