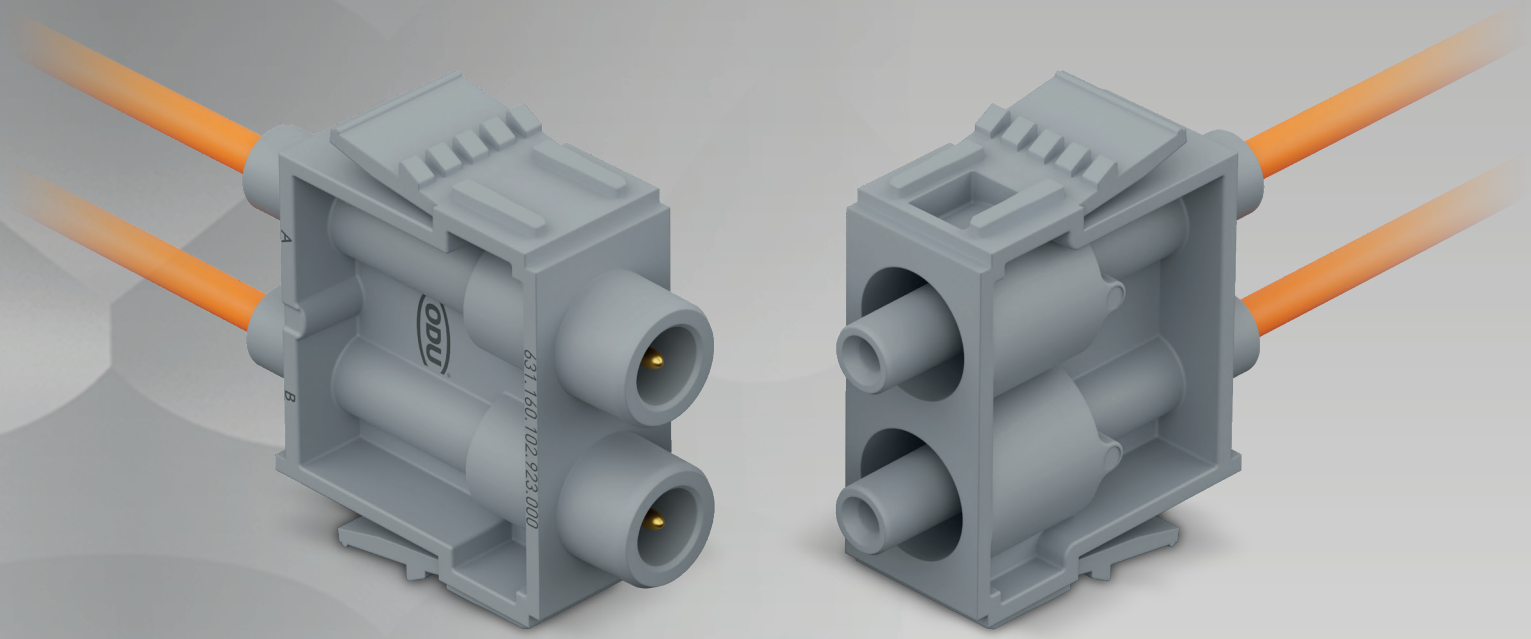
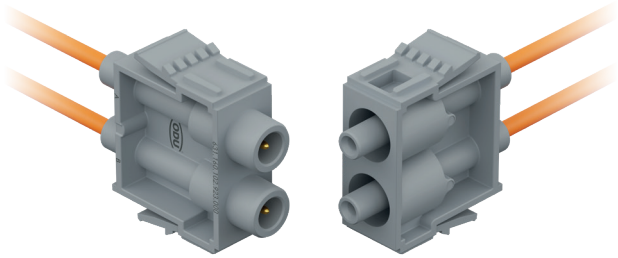
# ODU-MAC® Blue-Line

Assembly instructions for high-voltage modules



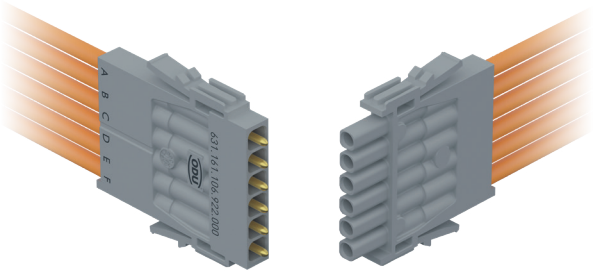
**NOTE** This document applies for all ODU High-Voltage modules, since the designs are based on the same principle.

### 2 contacts



Pin Socket

### 6 contacts



Pin Socket

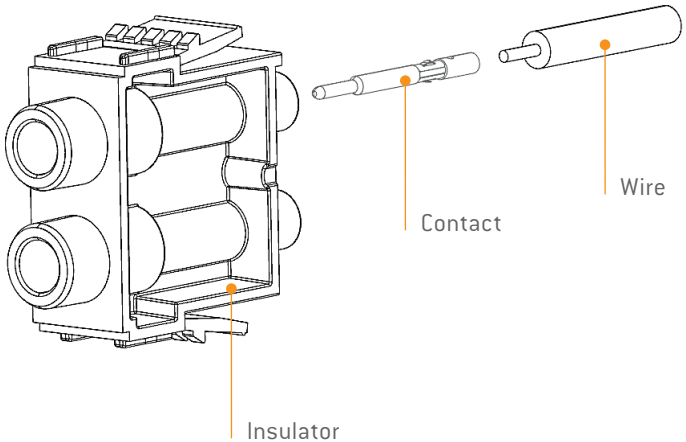
# ASSEMBLY INSTRUCTIONS



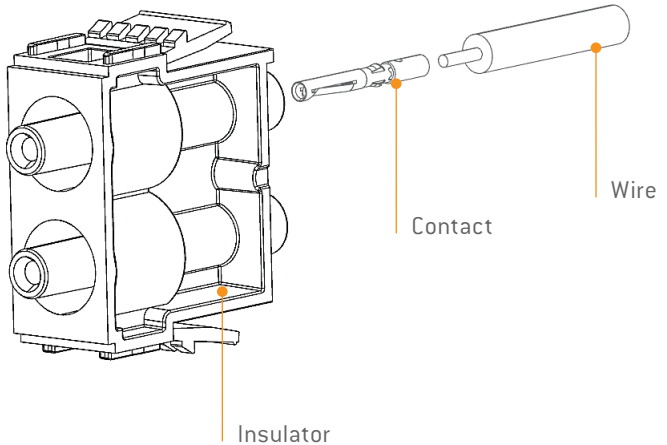
D00003978

# Product overview

## Pin




## Socket




# Tools / accessories

**Wire stripper**

**Crimping tool / crimping dies**

**Removal tool**

**ATTENTION!**

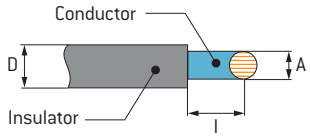
For recommended stripping length, crimping tool, positioner, and removal tool see page 4.

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

D00003978

# Tool recommendation

| D (mm) | A (mm²) | l (mm) | Crimping tool, positioner | Position | Adjustment dimension (mm) | Removal tool |
|---|---|---|---|---|---|---|
| 3.8 | 0.14 – 0.38 | 5.0 $^{+1.0}_{-1.0}$ | 080.000.051.000.000<br>080.000.051.101.000 | 10 | 0.62 | 087.7CC.130.004.000 |
| | 0.50 – 0.75 | | | | 0.92 | |
| | 1.00 | | | | 1.02 | |

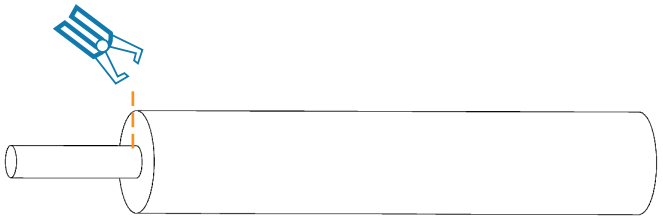



D = Max. wire diameter
l = Stripping length
A = Conductor cross section

# How to assemble

## Step 1

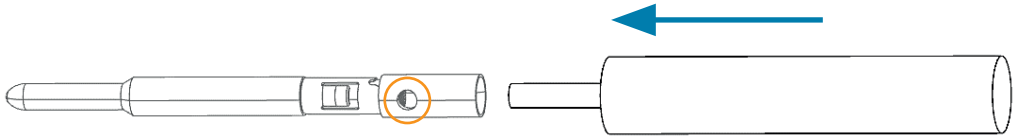
▶ Strip the wire to the length specified in the table on page 4.



## Step 2

▶ Insert the conductor into the crimp hole of the contact.

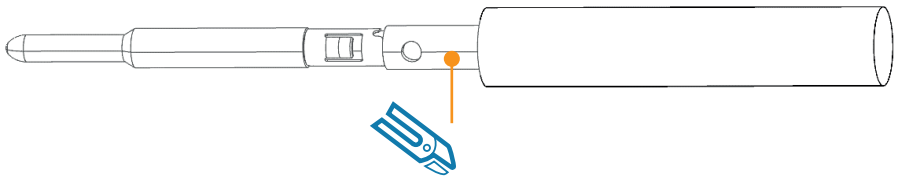
**ATTENTION!** Ensure that the conductor is correctly seated through the inspection hole.



## Step 3

▶ Crimp the contacts onto the wire.

**ATTENTION!** Ensure the correct adjustment of the used tools according to page 4.

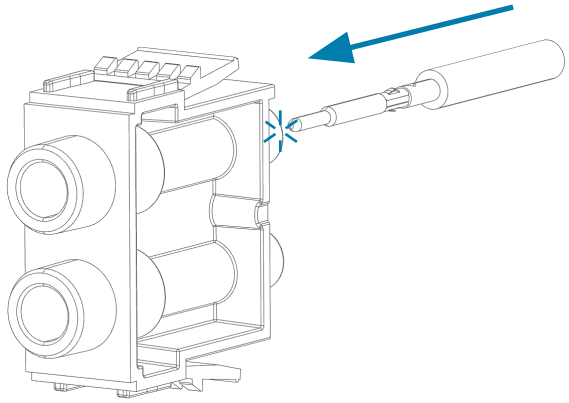


## Step 4

▶ Insert the crimped contact into the insulator.

**ATTENTION!** Full insertion is confirmed by an audible “click”.

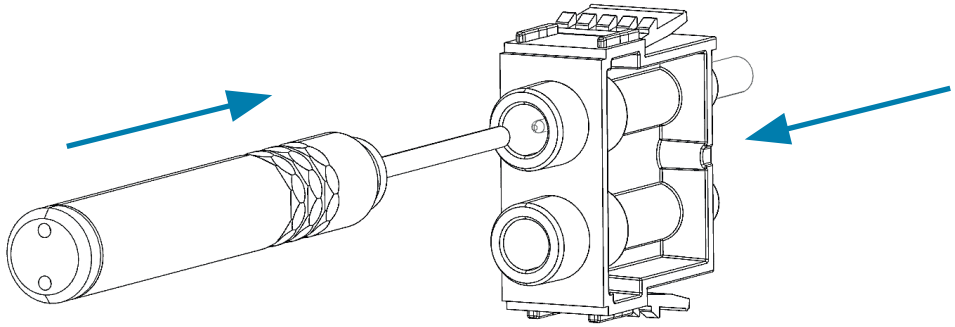
Full insertion can also be checked by carefully pulling the wire (max. 2 N).



# How to disassemble

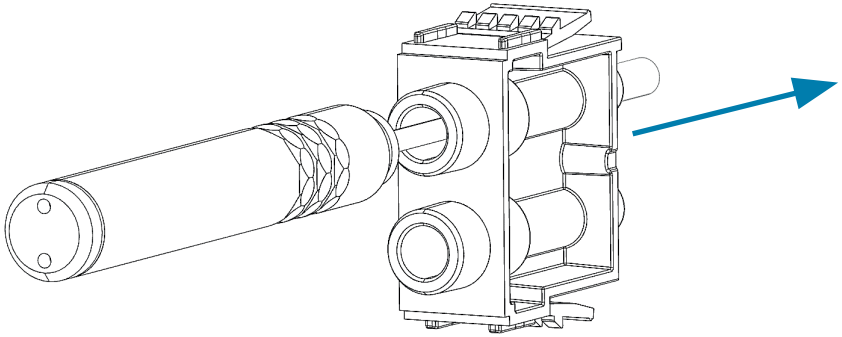
## Step 1

- Push the cable on the termination side into the insualtor to ease the disassembly.
- Insert the removal tool from the front into the insulator.



## Step 2

- Pull the cable out carefully to fully remove the contact from the insulator.



carbon neutral
print production
natureOffice.com | DE-077-860878

Printed on certified
recycled paper.

All dimensions are in mm.
Some figures are for illustrative purposes only. Subject to change without notice. Errors and omissions excepted. We reserve the right to change our products and their technical specifications at any time in the interest of technical improvement. This publication supersedes all prior publications.

ODU-MAC® BLUE-LINE HIGH-VOLTAGE / TI / 0923 / EN

This publication is also available as a PDF file that can be downloaded from www.odu-connectors.com

D00003978