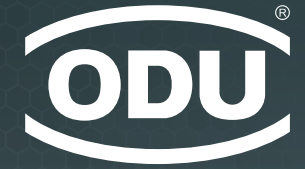


# ODU AMC<sup>®</sup> NP

Assembly instructions for solder termination





Break-away plug  
**Style A1**



In-line receptacle  
**Style K1**

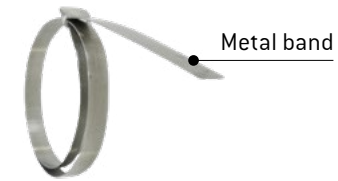
## TABLE OF CONTENTS

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# ASSEMBLY STEP BY STEP

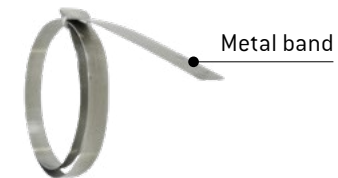
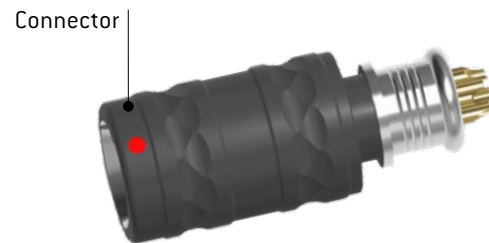
## CONNECTORS WITH CRIMP TERMINATION

Plug with solder contacts



Order separately

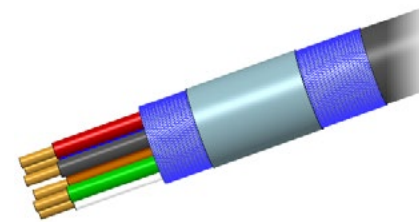
In-line receptacle with solder contacts



Order separately

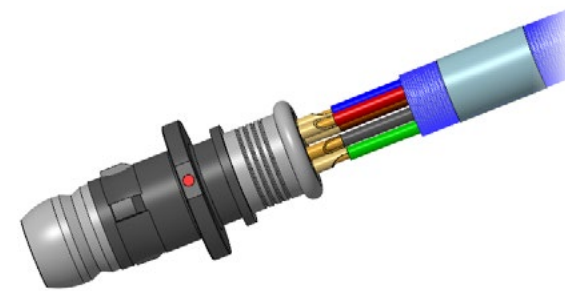
## Step 1

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



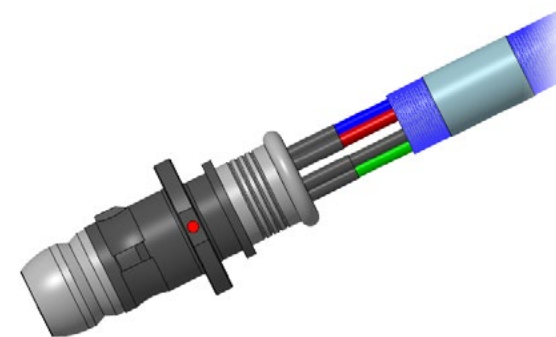
## Step 2

- ▶ Solder wires to the contacts.



## Step 3

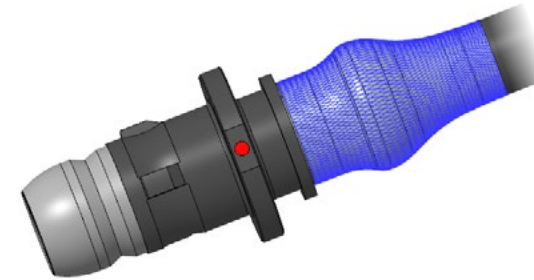
- ▶ Isolate solder joints with shrink tube to prevent shorts between contacts and cable braid.



---

## Step 4

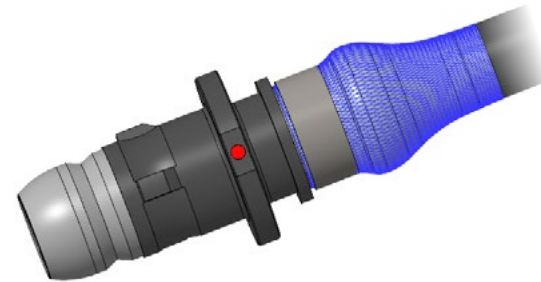
- ▶ Remove the fastening tape and lay the shield braid on to the crimp area.



---

## 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

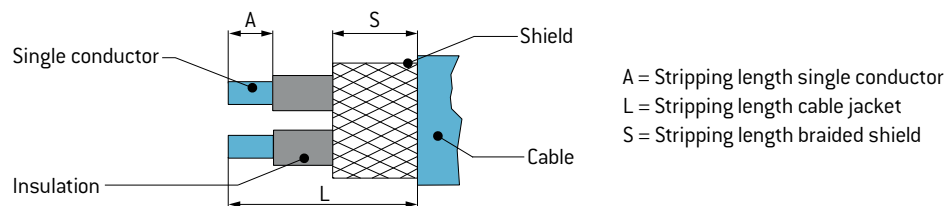
- ▶ Bend relief: This can be implemented by means of overmolding or by using shrink boot. More information on [page 8](#)



# 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),

wrap 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

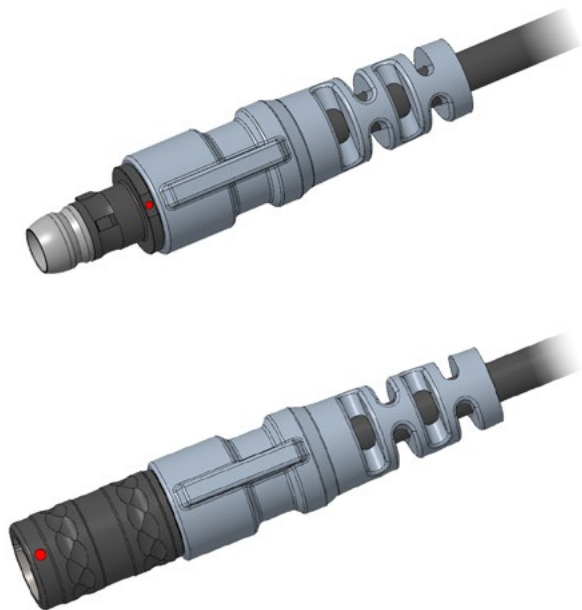


## CABLE INTERFACE

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



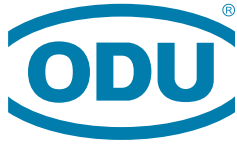
Heatshrink Straight Boot			
Shell size	ODU number	TE Connectivity	Cable Diameter
6	921.000.010.008.103	202K111-25-0	> 3.0 mm



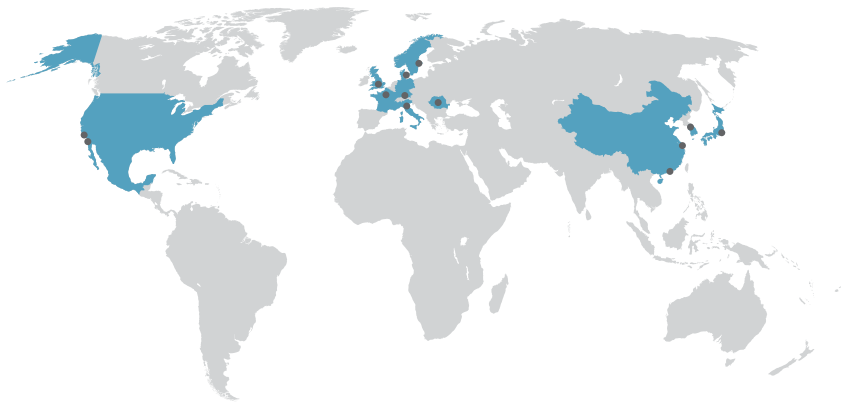
Heatshrink Right Angle Boot				
Shell size	ODU number	Hellermann Tyton	MIL Type	Cable Diameter
6	921.000.010.008.115	411-08480	1108-4	> 3.8 mm

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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<b>Romania</b>	ODU Romania Manufacturing SRL
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