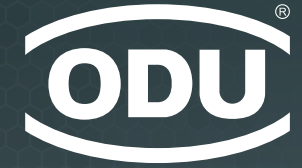
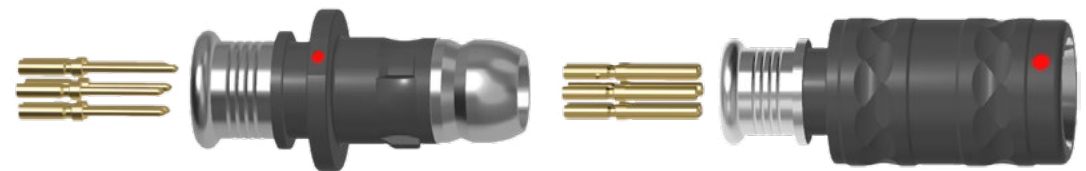


ODU AMC[®] NP

Assembly instructions for crimp termination





Break-away plug
Style A1

In-line receptacle
Style K1

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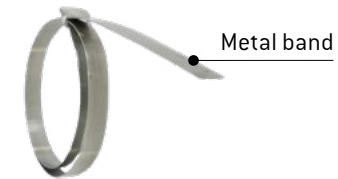
CABLE INTERFACE 08

ASSEMBLY STEP BY STEP

CONNECTORS WITH CRIMP TERMINATION

Plug with crimp contacts

Connector

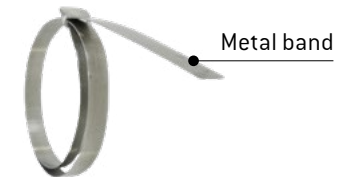


Metal band

Order separately

In-line receptacle with crimp contacts

Connector

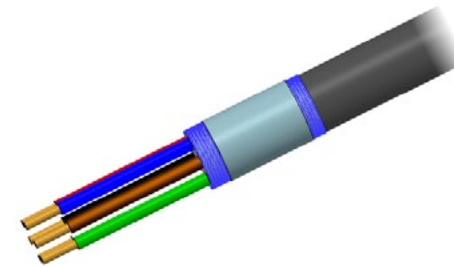


Metal band

Order separately

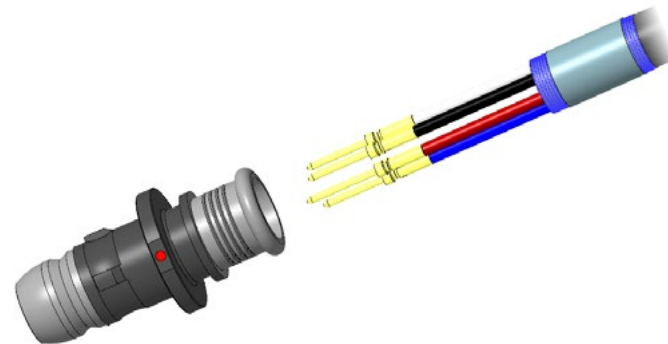
Step 1

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



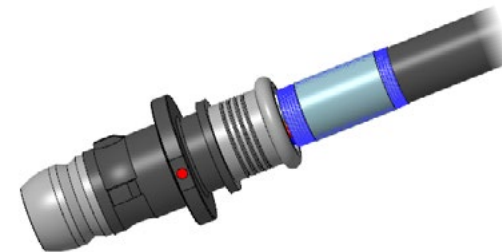
Step 2

- Crimp wires to the contacts.



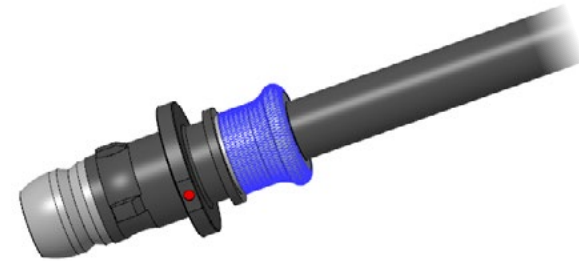
Step 3

- Insert the terminated contacts into the contact cavities according to the application-specific pinout instructions. Use insertion tool.



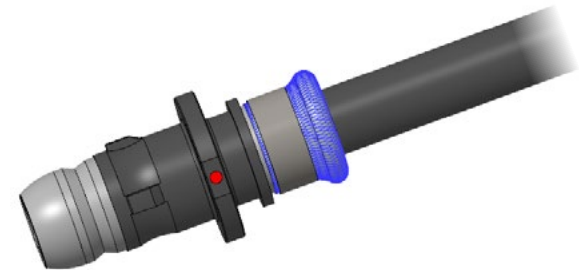
Step 4

- 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

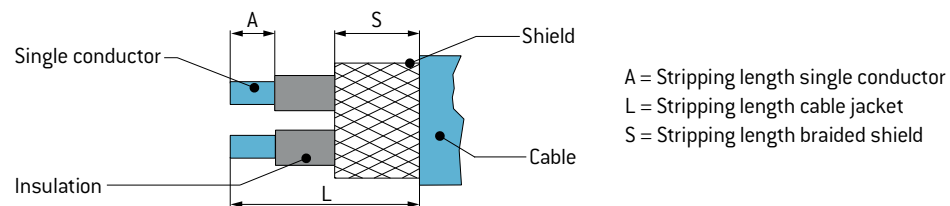
- Bend relief: This can be implemented by means of overmolding or by using shrink boot. More information on [page 8](#)



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



CRIMP TOOL

Size	ODU number	MIL type
All	080.000.072.000.000	M22520/2-01



MICRO BANDS

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



CRIMP TOOL

Size	ODU number	MIL type
All	080.000.075.000.000	M22520/2-01



INSERTION/REMOVAL TOOL

Shell size	ODU number	MIL type
23	085.613.100.100.000	M81969/1-05



POSITIONER

Size	ODU number	Wire gauge
All	080.000.075.101.000	22-28

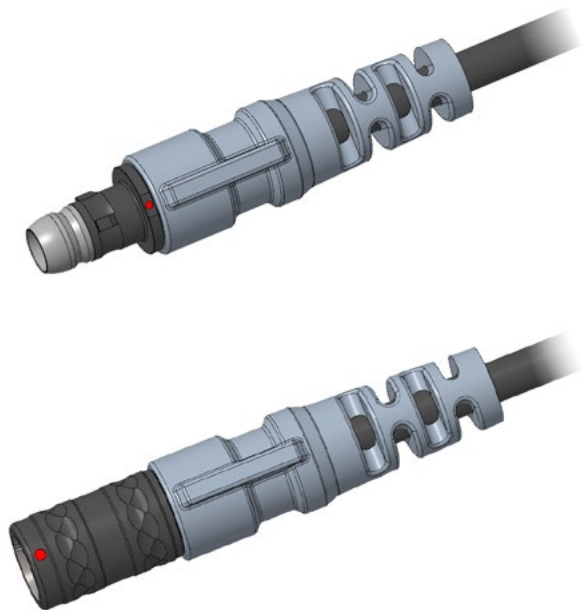


CABLE INTERFACE

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

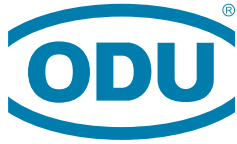


Heatshrink Straight Boot			
Shell size	ODU number	TE Connectivity	Cable Diameter
6	921.000.010.008.103	202K111-25-0	> 3 mm

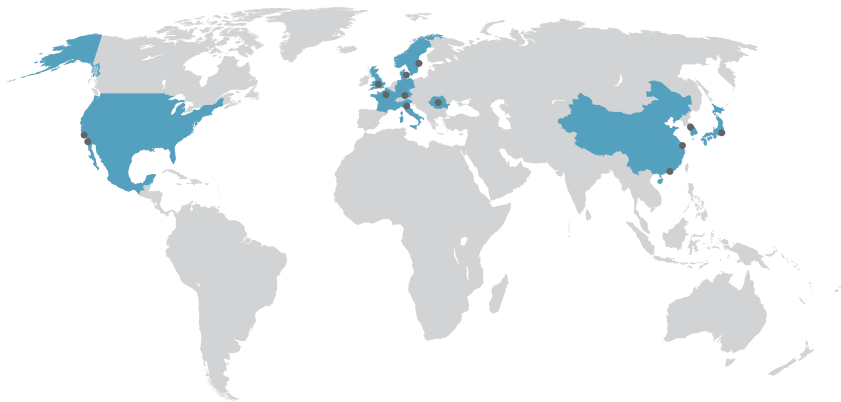


Heatshrink Right Angle Boot				
Shell size	ODU number	Hellermann Tyton	MIL Type	Cable Diameter
6	921.000.010.008.115	411-08480	1108-4	> 3.8 mm

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]



ODU GROUP WORLDWIDE



PRODUCTION AND LOGISTICS SITES

Germany	Otto Dunkel GmbH
China	ODU (Shanghai) Connectors Manufacturing Co., Ltd.
Mexico	ODU Mexico Manufacturing S. de R.L. de C.V.
Romania	ODU Romania Manufacturing SRL
USA	ODU North American Logistics Inc.

HEADQUARTERS

ODU GmbH & Co. KG

Pregelstraße 11, 84453 Mühldorf a. Inn, Germany

Phone: +49 8631 6156-0, Fax: +49 8631 6156-49, E-mail: sales@odu.de

SALES LOCATIONS

ODU-USA Inc.

Phone: +1 805 484-0540

E-mail: sales@odu-usa.com
odu-usa.com

ODU (Shanghai)

International Trading Co., Ltd.

Phone: +86 21 58347828-0

E-mail: sales@odu.com.cn
www.odu.com.cn

ODU (HK) Trading Co., Ltd.

Phone: +852 3963-9588

E-mail: sales@odu.hk
www.odu.hk

ODU Denmark ApS

Phone: +45 2233 5335

E-mail: sales@odu-denmark.dk
www.odu-denmark.dk

ODU-France SARL

Phone: +33 1 3935-4690

E-mail: sales@odu.fr
www.odu.fr

ODU Italia S.R.L.

Phone: +39 331 8708847

E-mail: sales@odu-italia.it
www.odu-italia.it

ODU Japan K.K.

Phone: +81 3 6441 3210

E-mail: sales@odu.co.jp
www.odu.co.jp

ODU Korea Inc.

Phone: +82 2 6964 7181

E-mail: sales@odu-korea.kr
www.odu-korea.kr

ODU Romania Manufacturing SRL

Phone: +40 269 704638

E-mail: sales@odu-romania.ro
www.odu-romania.ro

ODU Scandinavia AB

Phone: +46 176 18262

E-mail: sales@odu.se
www.odu.se

ODU-UK Ltd.

Phone: +44 330 002 0640

E-mail: sales@odu-uk.co.uk
www.odu-uk.co.uk

Further information and specialized representatives can be found at:
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