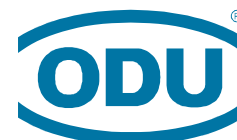
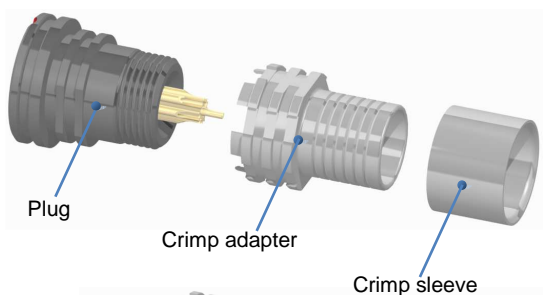


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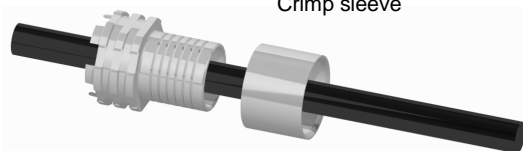
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## 1 Assembly sequence

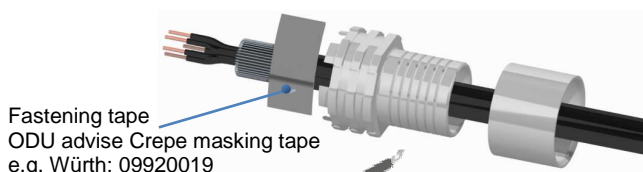


Size	max. cable Ø mm
00 (C)	5.0
0	7.0
1	8.5
1.5 (A)	10.5

Note: Cable with foil shield such as foiled twisted pair-cable (FTP) not suitable for shield termination mentioned below.



- Slide crimp sleeve and crimp adapter over the cable. The crimp sleeve is not needed if a metal band is used for fastening the shield to the crimp adapter.



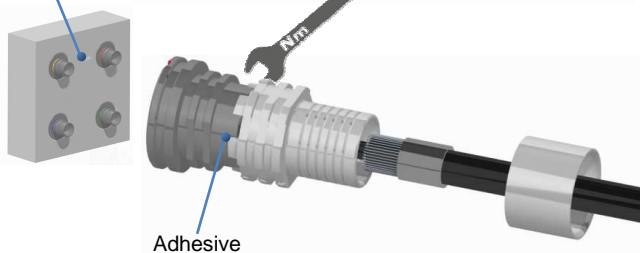
Fastening tape  
ODU advise Crepe masking tape  
e.g. Würth: 09920019

- Strip the cable and conductors<sup>1)</sup>. Fold back the shield and use fastening tape to fasten it temporarily to the cable jacket. Tin-plate this wires if needed.



ODU assembly tool  
(on request)

- Solder the wires, noting the placement of each wire according to your wiring chart. Clean the solder area with Isopropylalcohol and brush.



Adhesive

- Screw the crimp adapter on so that it is flush, observing torque values (see page 3). Secure the screw thread with adhesive<sup>2)</sup>.



- Remove the fastening tape and lay the shield braid on to the crimp adapter. Fasten the shield braid to the crimp adapter by means of crimping or by using a metal band. More information see page 4. Encapsulate the interior of the crimp adapter to secure the soldered points (ODU advise WEVO-2K-casting resin PU552FL).

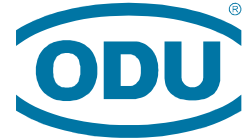


Sealing surface for cable overmolding

- Bend relief: This can be implemented by means of overmolding or by using a shrink tube. More information see page 5.

1) Additional information for cable preparation etc. please see page 2 and following  
2) Secure the crimp adapter on housing with adhesive (ODU advise Loctite 2701)

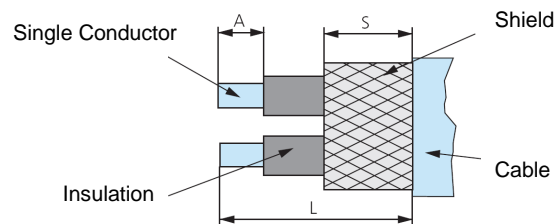
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## 2 Cable Preparation

The following table provides recommended guidelines for cable preparation. The according stripping measures have to be checked before assembly!



A = Stripping length single conductor  
L = Stripping length cable jacket  
S = Stripping length braided shield

Size	Contact $\varnothing$	L	A	S
00 (C)	0.3	8	1.5	8
	0.5	8	1.5	8
0	0.3	10	1.5	10
	0.7	10	1.5	10
1	0.3	12	1.5	12
1.5 (A)	0.3	14	1.5	14

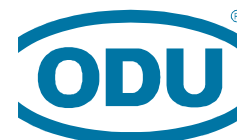
All dimensions in mm  
Tolerance: +10 %

Exceptions are noted on special instructions.

### Notes for data-rate-connectors

Before soldering, twist the strands back slightly in the original direction. If a shield is available for the separately pairs of wires (e.g. STP-Cables), wrap it around the pairs as far as possible.

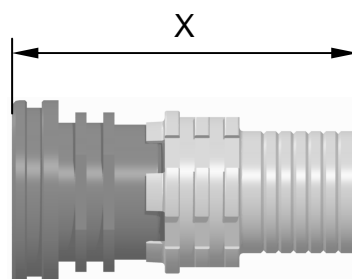
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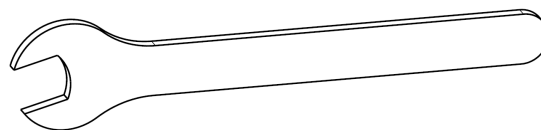
## 3 Assembly crimp adapter

Size	Torque Nm	Reference Dimension x mm
00 (C)	0.5	18.7
0	1.0	19.5
1	1.5	23.5
1.5 (A)	2.0	27.5



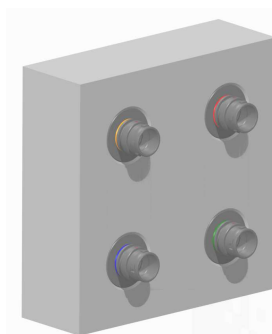
### 3.1 Spann wrench

Size	Part number	Wrench size
00 (C)	598.700.001.001.000	8
0	598.700.001.002.000	10
1	598.700.001.003.000	12
1.5 (A)	598.700.001.005.000	14



### 3.2 Assembly tool

Size	Part number
00 (C)	713.650.900.000.000
0	700.650.900.000.000
1	701.650.900.000.000
1.5 (A)	715.650.900.000.000



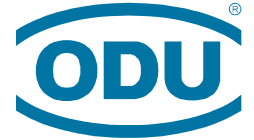
### 3.3 Adhesive

Secure the crimp adapter on housing with adhesive.  
(ODU reference: Loctite 2701)

### 3.4 Potting the interior of the crimp adapter

Encapsulate the interior of the crimp adapter to secure the soldered points with 2K casting resin PU. (ODU reference WEVO-2K-casting resin PU552FL)

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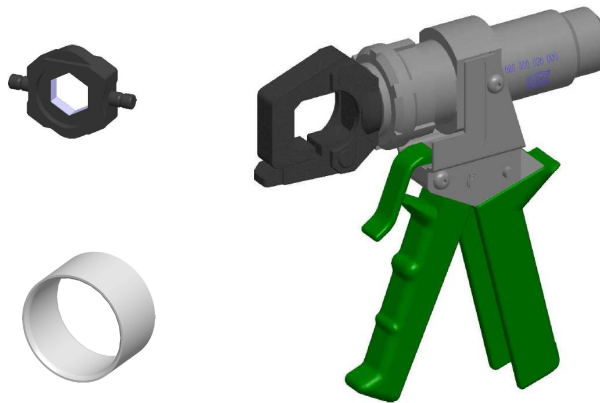
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## 4 Assembly crimp sleeve

### 4.1 Crimp tool ODU

Hand-crimptong	
Size	Part number
all	080.000.026.000.000

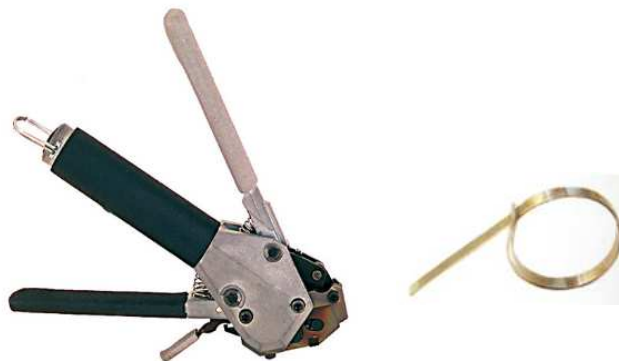
Crimp dies	
Size	Part number
00 (C)	080.000.026.713.001
0	080.000.026.701.000
1	080.000.026.715.000
1.5 (A)	080.000.026.702.000



### 4.2 Band-It Bands

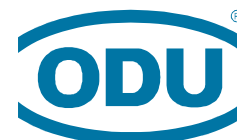
Hand-crimptong	
Size	Part number
all	080.000.058.000.000

Tie-Dex Micro Band	
Size	Part number
all	921.000.004.000.248



To connect the shielding with the crimp adapter, using a Tie-Dex Micro Band.

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## 5 Cable interface

ODU provides three different solutions for the cable interface. According to the requirements the customer can choose between overmolding, heat shrinkable molded parts and heat shrinkable tubing.

### 5.1 ODU overmolding (recommended series solution)

ODU provides complete solutions with straight overmoldings on request.



Example image: Break-Away Plug and In-Line Receptacle (size 00)

### 5.2 Heat shrinkable molded parts (samples, pre-series)

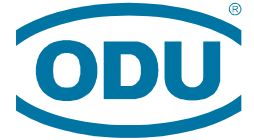
Size	Part number		Min. cable Ø in mm
	ODU	Supplier	
00 (C)	921.000.010.008.103	202K111-25 (Tyco)	3.0
0-1	921.000.010.008.084	401-52880 (Hellermann)	6.0
1.5 (A)	n. a.	n. a.	n. a.

To a better adhesion of the heatshrink boots on housing and cable, ODU recommends to work with an epoxy-adhesion (e. g. Hellermann V9500, Raychem S1125).



Example image: Break-Away Plug and In-Line Receptacle (size 1)

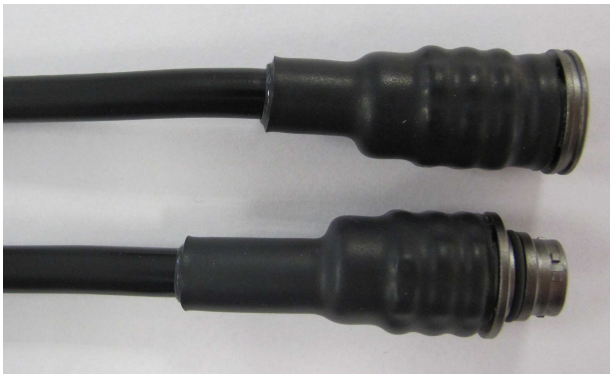
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## 5.3 Heat shrinkable tubing (samples, pre-series)

Size	Part Number		Min. cable $\varnothing$ in mm
	ODU	Tyco	
00 (C)	921.000.010.008.093	ATUM-12/3	3.0
0	921.000.010.008.093	ATUM-12/3	3.0
1	921.000.010.008.077	ATUM-16/4	4.0
1.5 (A)	921.000.010.008.077	ATUM-16/4	4.0



Example image: Break-Away Plug and In-Line Receptacle (size 1)