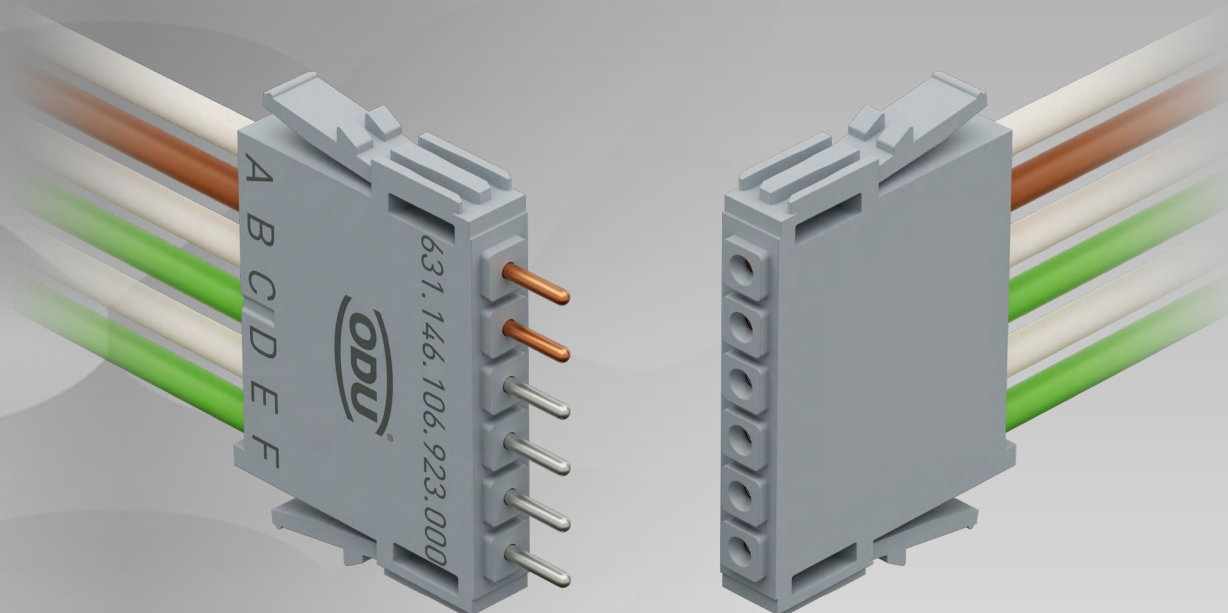


ODU-MAC[®] **Blue-Line**

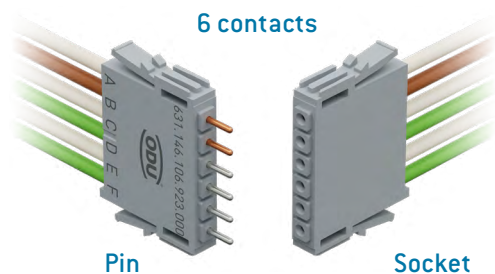


Assembly instructions for thermocouple module



NOTE

This document applies for all ODU thermocouple modules, since the designs are based on the same principle.

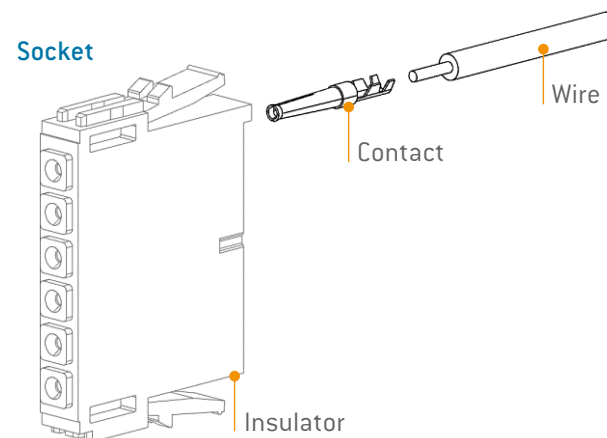
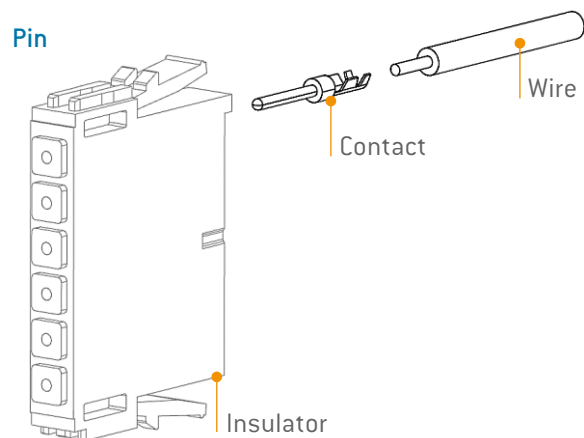
**ATTENTION!**

A thermocouple (2x pin/socket pairs) always consists of a specific combination of materials. This is either type K, with one pair made of NiCr (+) and the second pair made of Ni (-), or type T, with one pair made of Cu (+) and the second pair made of Cu-Ni (-).

ASSEMBLY INSTRUCTIONS

Product overview	<u>03</u>
Tool recommendation	<u>04</u>
How to assemble	<u>05</u>
How to disassemble	<u>07</u>

Product overview



Tools / Accessories



Stripper



Crimping tool



Removal tool



Wire cutter

NOTE

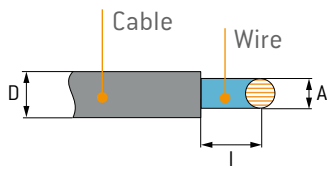
Ensure the correct adjustment of the used tools according to [page 4](#).

For recommended stripping length, crimping tool, and removal tool, see [page 4](#).

Wiring tests with test probes could damage the contacts. We recommend to use suitable test adapters or tests on the fiber termination area.

Tool recommendation

Thermocouple module	Contact-Ø [mm]	D [mm]	A [mm²]	l [mm]	Crimping tool	Position	Removal tools
6 contacts	1.0	2.4	0.22 – 0.50	5.0 ± 0.5	080.000.071.000.000	(0.20 – 0.56) mm²	087.611.001.003.000
							087.170.999.000.000



D = Max. wire diameter
l = Stripping length
A = Conductor cross section

How to assemble

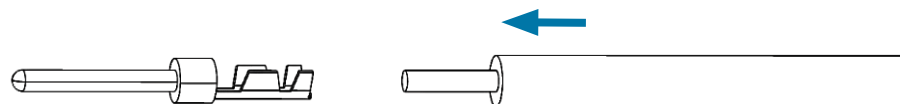
Step 1

► **Strip the wire** to the length specified in the table on [page 4](#).



Step 2

► **Insert the conductor** into the contact.

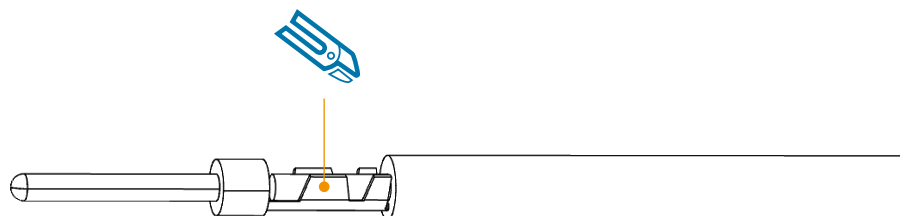


Step 3

► **Crimp the contact** onto the wire.

ATTENTION!

Ensure the correct adjustment of the used tools.



How to assemble

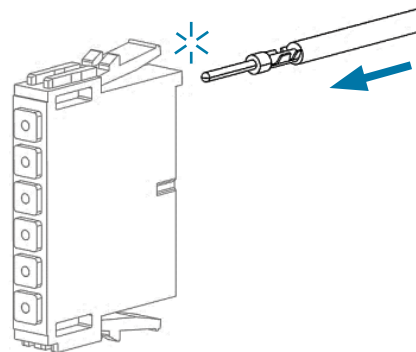
Step 4

► Insert the crimped contact into the insulator.

NOTE

Full insertion is confirmed by an audible “[click](#)”.

Full insertion can also be checked by carefully pulling the wire (max. 2 N).



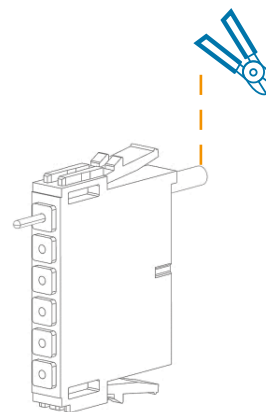
How to disassemble

Step 1 (optional)

► **Cut the wire** just before the insulator.

NOTE

Cutting the wire is not required, if disassembly tweezers are used.

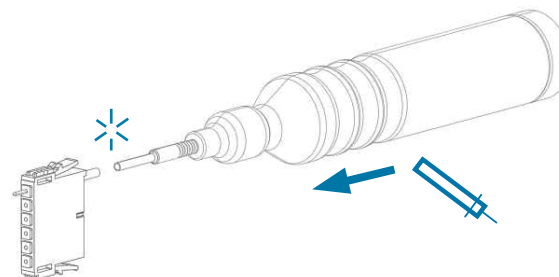


Step 2

► **Insert the removal tool** from the back into the insulator.

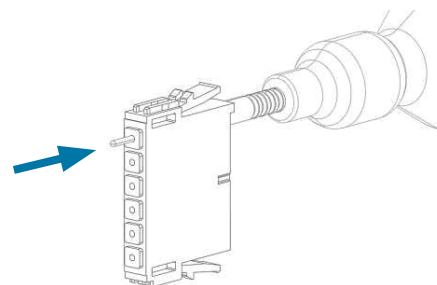
NOTE

Full insertion is confirmed by an audible „click“.



Step 3

► Carefully **push the contact** to remove it from the insulator.





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