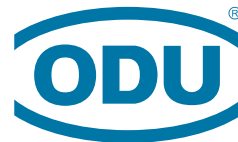


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ODU MEDI-SNAP[®]

Assembly instruction



ASSEMBLY INSTRUCTIONS

General notes 03

Size 1 | **Straight Plug** 04 – 05

Size 1 | **Break-Away Plug** (straight & right-angled versions) 06 – 10

Size 1 | **Right-angled Plug** 11 – 13

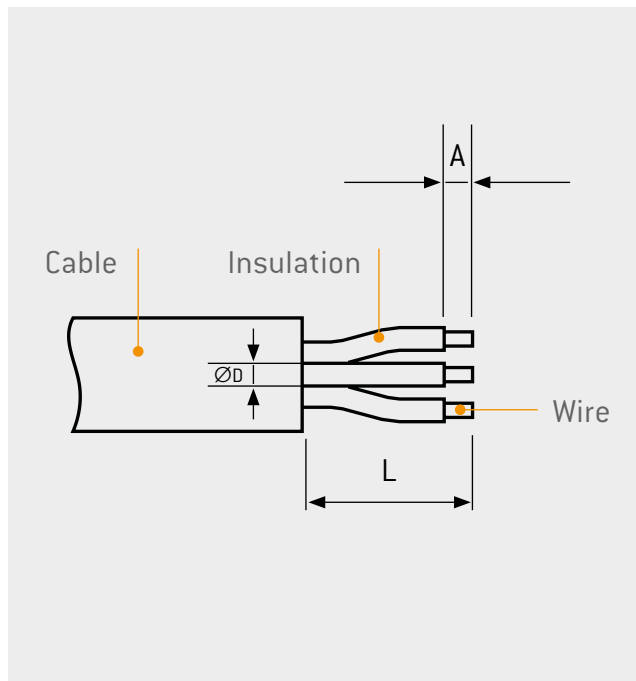
Size 1 | **In-line Receptacle** 14 – 15

Size 2 | **Straight Plug** 16 – 17

Size 2 | **Break-Away Plug** (straight version) 18 – 19

General notes

Recommended stripping length



Strand stripping length A

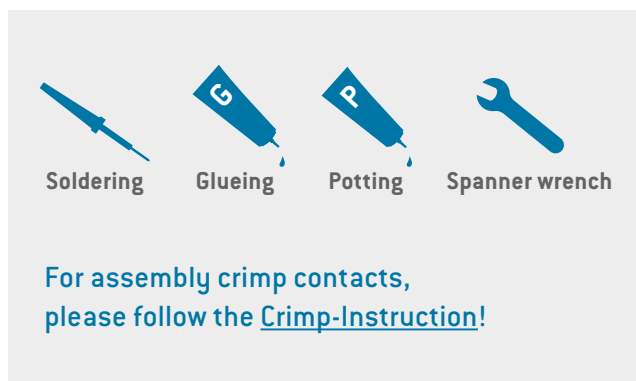
| SOLDER | |
|----------|---|
| AWG | Stripping length Drill depth + Strand diameter |
| 18 20 | $3.3 + \varnothing D$ |
| 22 26 | $2.8 + \varnothing D$ |
| 28 | $2.3 + \varnothing D$ |
| CRIMP | |
| AWG | Stripping length |
| 20–24 | 4.7 mm |
| 22–26 | 4.7 mm |

Cable stripping length L

| Size | Stripping length |
|------|------------------|
| 1 | 12 mm |
| 2 | 15 mm |

Tools / Accessories

ODU open-ended spanner and crimping tools see
ODU MEDI-SNAP® catalog section accessories and tools.



Tightening torque

Recommended tightening torques are depending on the
cable strength.

| | Torque moment Size 1 | Torque moment Size 2 |
|-----------------------------------|----------------------------|----------------------------|
| Straight plug | 0.25 Nm | 0.5 Nm |
| Right-angled plug clamping cap | 0.30 Nm | – |
| Right-angled plug clamping nut | 0.25 Nm | – |
| In-line receptacle | 0.25 Nm | – |

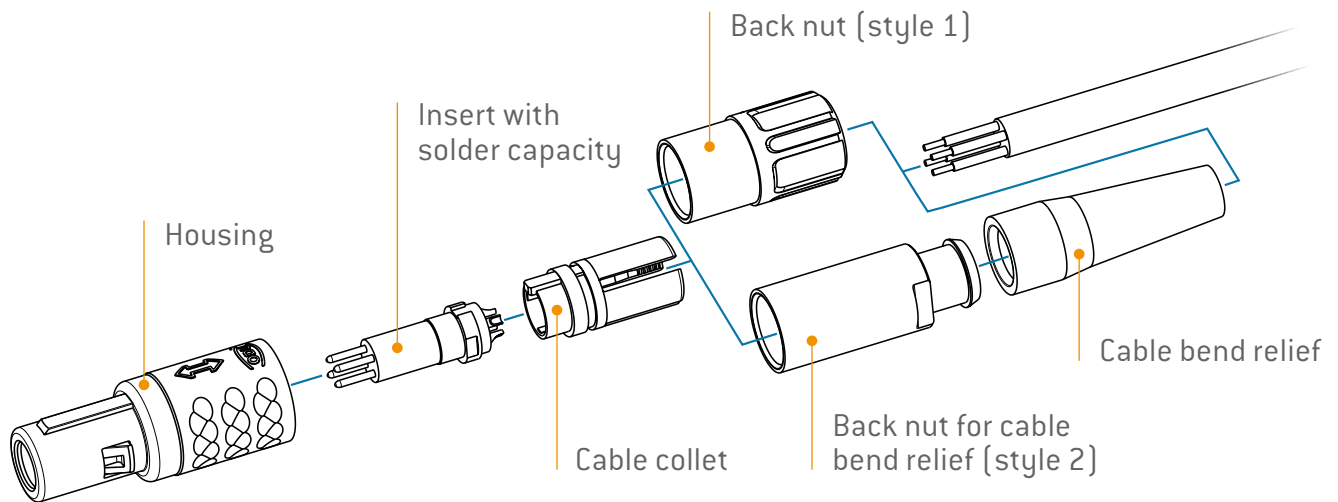
Recommended glue for the back nut

Scotchweld (grey), ODU part number 890.204.000.030.025
Recommended cleaning agent: Isopropyl alcohol

ATTENTION!

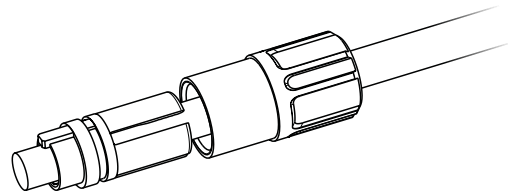
If glues are used, that have not been released, cracks may
appear after some time. Use only the indicated glues.

Assembly Straight Plug Size 1



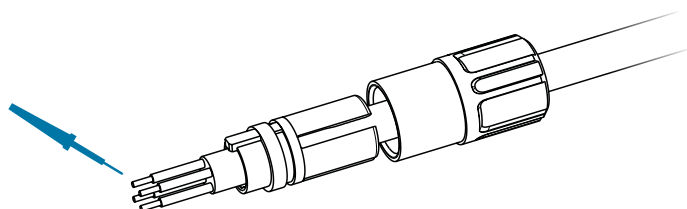
Step 1

- Slide back nut and cable collet over the cable.



Step 2

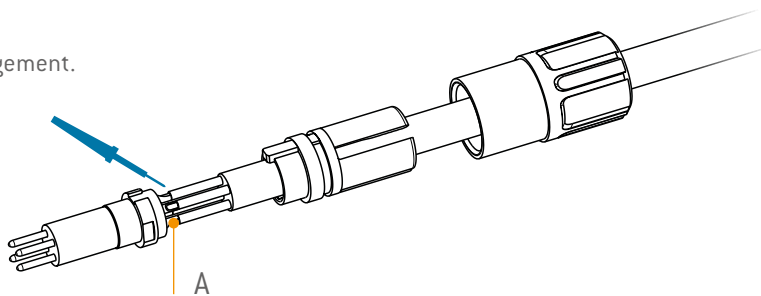
- Strip cable and wire (see page 3).
- Pre-tin strands.



Step 3

- Solder the litz wires (A) according to contact arrangement.

Recommended cleaning agent:
Isopropyl alcohol

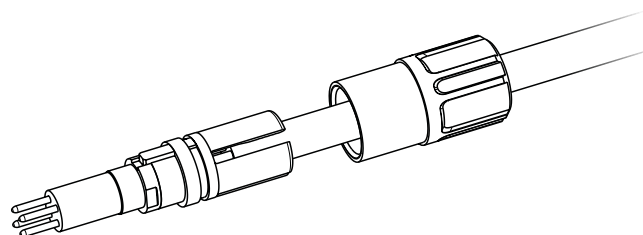


Step 4

- Slide the cable collet against contact insert.

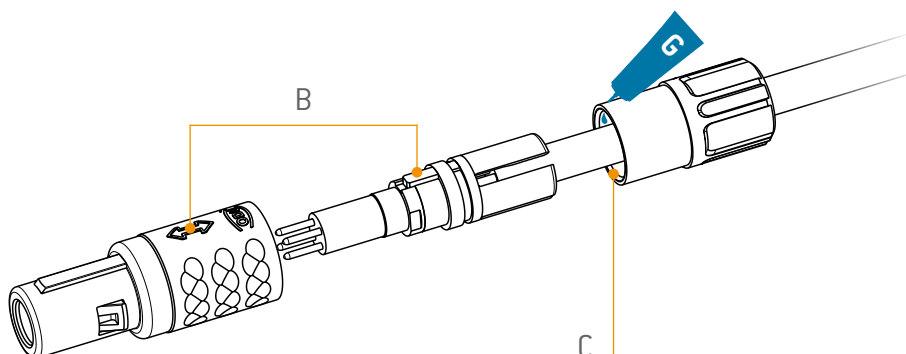
ATTENTION!

Don't damage the contacts.



Step 5

- Put the assembled cable considering the guidings (B) into the housing.
- If necessary, secure thread (C) with glue Scotch-Weld DP190 (890.204.000.030.025).

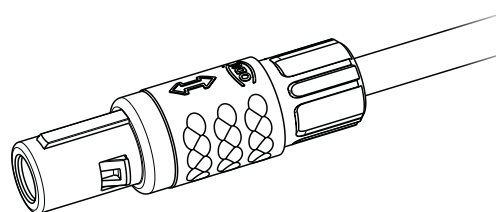


Step 6

- Screw and fasten back nut on the assembled straight plug.

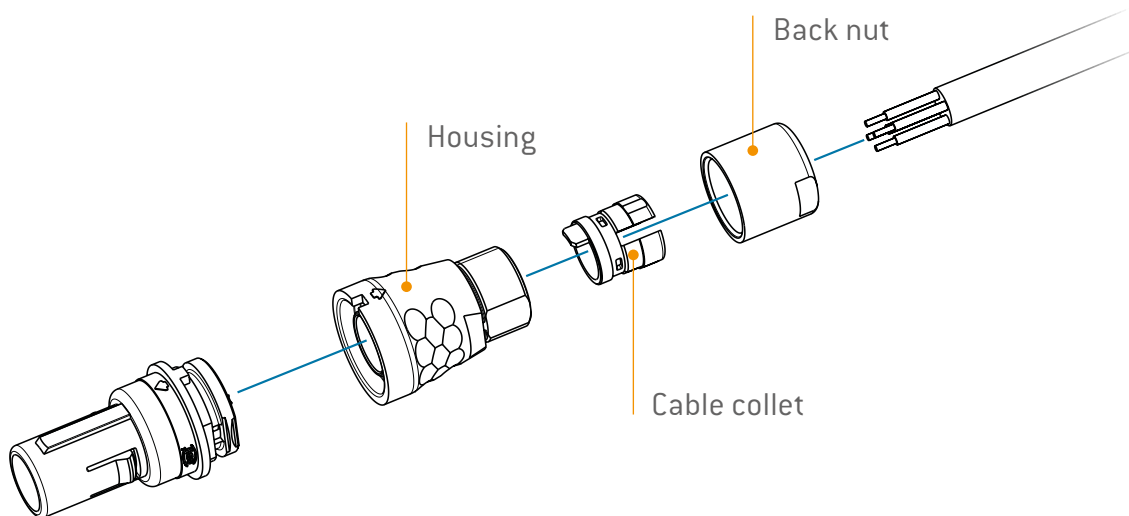
ATTENTION!

Consider tightening torque (see page 3).



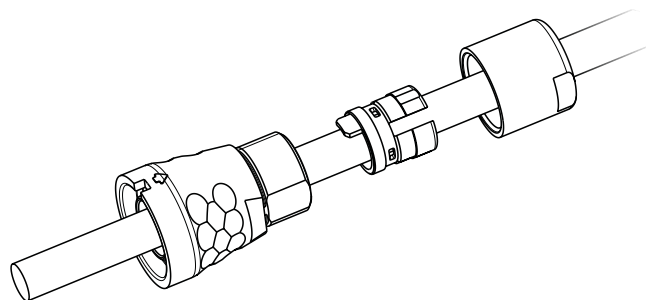
Assembly Break-Away Plug Size 1

Straight version



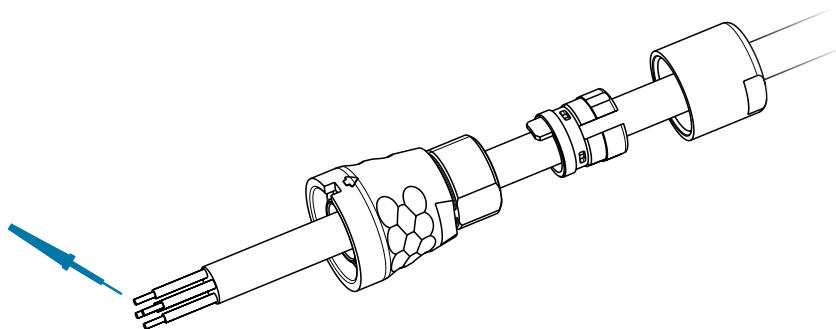
Step 1

- Slide back nut, cable collet and housing over the cable.



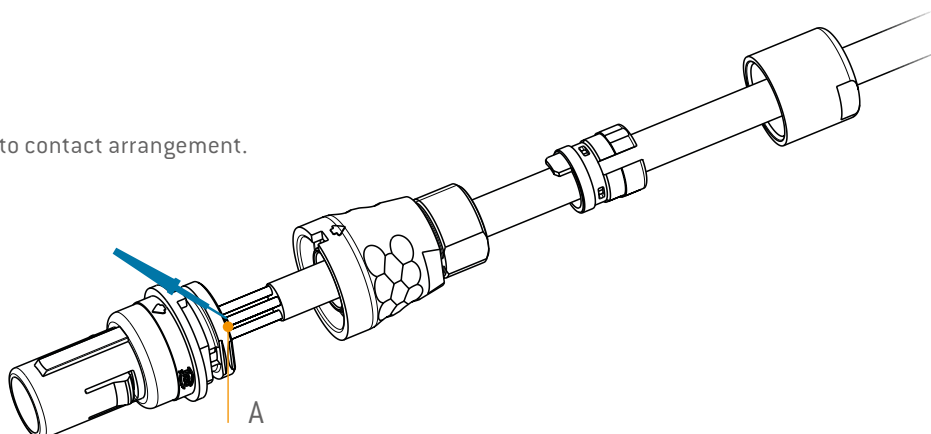
Step 2

- Strip cable and wire (see page 3).
- Pre-tin strands.



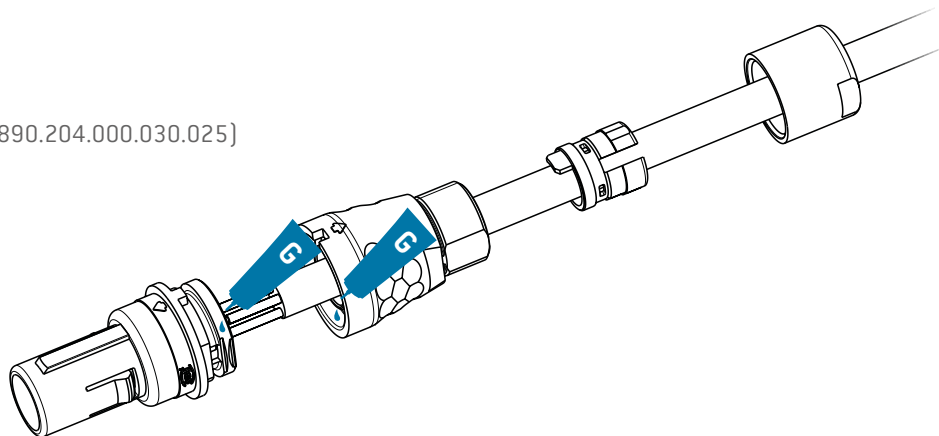
Step 3

- Solder the litz wires (A) according to contact arrangement.



Step 4

- ▶ Apply glue Scotch-Weld DP 190 (890.204.000.030.025) in the glue area.



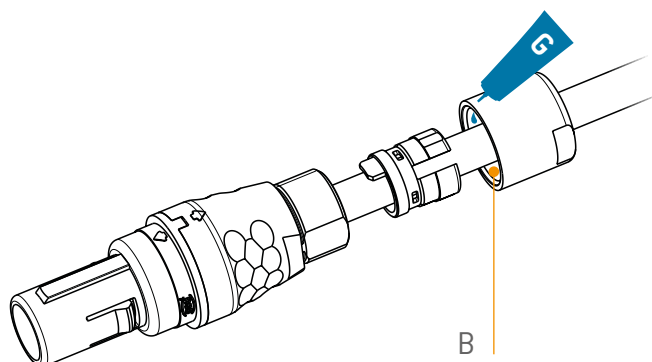
Step 5

- ▶ Push housing onto plug without a gap.

ATTENTION!

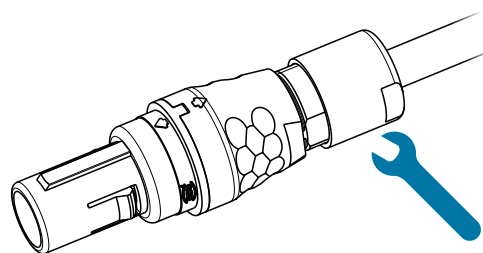
Consider position of arrows.

- ▶ If necessary, secure thread (B) with glue Scotch-Weld DP190 (890.204.000.030.025).



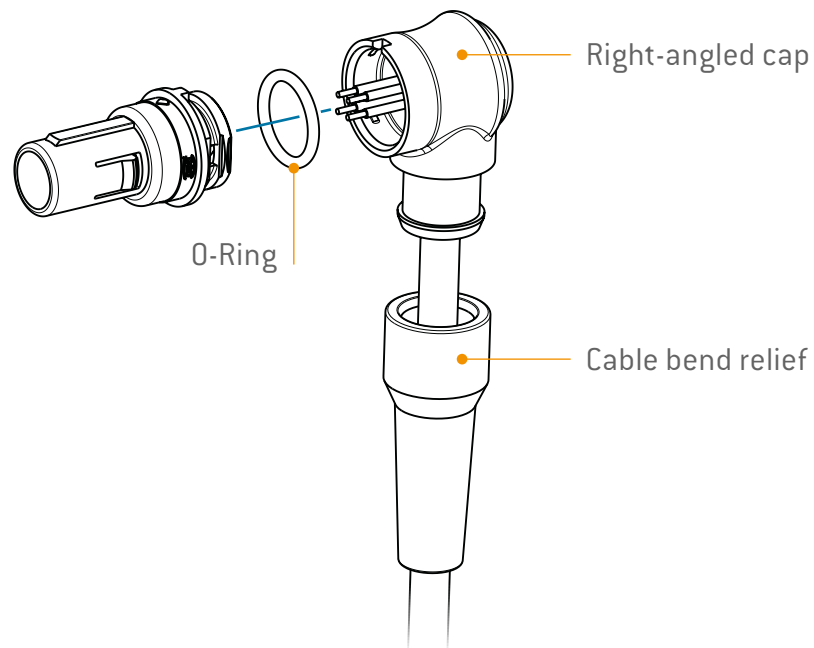
Step 6

- ▶ Slide the cable collet in the housing.
- ▶ Slide the back nut over the back shell and tighten it with **0.3 Nm**.



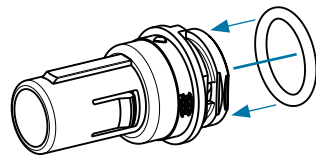
Assembly Break-Away Plug Size 1

Right-angled version



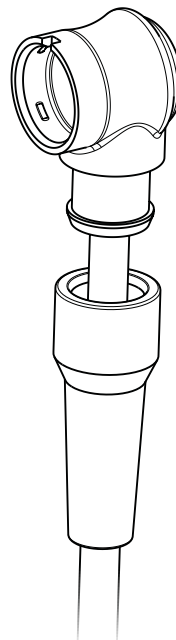
Step 1

- Push O-ring on plug.



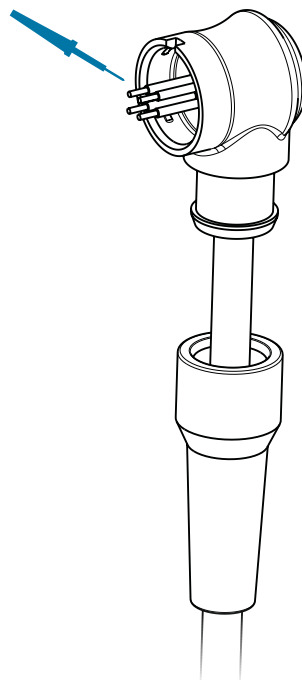
Step 2

- Slide the cable bend relief and right-angled cap over the cable.



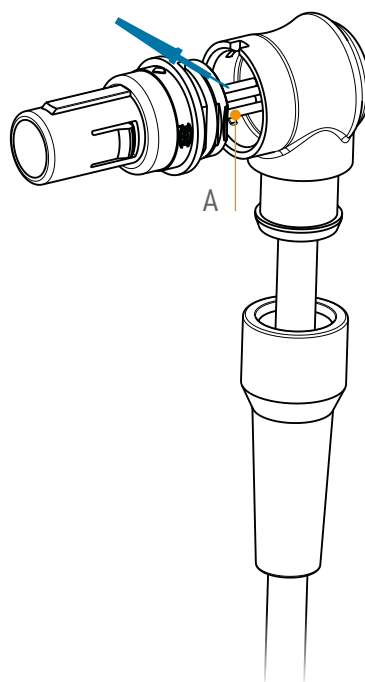
Step 3

- ▶ Strip cable and wire (see page 3).
- ▶ Pre-tin strands.



Step 4

- ▶ Solder the litz wires (A) according to contact arrangement.



Step 5

- ▶ Push right-angled housing onto plug.

ATTENTION!

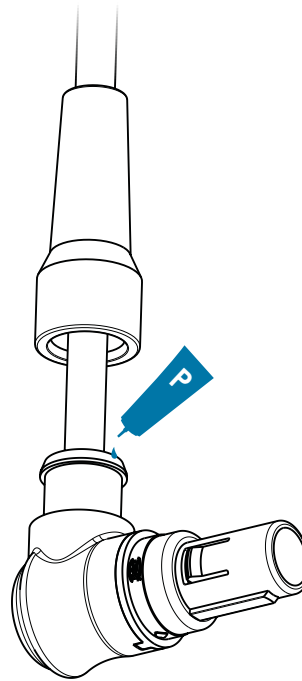
Consider position of codings.

- ▶ For strain relief, cast the connection area with potting material.

Recommendation of ODU:

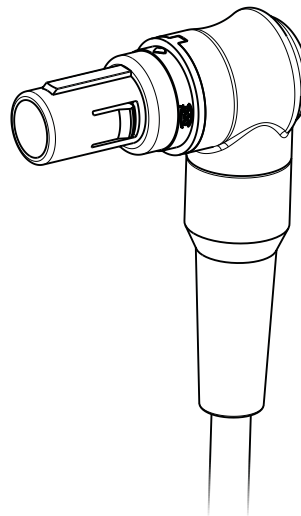
WEVO PU552FL

- ▶ Adhesion to cable sheathing must be checked by the manufacturer of the cable assembly.

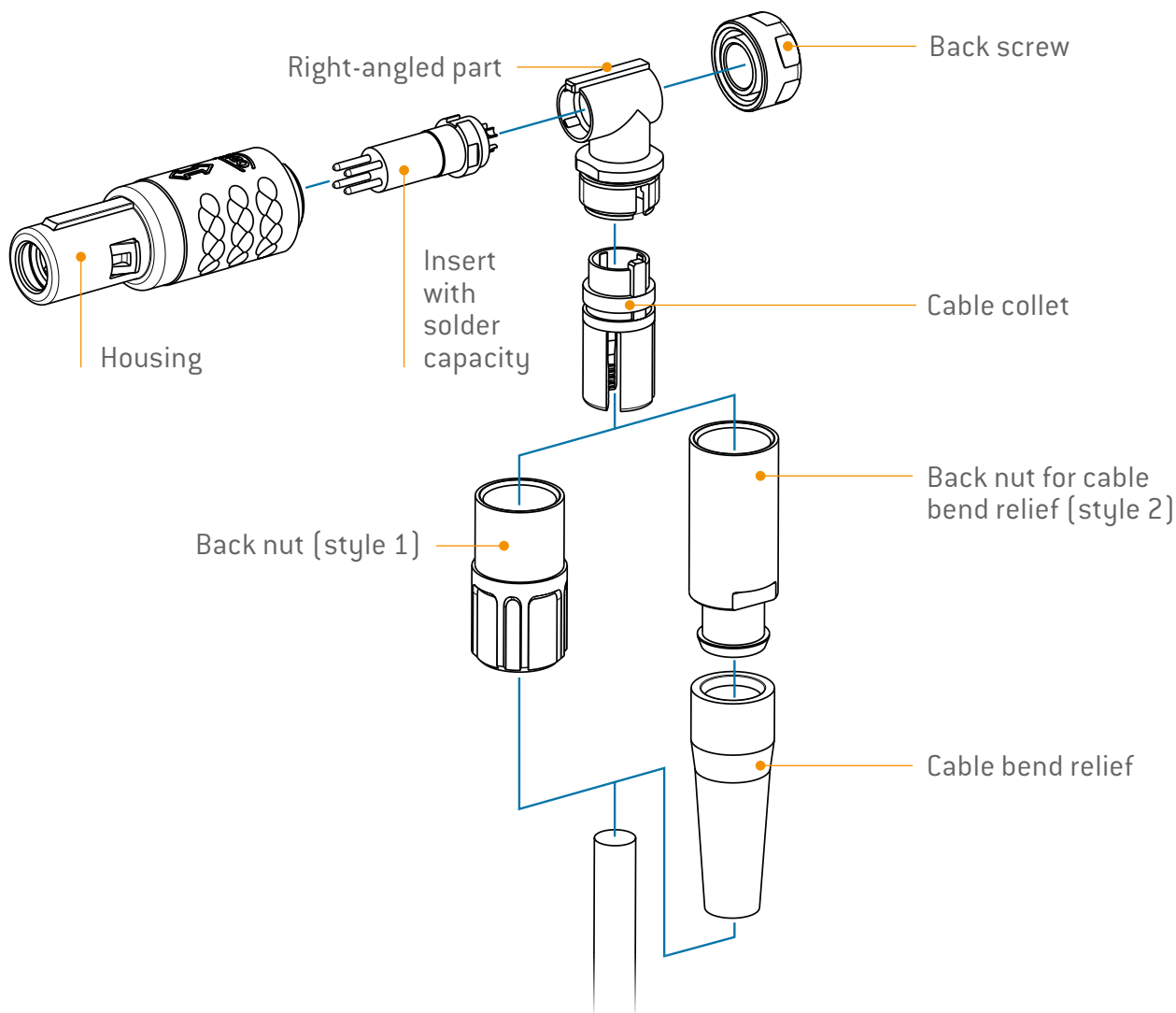


Step 6

- ▶ Push cable bend relief over right-angled cap.



Assembly Right-Angled Plug Size 1

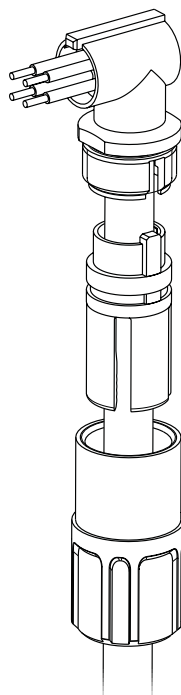


Step 1

- Strip cable and wire (see page 3).

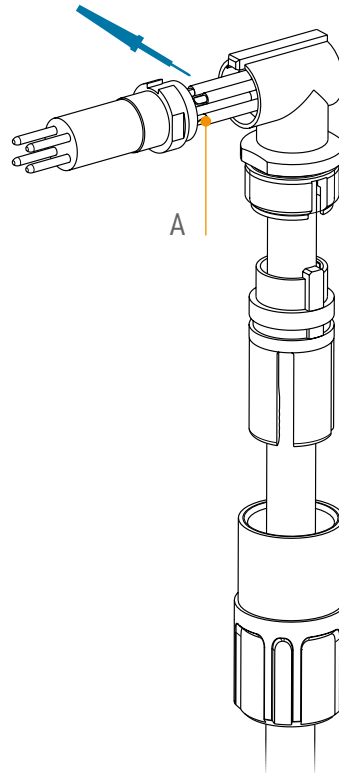
Step 2

- Slide back nut, cable collet and right-angled part over the cable.



Step 3

- Pre-tin strands.



Step 4

- Solder the litz wires (A) according to contact arrangement.

Recommended cleaning agent:

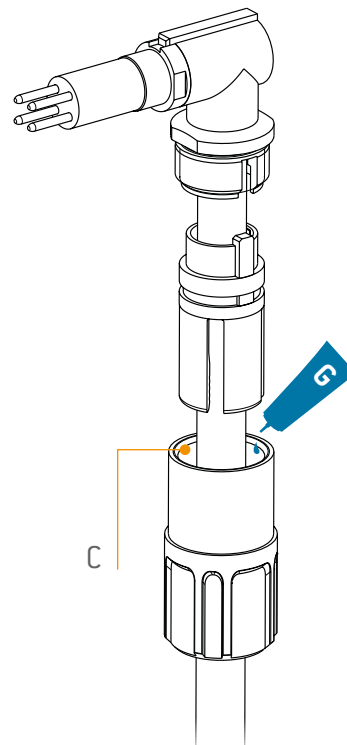
Isopropyl alcohol

Step 5

- Slide the right-angled part against contact insert.

ATTENTION!

Don't damage the contacts.



Step 6

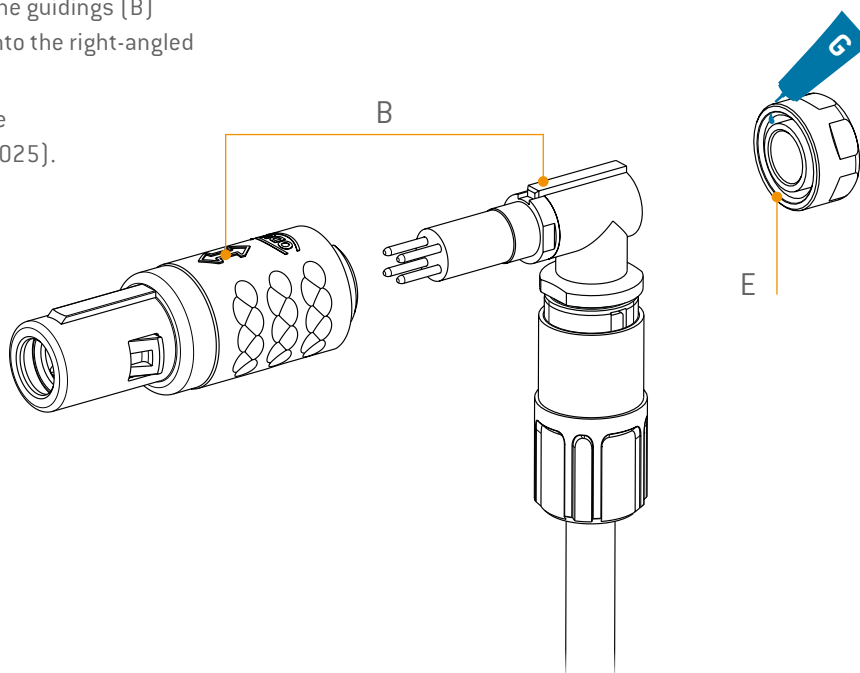
- Slide the cable collet against right-angled part.
- If necessary, secure thread (C) with glue Scotch-Weld DP190 (890.204.000.030.025).

Step 7

- ▶ Slide the assembled cable considering the guidings (B) into the housing. Slide the cable collet into the right-angled part and screw it with the back nut.
- ▶ If necessary, secure thread (E) with glue Scotch-Weld DP190 (890.204.000.030.025).

ATTENTION!

Consider tightening torque (see page 3).

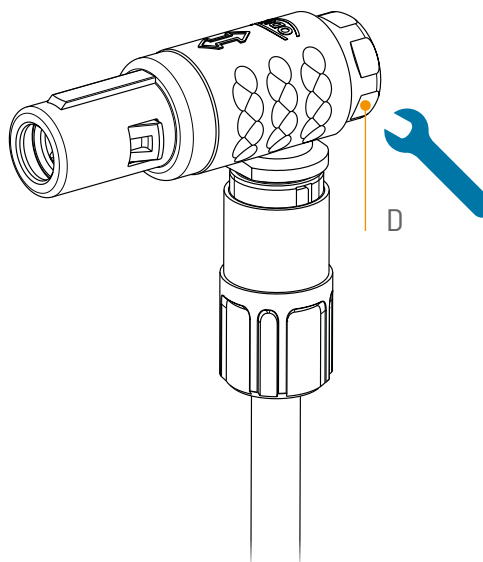


Step 8

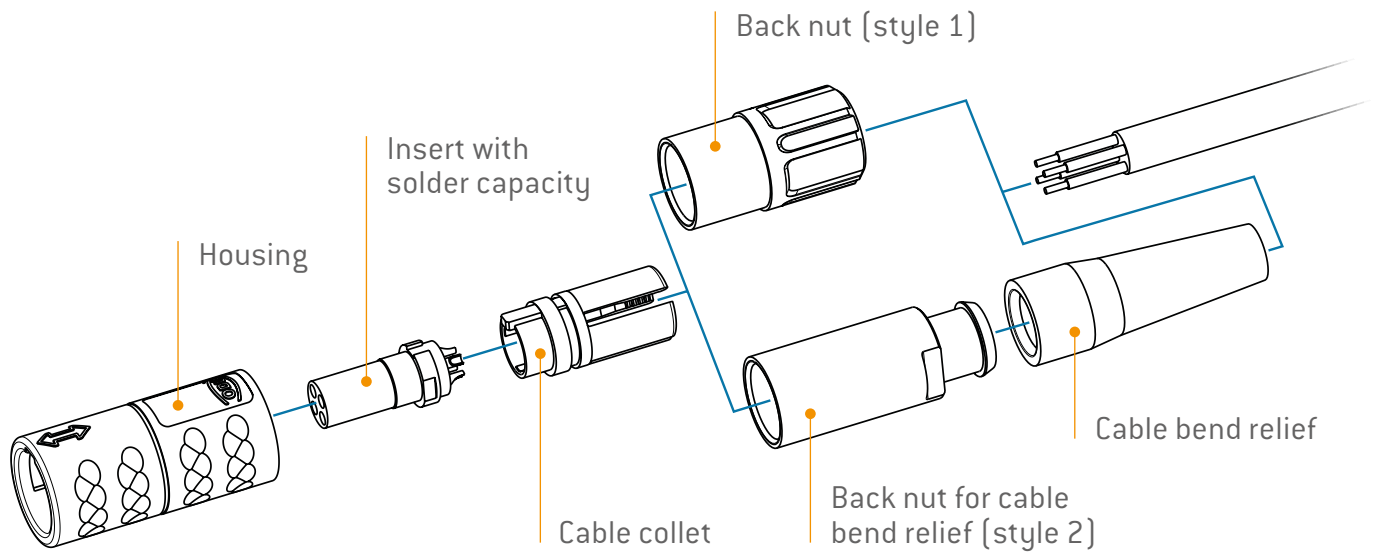
- ▶ Screw back screw on the assembled plug and fasten it with ODU spanner wrench (D).

ATTENTION!

Consider tightening torque (see page 3).

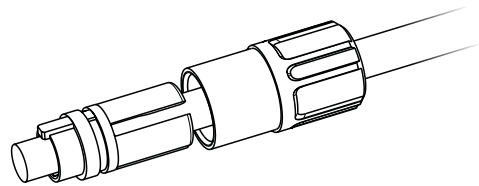


Assembly In-line Receptable Size 1



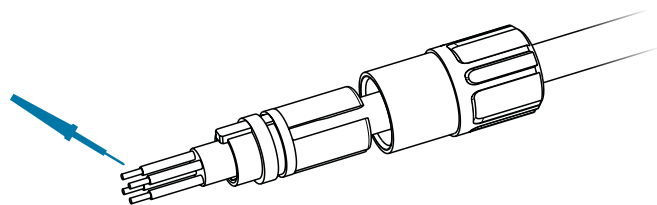
Step 1

- Slide back nut and cable collet over the cable.



Step 2

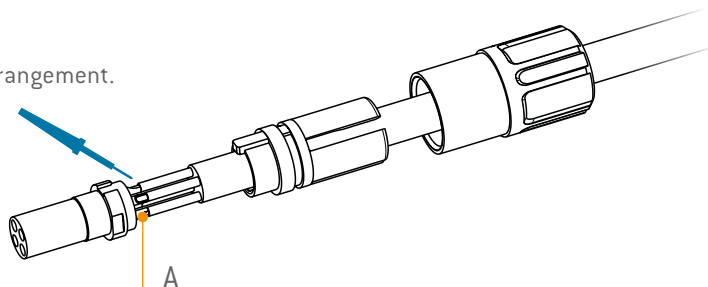
- Strip cable and wire (see page 3).
- Pre-tin strands.



Step 3

- Solder the litz wires (A) according to contact arrangement.

Recommended cleaning agent:
Isopropyl alcohol

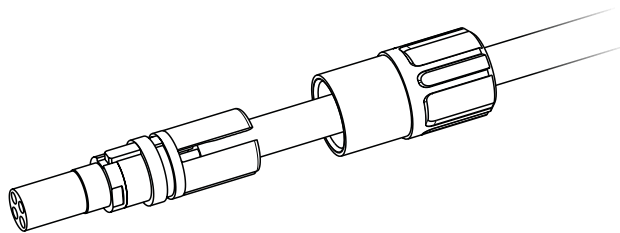


Step 4

- Slide the cable collet against contact insert.

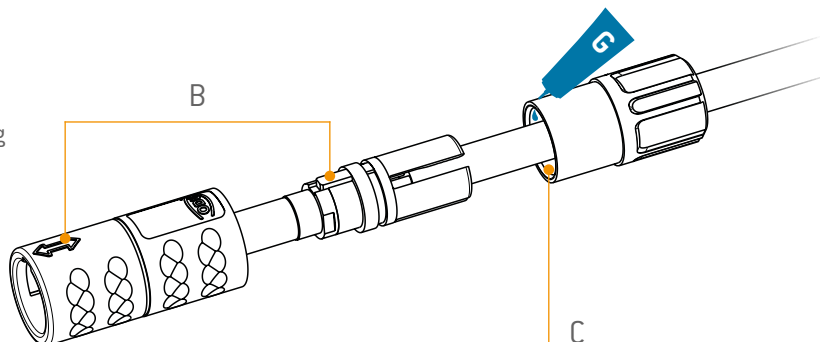
ATTENTION!

Don't damage the contacts.



Step 5

- Put the assembled cable considering the guidings (B) into the housing.
- If necessary, secure thread (C) with glue Scotch-Weld DP190 [890.204.000.030.025].

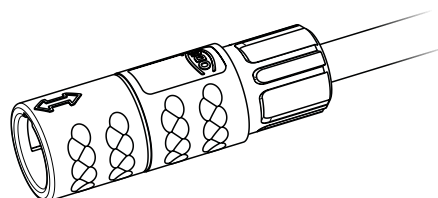


Step 6

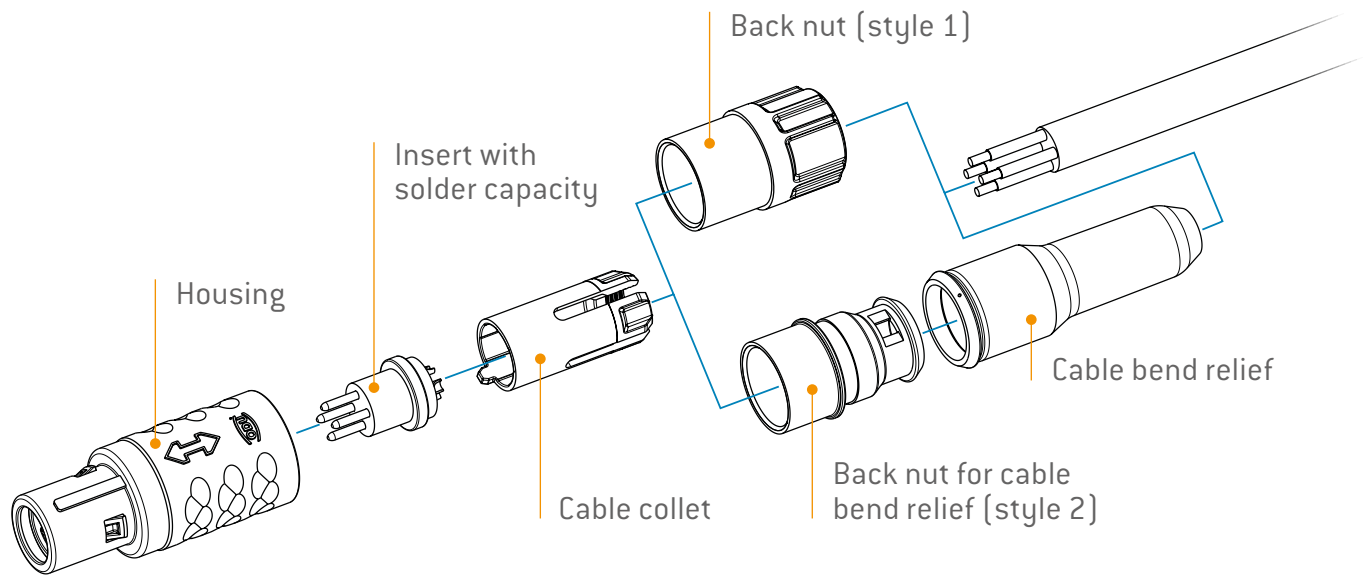
- Screw and fasten back nut on the assembled in-line receptacle.

ATTENTION!

Consider tightening torque (see page 3).

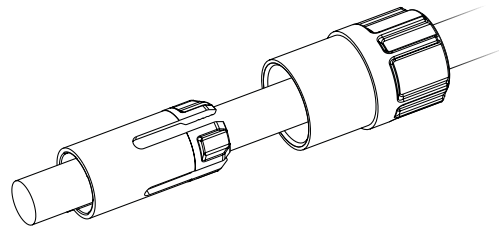


Assembly Straight Plug Size 2



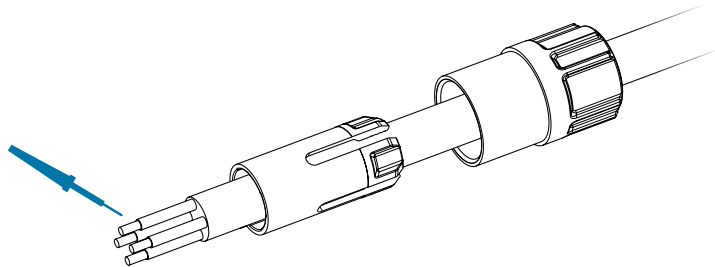
Step 1

- Slide back nut and cable collet over the cable.



Step 2

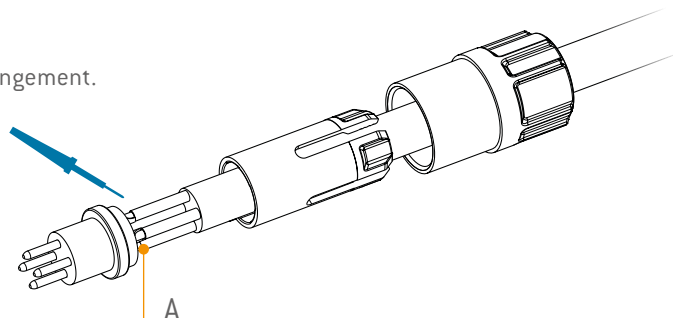
- Strip cable and wire (see page 3).
- Pre-tin strands.



Step 3

- Solder the litz wires (A) according to contact arrangement.

Recommended cleaning agent:
Isopropyl alcohol

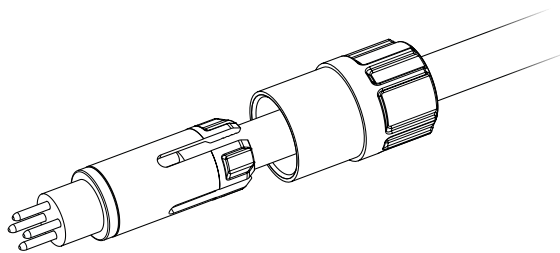


Step 4

- Slide the cable collet against contact insert.

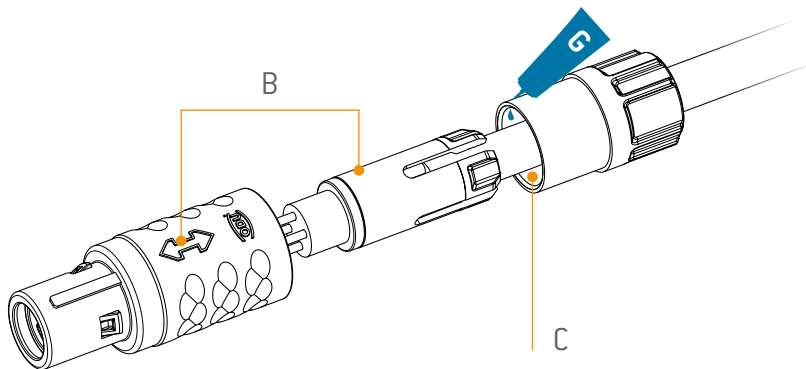
ATTENTION!

Don't damage the contacts.



Step 5

- Put the assembled cable considering the guidings (B) into the housing.
- If necessary, secure thread (C) with glue Scotch-Weld DP190 [890.204.000.030.025].

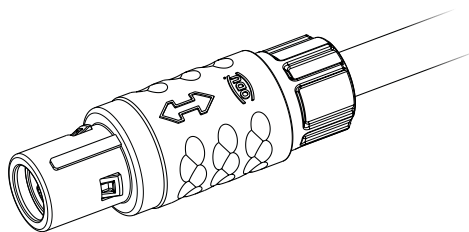


Step 6

- Screw and fasten back nut on the assembled in-line receptacle.

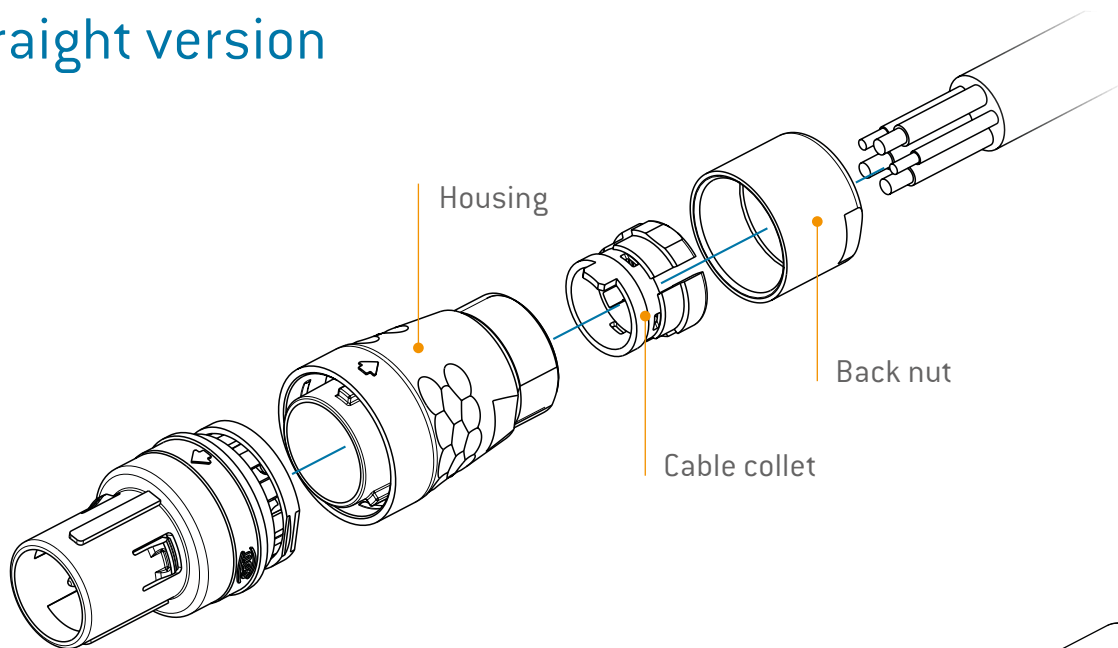
ATTENTION!

Consider tightening torque (see page 3).



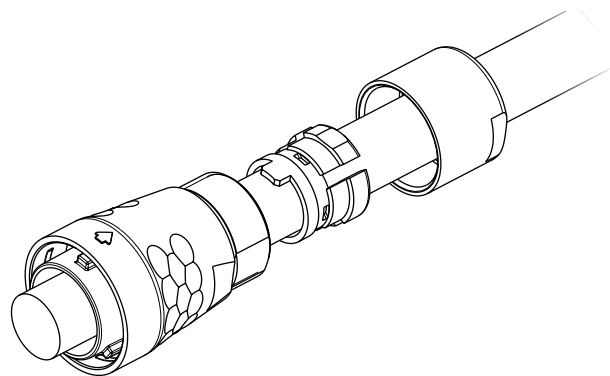
Assembly Break-Away Plug Size 2

Straight version



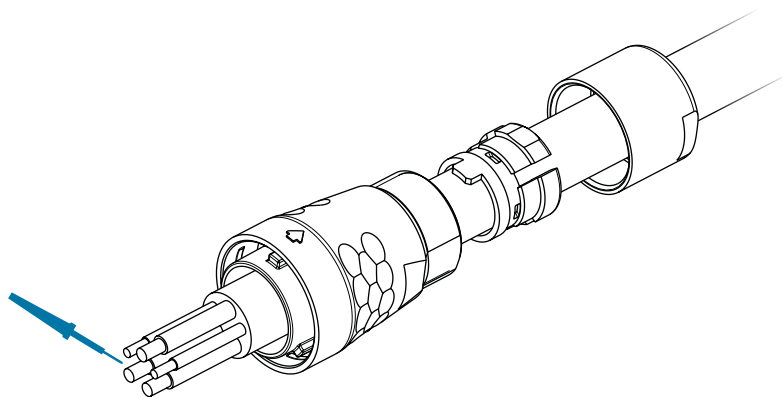
Step 1

- Slide back nut, cable collet and housing over the cable.



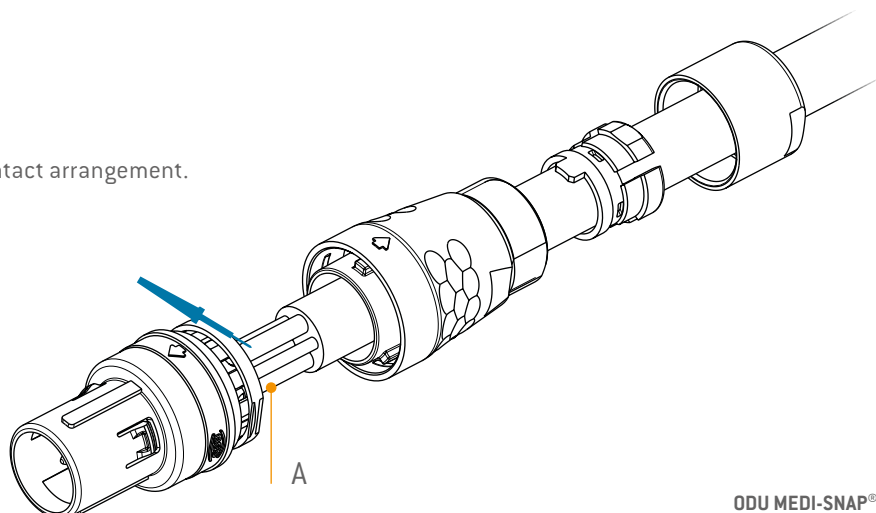
Step 2

- Strip cable and wire [see page 3].
- Pre-tin strands.



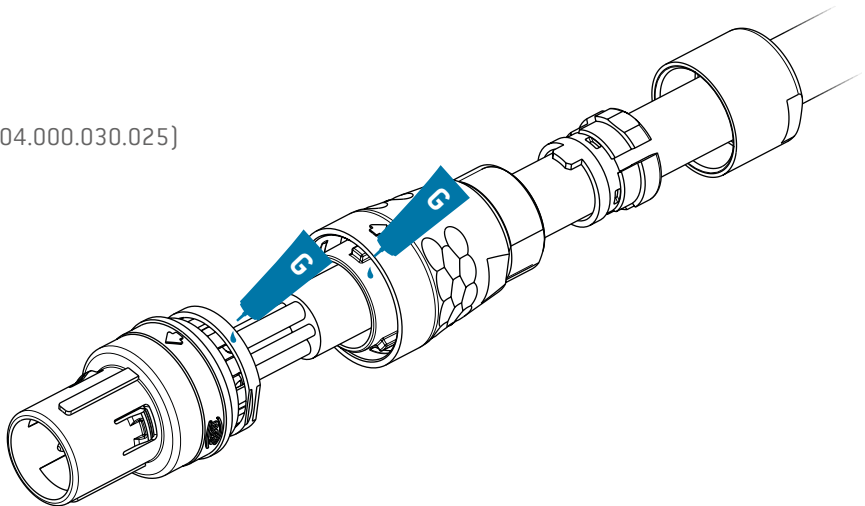
Step 3

- Solder the litz wires [A] according to contact arrangement.



Step 4

- ▶ Apply glue Scotch-Weld DP 190 (890.204.000.030.025) in the glue area.



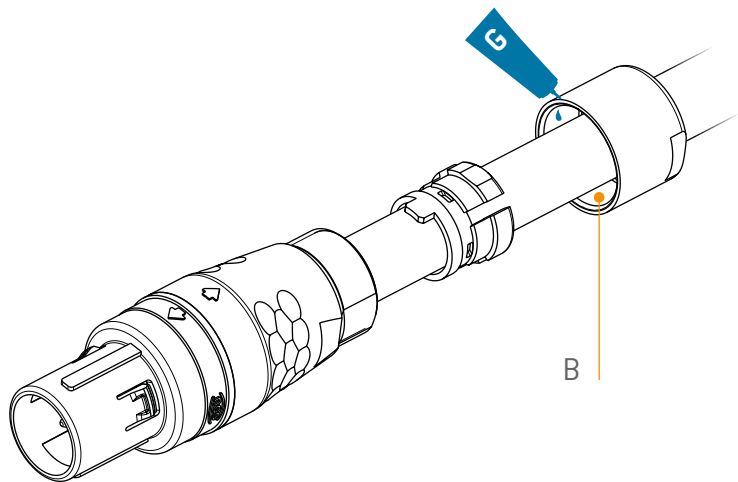
Step 5

- ▶ Push housing onto plug without a gap.

ATTENTION!

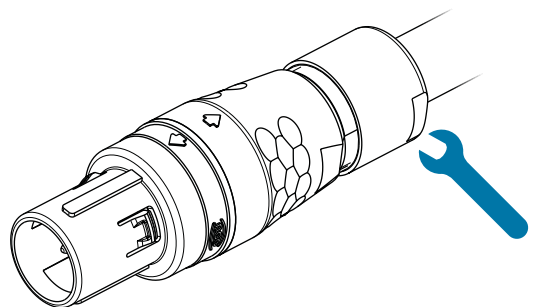
Consider position of arrows.

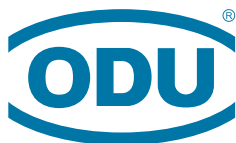
- ▶ If necessary, secure thread [B] with glue Scotch-Weld DP190 (890.204.000.030.025).



Step 6

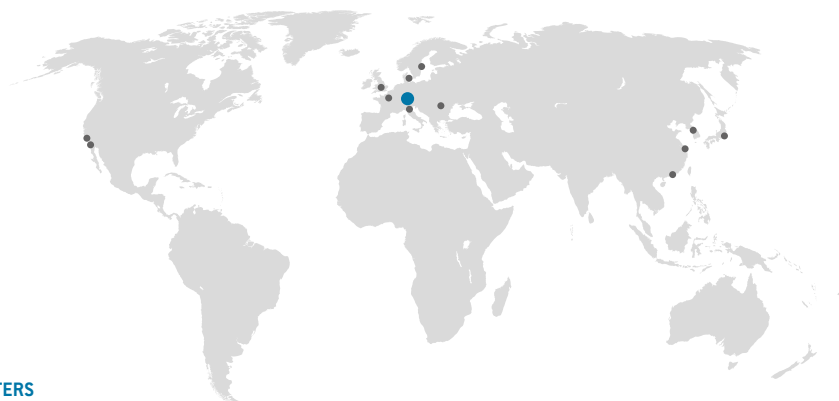
- ▶ Slide the cable collet in the housing.
- ▶ Slide the back nut over the back shell and tighten it with **0.5 Nm**.





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ODU GROUP WORLDWIDE



HEADQUARTERS

ODU GmbH & Co. KG

Pregelstraße 11, 84453 Mühldorf a. Inn, Germany

Phone: +49 8631 6156-0, Fax: +49 8631 6156-49, E-mail: sales@odu.de

SALES LOCATIONS

ODU (Shanghai)

International Trading Co., Ltd.

Phone: +86 21 58347828-0

E-mail: sales@odu.com.cn

www.odu.com.cn

ODU Italia S.R.L.

Phone: +39 331 8708847

E-mail: sales@odu-italia.it

www.odu-italia.it

ODU Scandinavia AB

Phone: +46 176 18262

E-mail: sales@odu.se

www.odu.se

ODU (HK) Trading Co., Ltd.

Phone: +852 5439-9036

E-mail: sales@odu.hk

www.odu.hk

ODU Japan K.K.

Phone: +81 3 6441 3210

E-mail: sales@odu.co.jp

www.odu.co.jp

ODU-UK Ltd.

Phone: +44 330 002 0640

E-mail: sales@odu-uk.co.uk

www.odu-uk.co.uk

ODU Denmark ApS

Phone: +45 2233 5335

E-mail: sales@odu-denmark.dk

www.odu-denmark.dk

ODU Korea Inc.

Phone: +82 2 6964 7181

E-mail: sales@odu-korea.kr

www.odu-korea.kr

ODU-USA Inc.

Phone: +1 805 484-0540

E-mail: sales@odu-usa.com

www.odu-usa.com

ODU-France SARL

Phone: +33 1 3935-4690

E-mail: sales@odu.fr

www.odu.fr

ODU Romania Manufacturing SRL

Phone: +40 269 704638

E-mail: sales@odu-romania.ro

www.odu-romania.ro

Further information and specialized representatives can be found at:

www.odu-connectors.com/contact

PRODUCTION AND LOGISTICS SITES

Germany Otto Dunkel GmbH

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