

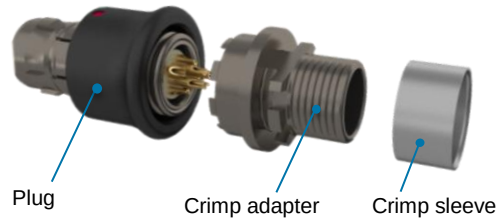
ASSEMBLY INSTRUCTION

ODU AMC® & ODU AMC® Easy-Clean



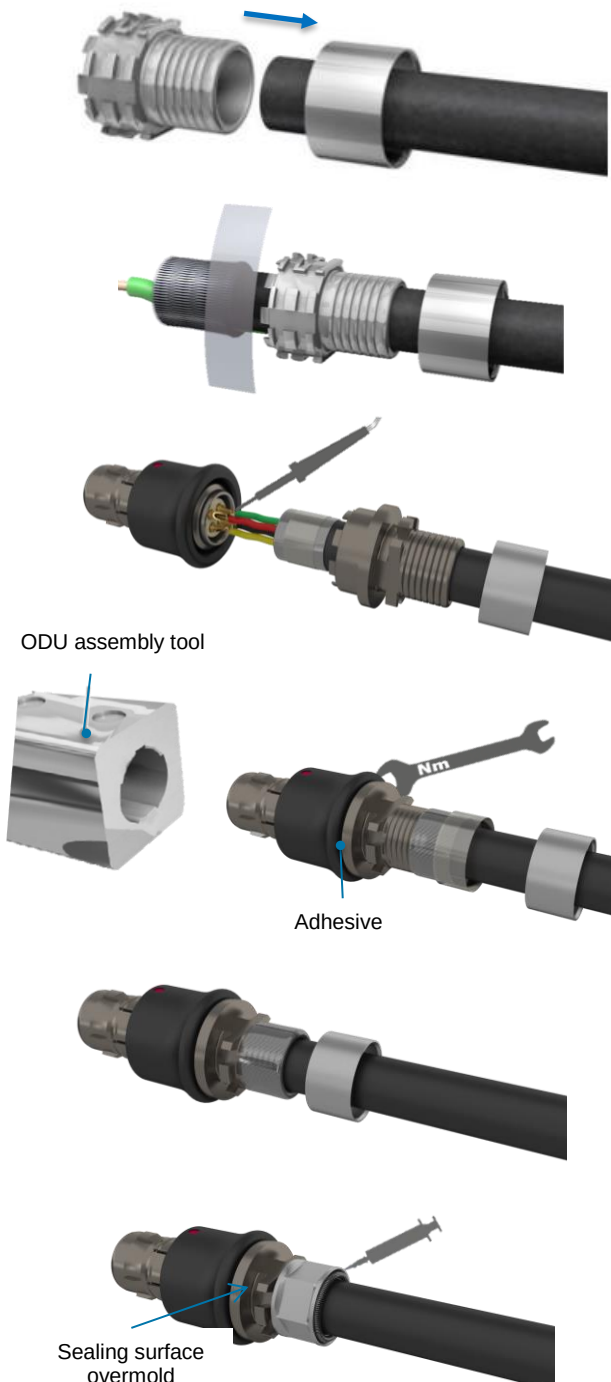
1. Cable assembly

Note: Images are examples and may differ from the product.



Size	max. cable Ø mm
0	5.5
1	6.5
1.5	8.0
2	10.0
3	11.5
4.5	17.5

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



1. Slide crimp sleeve and 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.
2. Strip the cable and conductors (page 2). 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. Secure the screw thread with adhesive. The assembly tools should be used to counter the torque.(see page 3)
5. Remove the fastening tape and lay the shield braid on to the crimp adapter.
6. Fasten the shield braid to the crimp adapter by means of crimping or by using a metal band. More information. (see page 4) Pour potting compound into the connection area
7. Bend relief: This can be implemented by means of overmolding or by using shrink boot. More information. (See page 5)

General information: Illustrations only exemplary. Product may vary in appearance.
1) Additional information for cable preparation etc. please see page 2 and following

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2. Cable Preparation – straight / right angle cable exit

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

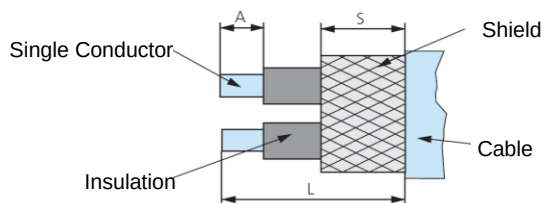


Figure can deviate from recommended stripping dimensions.

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

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

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

Size	Contact ø	With standard crimp adapter for ODU overmolding						S1 Push-Pull connector heat shrink adapter ²⁾					
		Straight cable assembly			Right angle cable assembly			Straight cable assembly			Right angle cable assembly		
		L	A	S	L	A	S	L	A	S	L	A	S
0	0.5	9	3.5	8	14	3.5	14	11	3.5	8	16	3.5	16
	0.6	9	3.5	8	14	3.5	14	11	3.5	8	16	3.5	16
	0.7	9	3.7	8	14	3.7	14	11	3.7	8	16	3.7	16
	0.9	9	3.7	8	14	3.7	14	11	3.7	8	16	3.7	16
1	0.5	11	3.5	8	15	3.5	15	13.5	3.5	8	17.5	3.5	17.5
	0.6	11	3.5	8	15	3.5	15	13.5	3.5	8	17.5	3.5	17.5
	0.7	11	3.7	8	15	3.7	15	13.5	3.7	8	17.5	3.7	17.5
	0.9	11	3.7	8	15	3.7	15	13.5	3.7	8	17.5	3.7	17.5
1.5	0.5	11	3.5	8	15	3.5	15	13.5	3.5	8	17.5	3.5	17.5
	0.6	11	3.5	8	15	3.5	15	13.5	3.5	8	17.5	3.5	17.5
	0.7	11	3.7	8	15	3.7	15	13.5	3.7	8	17.5	3.7	17.5
2	0.5	11	3.5	8	15	3.5	15	13.5	3.5	8	18.5	3.5	18.5
	0.7	11	3.7	8	15	3.7	15	14.5	3.7	8	18.5	3.7	18.5
	0.9	11	3.7	8	15	3.7	15	14.5	3.7	8	18.5	3.7	18.5
	1.3	11	4.1	8	15	4.1	15	14.5	4.1	8	18.5	4.1	18.5
3	0.5	13	3.5	8	30	3.5	25	17.5	3.5	8	34.5	3.5	34.5
	0.7	13	3.7	8	30	3.7	25	17.5	3.7	8	34.5	3.7	34.5
	0.9	13	3.7	8	30	3.7	25	17.5	3.7	8	34.5	3.7	34.5
	2.0	13	5.4	8	30	5.4	25	17.5	5.4	8	34.5	5.4	34.5
4.5	0.7	20	3.7	20	40	3.7	30	20	3.7	20	40	3.7	30

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.

²⁾ Special crimp adapter to be ordered separately. See chapter 5.2.

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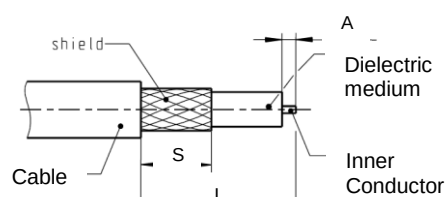


2.1 Cable Preparation / Koax, only size 0 (A1 / S1 / G6)

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

Single Conductor

Size	Contact ø	L	A	S
0	0.9	8	2	8

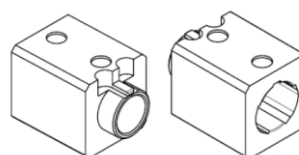


3. Assembly crimp adapter

3.1 Spann wrench



3.2 Assembly tool



Size	Part number	AF	S1	A1 / K1 / G6
0	598.700.001.011.000	7	X	
	598.700.001.022.000	9		X
1	598.700.001.001.000	8	X	
	598.700.001.012.000	11		X
1.5	598.700.001.002.000	10	X	
	598.700.001.003.000	12		X
2	598.700.001.003.000	12	X	
	598.700.001.005.000	14		X
3	598.700.001.005.000	14	X	
	598.700.001.023.000	18		X
4.5	598.700.001.018.000	21	X	

Size	Part number	Torque Nm
0	700.645.900.320.000	0.5
1	701.645.900.320.000	1.0
1.5	715.645.900.320.000	1.5
2	702.645.900.320.000	2.0
3	703.645.900.320.000	2.5
4.5	745.645.900.320.000	3.0

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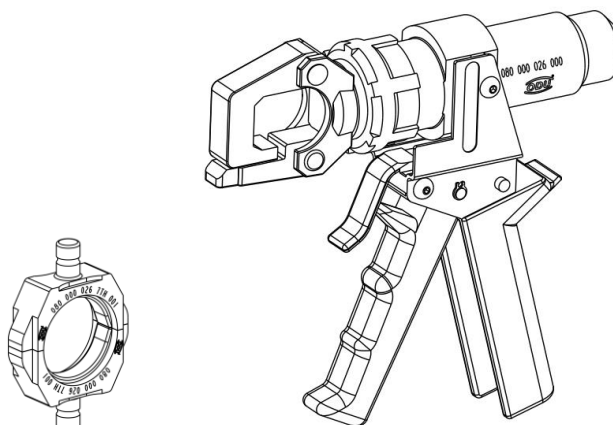
4. Shield termination

4.1 Crimp tool ODU

To connect the shielding with the crimp.

Hand-crimp tool	
Size	Part number
0-3	080.000.026.000.000

Crimp dies	
Size	Part number
0	080.000.026.700.000
1	080.000.026.701.000
1.5	080.000.026.715.000
2	080.000.026.702.000
3	080.000.026.703.000

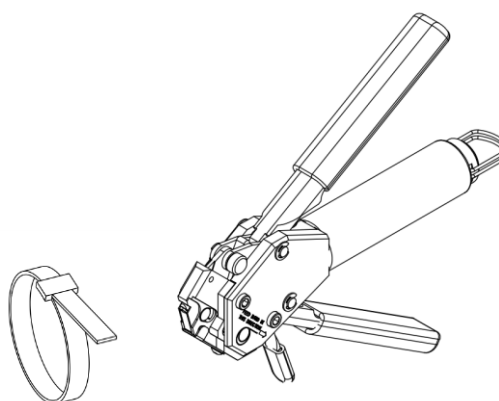


4.2 Band-It Bands

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

Ban-it tool	
Size	Part number
all	080.000.058.000.000

Tie-Dex Micro Bands	
Size	Part number
0-3	921.000.004.000.248
4,5	921.000.004.000.249



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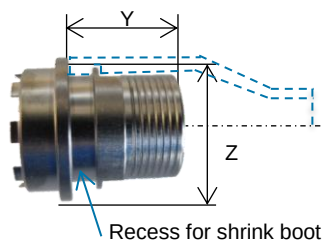


5. Cable interface

5.1 ODU overmolding

For optimal performance, we recommend ODU's overmolded cable assemblies. We offer comprehensive solutions, including both straight and right-angle overmolding, tailored to your specific requirements.

5.2 S1 Push-Pull connectors heat shrink adapter



Size	Special crimp adapter	Y	Z	AF
0	700.645.260.659.003	11.5	11.9	8
1	701.645.260.659.003	12	13.9	9
1.5	715.645.260.659.003	12	15.5	11
2	702.645.260.659.003	13	17.6	12
3	703.645.260.659.003	14	21.6	14

5.3 Heatshrinkable straight solution

Type	Size	Part number	Hellermann	TE Connectivity	CableØ [mm]
S1	0	921.000.010.008.103	-	202K111-25-0	>3mm
	1	921.000.010.008.103	-	202K111-25-0	<6mm
	1	921.000.010.008.085	401-52780	202K121-25-01	>6mm
	1.5	921.000.010.008.085	401-52780	202K121-25-01	>6 mm
	2	921.000.010.008.084	401-52880	202D121-3-60	>6 mm
	3	921.000.010.008.084	401-52880	202D121-3-60	>6 mm
A1, G6, K1	4.5	921.000.010.008.089	401-55780	202K142-25-01	>6 mm
	0	921.000.010.008.103	-	202K111-25-0	>3 mm
	1	921.000.010.008.103	-	202K111-25-0	>3 mm
	1.5	921.000.010.008.103	-	202K111-25-0	>3 mm
	1.5	921.000.010.008.084	401-52780	202D121-3-60	>6 mm
	2	921.000.010.008.084	401-52880	202D121-3-60	>6 mm
	3	921.000.010.008.084	401-52880	202D121-3-60	>6 mm



The image can vary depending on size and variant of this shrinking tube. Use of anepoxyd-adhesion recpmended

5.4 Heatshrinkable right-angle solution

Type	Size	Part number	Hellermann	Cable Ø [mm]
S1	0	921.000.010.008.115	411-08480	>3.8mm
	1	921.000.010.008.115	411-08480	>3.8mm
	1	921.000.010.008.087	411-52480	>6mm
	1.5	921.000.010.008.087	411-52480	>6mm
	2	921.000.010.008.087	411-52480	>6mm
	3	921.000.010.008.087	411-52480	>6mm
	4.5	921.000.010.008.111	411-56480	>6mm
A1, G6, K1	0	921.000.010.008.115	411-08480	>3.8 mm
	1	921.000.010.008.087	411-52480	>6 mm
	1.5	921.000.010.008.087	411-52480	>6 mm
	2	921.000.010.008.087	411-52480	>6 mm
	3	921.000.010.008.111	411-56480	>8.5 mm



The image can vary depending on size and variant of this shrinking tube. Use of anepoxyd-adhesion recpmended

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6. Protective Caps

Depending on the application, protective caps can be adjusted to the best length.

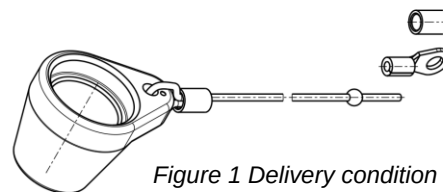
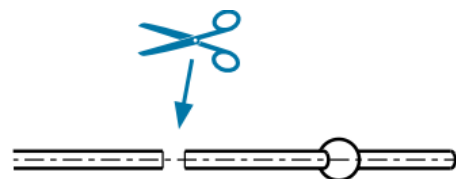
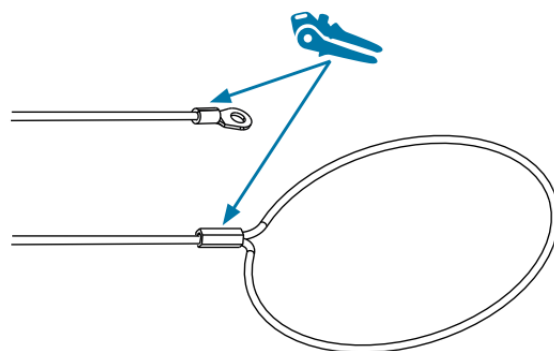


Figure 1 Delivery condition

1. Cut the lanyard in front of knot to desired length



2. Depending on version crimp lanyard with crimp barrel or ferrule with tool.



7. ODU Crimping tool

Ban-it tool	
Size	Part number
all	080.000.061.000.000

7.1 Crimping range

Part	Tool adjustment
Crimping lug	0.25 – 1.5
Crimping ferule	0.25 – 1.5

