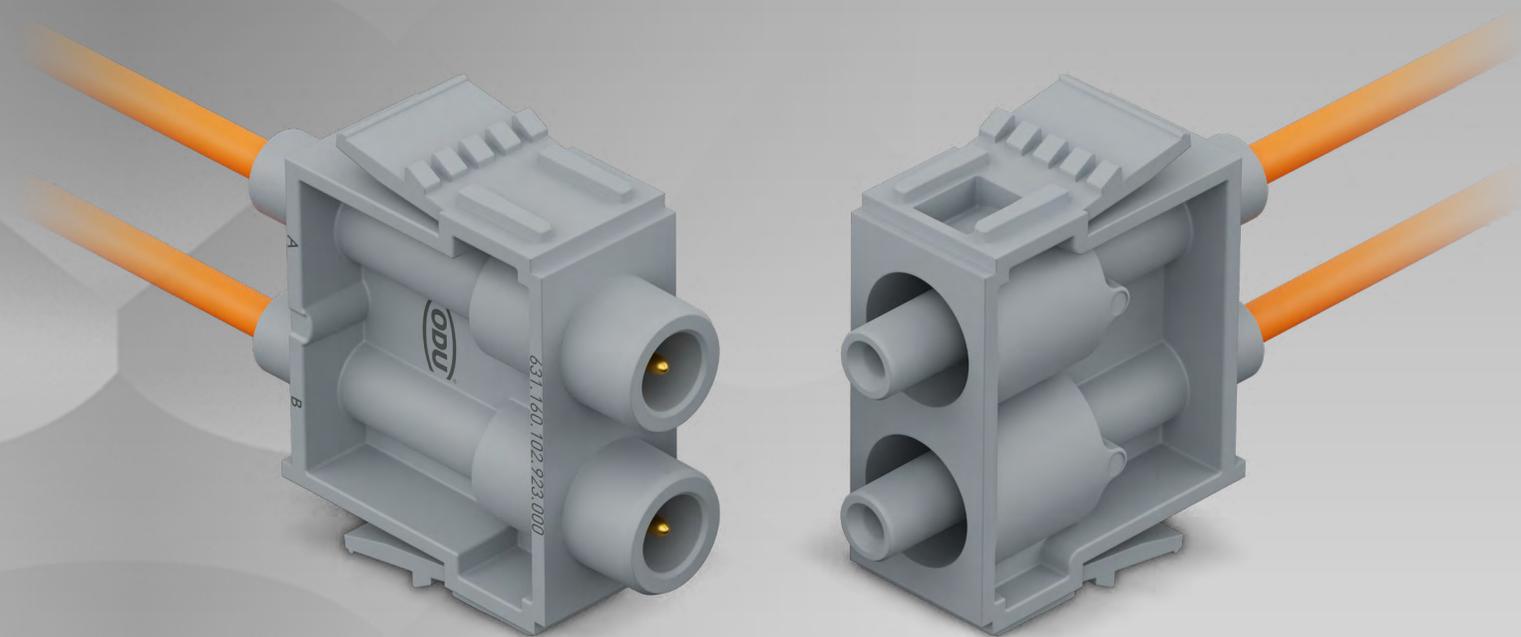
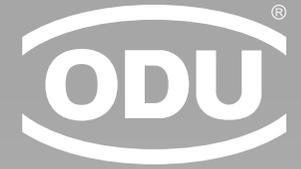


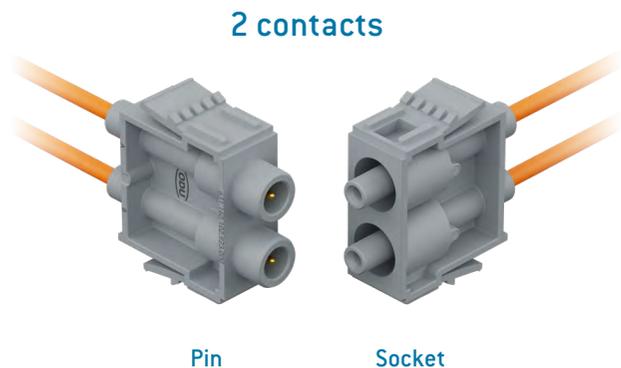
ODU-MAC[®] Blue-Line

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.

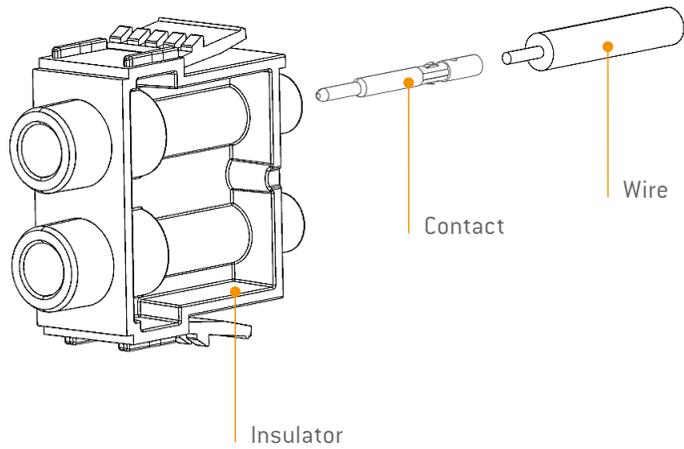


ASSEMBLY INSTRUCTIONS

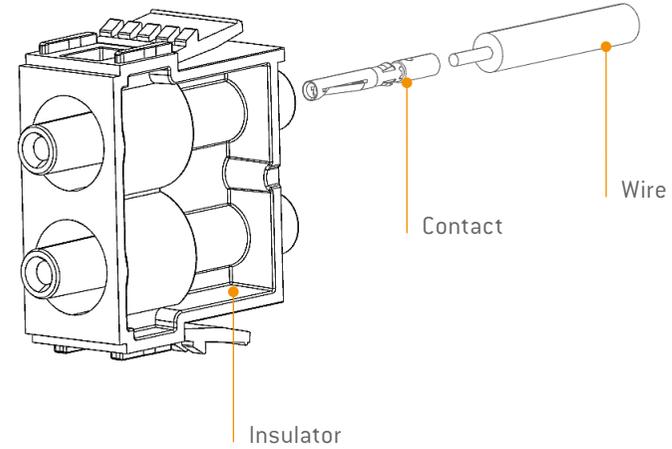
Product overview	<u>03</u>
Tool recommendation	<u>04</u>
How to assemble	<u>05</u>
How to disassemble	<u>07</u>

Product overview

Pin



Socket



Tools / accessories



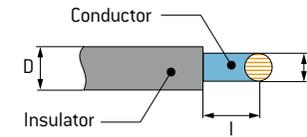
ATTENTION!

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.

Tool recommendation

D (mm)	A (mm ²)	l (mm)	Crimping tool, positioner	Position	Adjustment dimension (mm)	Removal tool
3.8	0.14 – 0.38	5.0 ^{+1.0} _{-1.0}	080.000.051.000.000 080.000.051.101.000	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

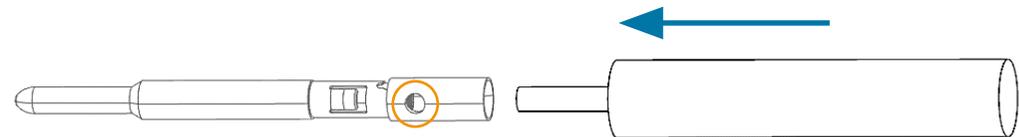
- ▶ Strip the wire to the length specified in the table on [page 4](#).



Step 2

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

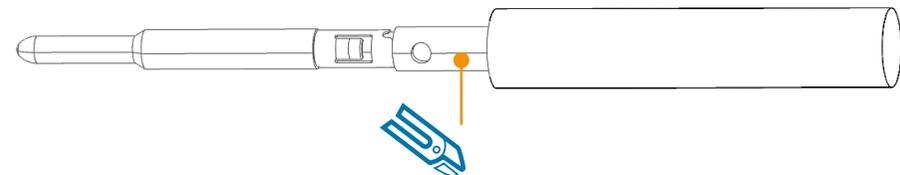
ATTENTION! Ensure that the conductor is correctly seated through the **inspection hole**.



Step 3

- ▶ Crimp the contacts onto the wire.

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



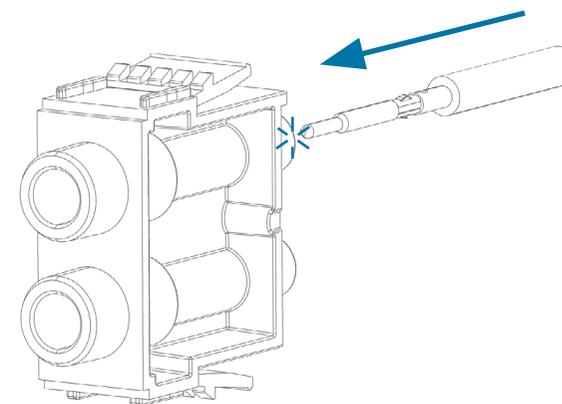
Step 4

► Insert the crimped contact into the insulator.

ATTENTION!

Full insertion is confirmed by an audible “click”.

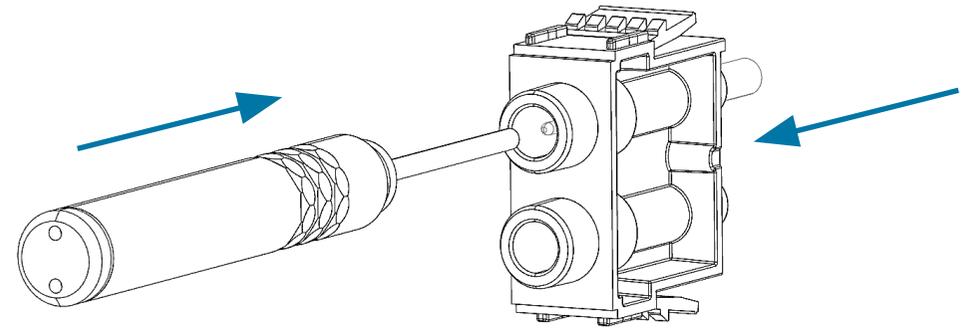
Full insertion can also be checked by carefully pulling the wire (max. 2 N).



How to disassemble

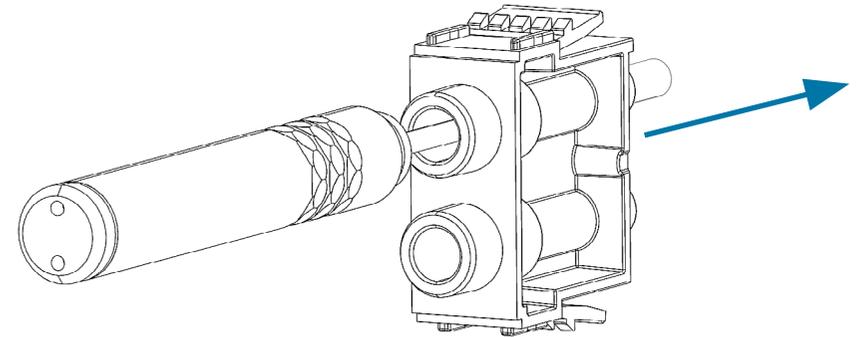
Step 1

- ▶ Push the cable on the termination side into the insulator 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.





Printed on certified recycled paper.

All dimensions are in mm.
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