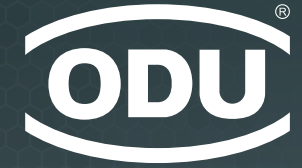


ODU AMC[®] NP

Assembly instructions for solder termination





Break-away plug
Style A1



In-line receptacle
Style K1

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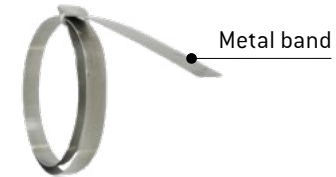
CABLE INTERFACE 08

ASSEMBLY STEP BY STEP

CONNECTORS WITH CRIMP TERMINATION

Plug with solder contacts

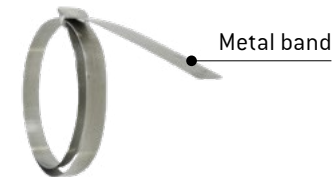
Connector



Order separately

In-line receptacle with solder contacts

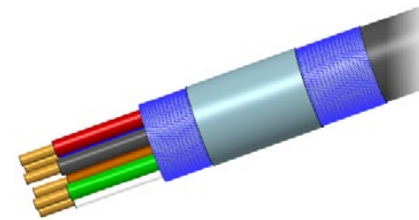
Connector



Order separately

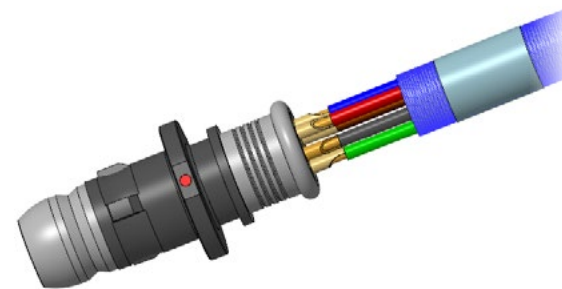
Step 1

- Strip cable and conductors ([see page 6](#)). Fold back the shield and use fastening tape to fasten it temporarily to the cable jacket.



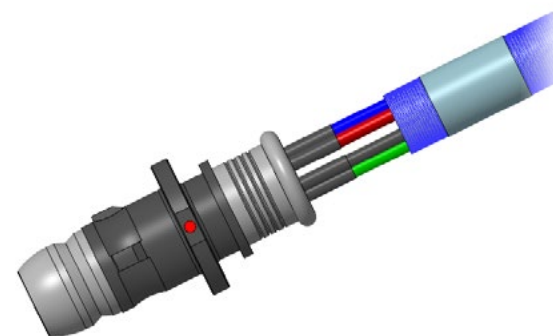
Step 2

- Solder wires to the contacts.



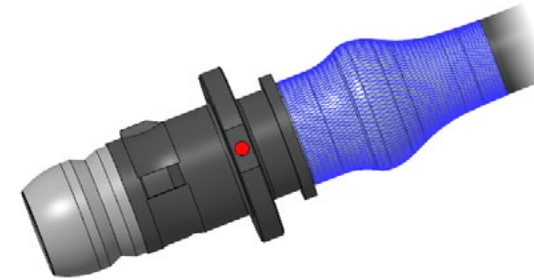
Step 3

- Isolate solder joints with shrink tube to prevent shorts between contacts and cable braid.



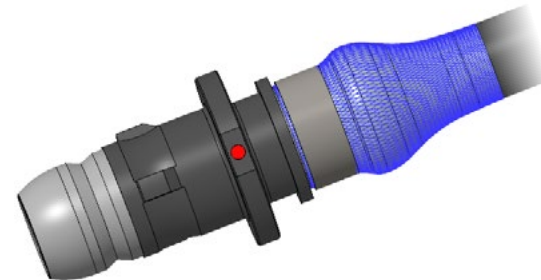
Step 4

- Remove the fastening tape and lay the shield braid on to the crimp area.



Step 5

- Fasten the shield braid to the crimp area by using a metal band. More information on [page 7](#)



Step 6

- Optional: For additional sealing or to prepare for overmolding, the termination area need to be potted. (ODU recommends Dow Corning SE 9187 or DP105 casting resin PU552FL, depending on the application).

Step 7

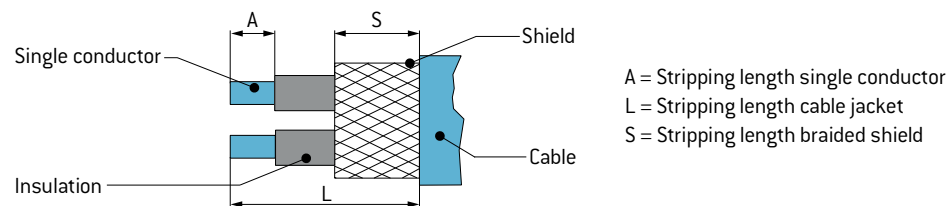
- Bend relief: This can be implemented by means of overmolding or by using shrink boot. More information on [page 8](#)



GENERAL NOTES

RECOMMENDED STRIPPING LENGTH

The following table provides recommended guidelines for cable preparation.



Shell size	Plug			Inline Receptacle		
	L	A	S	L	A	S
6	9	2.5	16	9	2.5	16

All dimensions in mm

Tolerance: +10 %

Exceptions are noted on special instructions.

Please note concerning data rate connectors:

Before crimping, please bend the strands back slightly in the original direction.

If a shield is available for the separate pairs of wires (e.g. STP-cables), warp it around the pairs as far as possible.

TOOLS

BANDING TOOL

Shell size	ODU number
all	080.000.058.000.000



MICRO BANDS

Shell size	ODU number	MIL type
6	921.000.004.000.248	M85049/128-7

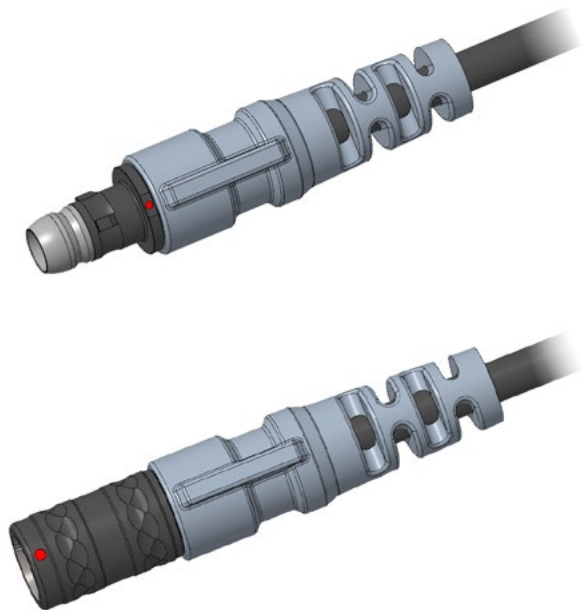


CABLE INTERFACE

ODU connectors are designed for overmolding. A heatshrink bend relief is also possible

ODU OVERMOLDING

We provide complete solution with straight and right-angled overmolding on request.



HEAT SHRINK SOLUTION



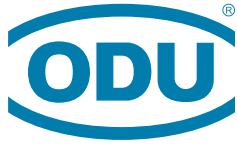
Heatshrink Straight Boot			
Shell size	ODU number	TE Connectivity	Cable Diameter
6	921.000.010.008.103	202K111-25-0	> 3.0 mm



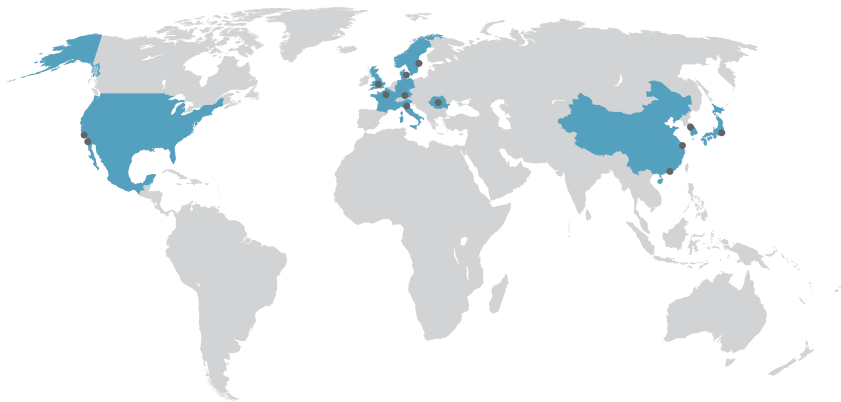
Heatshrink Right Angle Boot				
Shell size	ODU number	Hellermann Tyton	MIL Type	Cable Diameter
6	921.000.010.008.115	411-08480	1108-4	> 3.8 mm

To a better adhesion of the heatshrink boots on housing and cable, ODU recommend to work with an epoxyd-adhesion e.g. Hellermann V9500, TE Connectivity S1125.

[Take care of Hellermann / TE Connectivity work instruction]



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