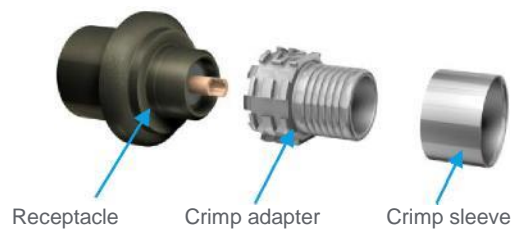


ASSEMBLY INSTRUCTION

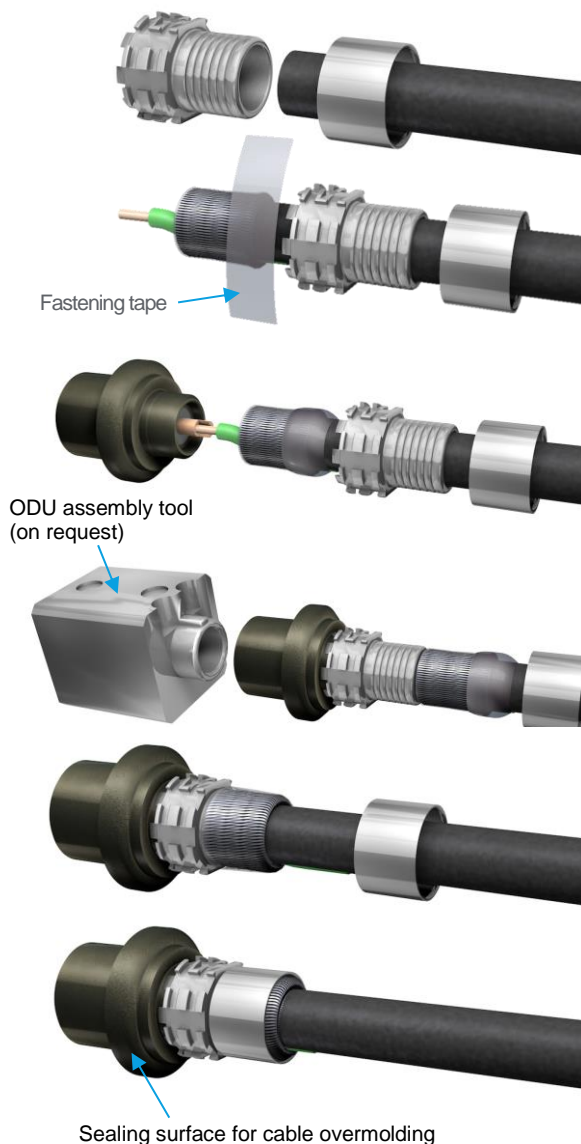


ODU AMC[®] Receptacle style G6

1. Cable assembly



Size	max. cable \varnothing mm
0	5.5
1	6.5
1.5 (A)	8.0
2	10.0



- 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.
- 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.
- Solder the wires, noting the placement of each wire according to your wiring chart. Clean the solder area with Isopropylalcohol and brush.
- Screw the crimp adapter on so that it is flush, observing torque values (see page 3). Secure the screw thread with adhesive²⁾.
- Remove the fastening tape and lay the shield braid on to the crimp adapter. Fasten the shield braid to the crimp adapter by means of crimping or by using a metal band. More information see page 4. Encapsulate the interior of the crimp adapter 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.

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

ASSEMBLY INSTRUCTION

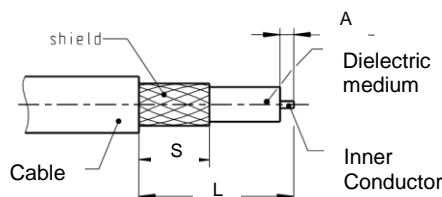


Receptacle style G6

2. Cable Preparation / Koax, only size 0

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

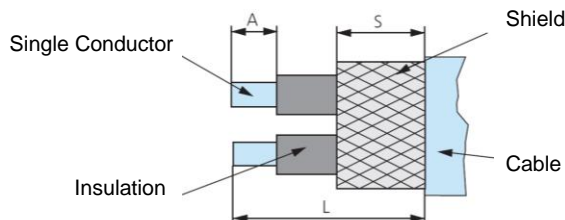
Single Conductor



Size	Contact \varnothing	L	A	S
0	0.9	8	2	8

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

Mult-wire



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

Size	Contact \varnothing	Straight cable assembly		
		L	A	S
0	0.5	8	2	8
	0.6	8	2	8
	0.7	8	2	8
	0.9	8	2	8
1	0.5	9	2	8
	0.6	9	2	8
	0.7	9	2	8
	0.9	9	2	8
1.5 (A)	0.5	11	2	8
	0.6	11	2	8
	0.7	11	2	8
2	0.5	11	2	8
	0.7	11	2	8
	1.3	11	2	8

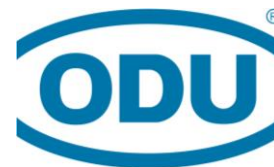
Exceptions are noted on special instructions.

Right-angle plugs have special instructions.

Notes 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 so as far as possible.

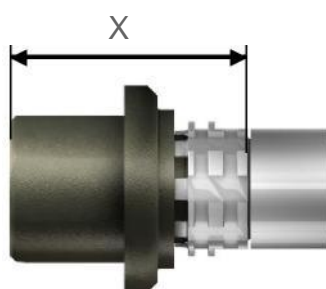
ASSEMBLY INSTRUCTION



Receptacle style G6

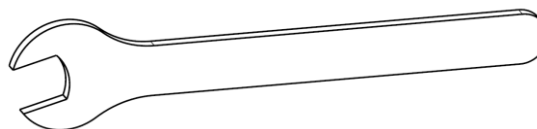
3. Assembly crimp adapter

Size	Torque Nm	Reference Dimension x mm
0	0.5	18.5
1	1.0	23.5
1.5 (A)	1.5	20.5
2	2.0	23.7



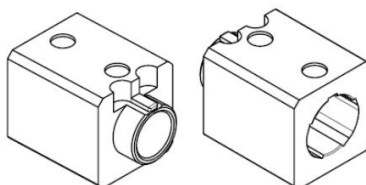
3.1 Spann wrench

Size	Part number	Wrench size
0	598.700.001.022.000	9
1	598.700.001.012.000	11
1.5 (A)	598.700.001.003.000	12
2	598.700.001.005.000	14



3.2 Assembly tool

Size	Part number
0	700.645.900.320.000
1	701.645.900.320.000
1.5 (A)	715.645.900.320.000
2	702.645.900.320.000



ASSEMBLY INSTRUCTION



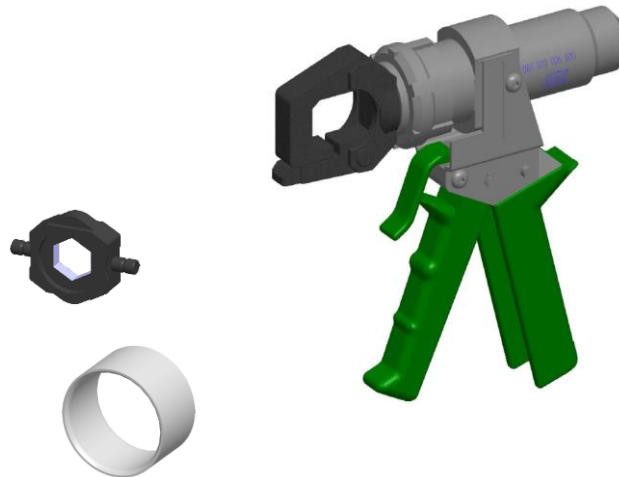
Receptacle style G6

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
0	080.000.026.700.000
1	080.000.026.701.000
1.5 (A)	080.000.026.715.000
2	080.000.026.702.000



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
0-3	921.000.004.000.248



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

ASSEMBLY INSTRUCTION



Receptacle style G6

5. Cable interface

5.1 ODU overmolding

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



5.2 Heatshrinkable straight solution

Size	Part number			Cable diameter
	ODU	Hellermann	TE Connectivity	
0+1	921.000.010.008.103	-	202K111-25-0	>3 mm
1.5	921.000.010.008.103	-	202K111-25-0	>3 mm
	921.000.010.008.084	401-52780	202D121-3-60	>6 mm
2+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.

ODU stock parts are the bold numbers.

5.3 Heatshrinkable right-angle solution

Size	Part number		Cable diameter
	ODU	Hellermann	
0	921.000.010.008.115	411-08480	>3,8 mm
1-2	921.000.010.008.087	411-52480	>6 mm
3	921.000.010.008.111 ³⁾	411-56480 ³⁾	>8,5 mm



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, we recommend to work with anepoxyd-adhesion e.g. Hellermann V9500, Raychem S1125.
(Take care of Hellermann/TE Connectivity work instruction)

3) On size 3 it's necessary to secure between housing and heatshrink boot with Hellermann V9500/TE Connectivity S1125.