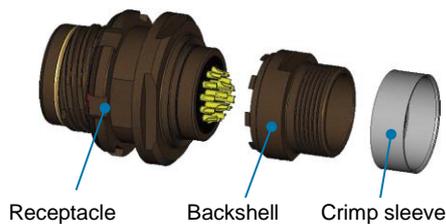


ASSEMBLY INSTRUCTION



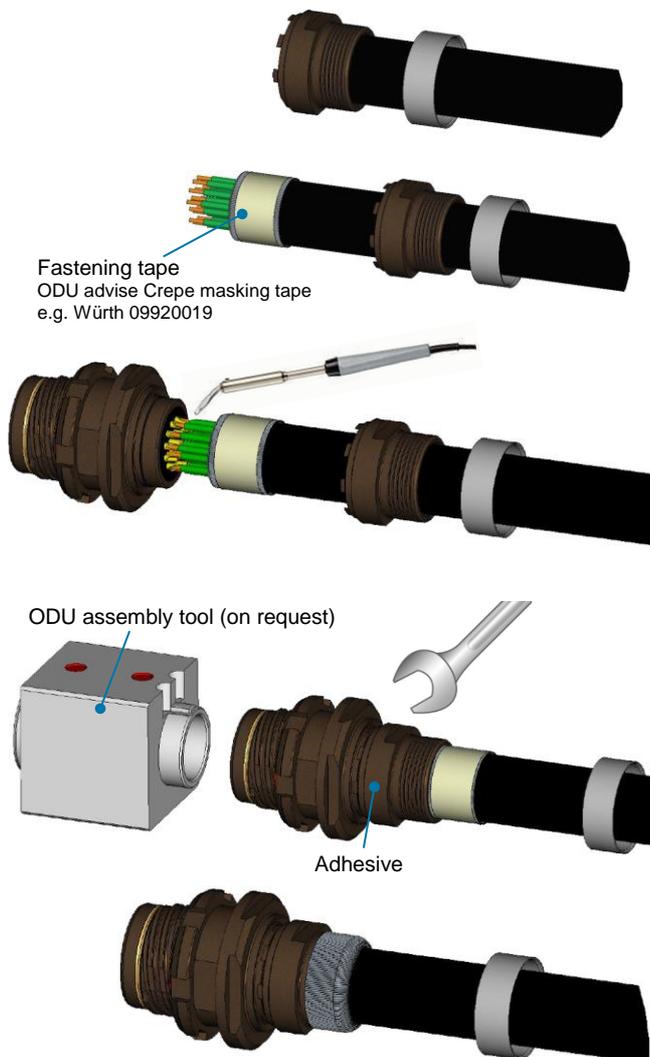
ODU AMC[®] Receptacle style G6

1. Cable assembly



Size	max. cable \varnothing mm
1.5	8.5
3	12.5

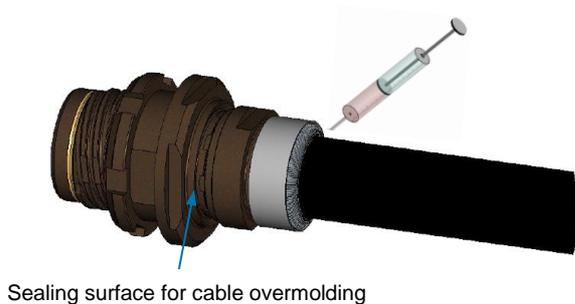
Note: Cable with foil shield such as foiled twisted pair-cable (FTP) not suitable for shield termination mentioned below.



1. Slide crimp sleeve and backshell over the cable. The crimp sleeve is not needed if a metal band is used for fastening the shield to the backshell.
2. Strip the cable and conductors¹⁾. Fold back the shield and use fastening tape to fasten it temporarily to the cable jacket. Tin-plate this wires if needed.
3. Solder the wires, noting the placement of each wire according to your wiring chart. Clean the solder area with Isopropylalcohol and brush.
4. Screw the crimp adapter on so that it is flush, observing torque values (see page 3). Secure the screw thread with adhesive ²⁾.
5. Remove the fastening tape and lay the shield braid on to the backshell.

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

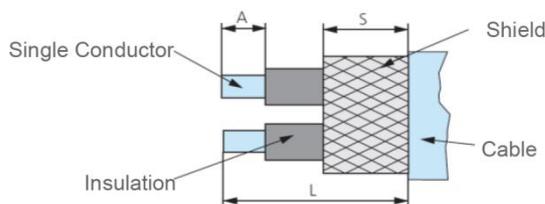
ASSEMBLY INSTRUCTION



- Fasten the shield braid to the backshell by means of crimping or by using a metal band. More information see page 4. Encapsulate the interior of the backshell to secure the soldered points (ODU advise WEVO-2K-casting resin PU552FL)
- Bend relief: This can be implemented by means of Overmolding or by using shrink boot. More information see page 5.

2. Cable Preparation – straight cable exit

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



Size	Contact \varnothing	Straight cable assembly			Right angle cable assembly		
		L	A	S	L	A	S
1.5	0.5	11	3.5	8	15	3.5	15
	0.6	11	3.5	8	15	3.5	15
	0.7	11	3.7	8	15	3.7	15
3	0.5	13	3.5	8	30	3.5	25
	0.7	13	3.7	8	30	3.7	25
	0.9	13	3.7	8	30	3.7	25
	2.0	13	5.4	8	30	5.4	25

Stripping lengths cable jacket (L)	
Length in mm	Tolerance in mm
< 20	± 1
> 20 - 50	± 2
> 50 - 100	± 3

Stripping length braided shield (S)	
Length in mm	Tolerance in mm
< 10	± 1
> 10 - 20	± 2

Stripping lengths single conductor (A)	
Length in mm	Tolerance in mm
< 5	± 0.5
> 5 - 10	± 1
> 10 - 20	± 2

Exceptions are noted on special instructions.

Note 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.

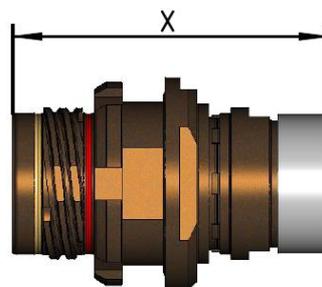
ASSEMBLY INSTRUCTION



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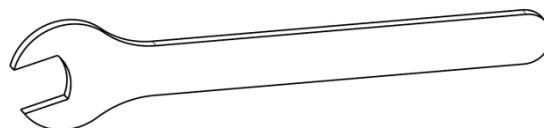
3. Assembly crimp adapter

Size	Torque Nm	Reference Dimension x mm
1.5	1.5	30.3
3	2.5	48.1



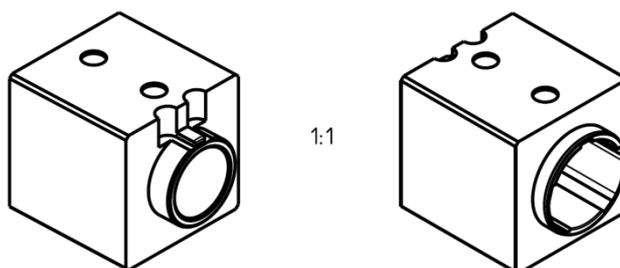
3.1 Spann wrench

Size	Part number	Wrench size
1.5	598.700.001.012.000	11
3	598.700.001.007.000	16



3.2 Assembly tool

Size	Part number
1.5	715.645.900.320.100
3	703.645.900.320.100



ASSEMBLY INSTRUCTION



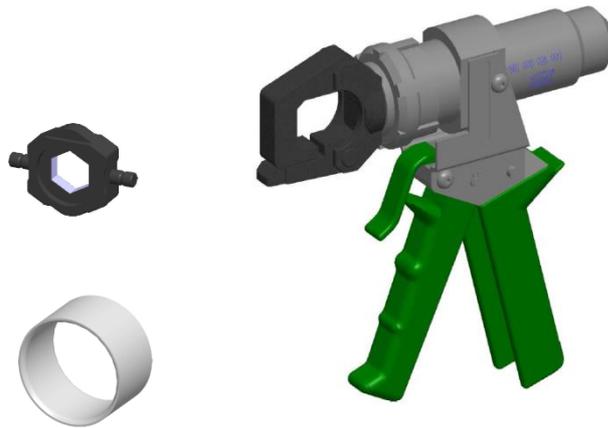
Receptacle style G6

4. Assembly crimp sleeve

4.1 Crimp tool ODU

Hand-crimp tool	
Size	Part number
all	080.000.026.000.000

Crimp dies	
Size	Part number
1.5	080.000.026.715.000
3	080.000.026.703.000



To connect the shielding with the crimp.

4.2 Band-It Bands

Hand-crimp tool	
Size	Part number
all	080.000.058.000.000

Tie-Dex Micro Bands	
Size	Part number
1.5	921.000.004.000.248
3	921.000.004.000.248



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

ASSEMBLY INSTRUCTION



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5. Cable interface

ODU connectors are designed for overmolding. A heatshrinkable bend relief is also possible. The used backshell is designed for overmolding and heatshrinkable solution.

5.1 ODU overmolding

We provide complete solution with straight overmolding.



5.2 Heatshrinkable straight solution

Size	Part number		
	ODU	Hellermann	TE Connectivity
1.5	921.000.010.008.085	401-52780	202K121-25-01
3	921.000.010.008.084	401-52880	202D121-3-60



The image can vary depending on size and variant of this shrinking tube.

ODU stock parts are the bold numbers.

5.2 Heatshrinkable right-angle solution

Size	Part number	
	ODU	Hellermann
1.5	921.000.010.008.087	411-52480
3	921.000.010.008.087	411-52480



The image can vary depending on size and variant of this shrinking tube.

To a better adhesion of the heatshrink boots on housing and cable, ODU recommend to work with an epoxydadheseion e.g. Hellermann V9500, TE connectivity S1125. (Take care of Hellermann/TE Connectivity work instruction)