



ODU Heavy Duty Connector Assembly Guidelines

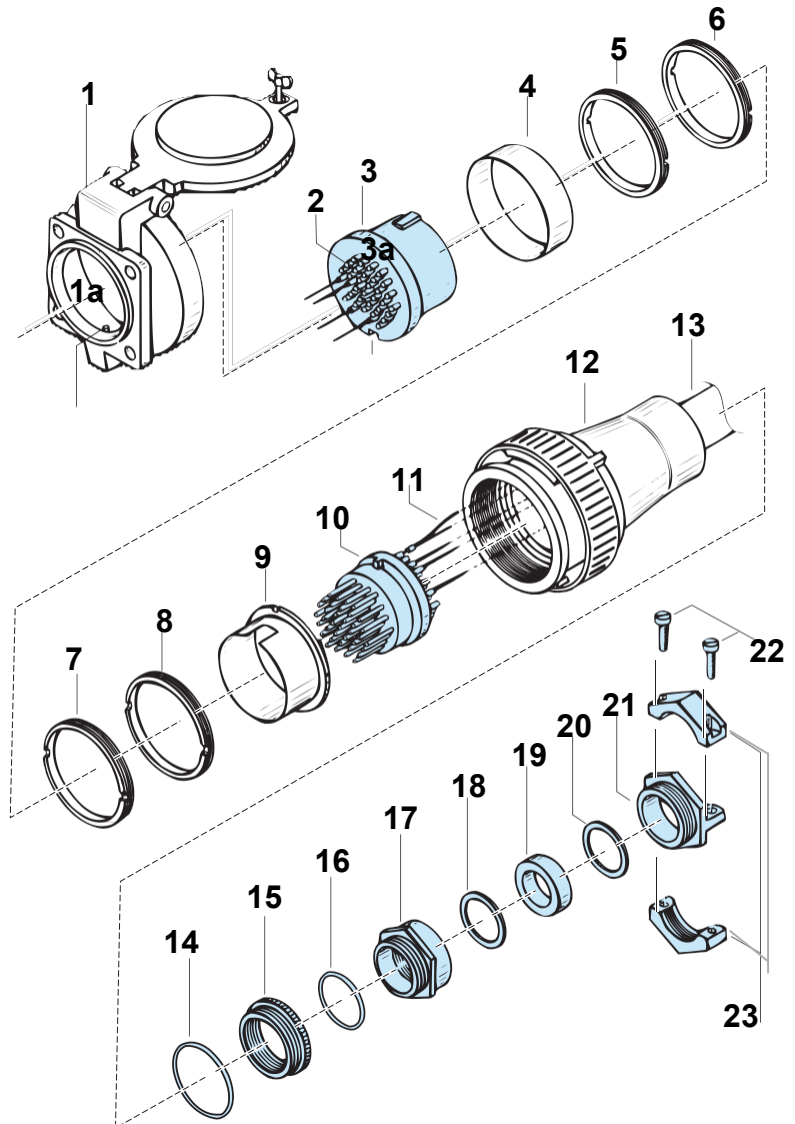
Series 308, 309 and 310 Assembly Instructions

Parts Description	
1.	Receptacle Housing
2.	Contacts
3.	Socket Insert
4.	Spacer Ring
5-8	Threaded Ring
9.	Guide Ring (only for unprotected pins)
10.	Pin Insert
11.	Ground Cable
12.	Plug Housing
13.	Cable
14-23	Cable Clamp



For Series	Part Number for Assembly Key
308	308.098.001.719.000
309	309.098.000.719.000
310	310.098.001.719.000

= order separately



Assembly of Receptacle	
1.	Push stripped conductors through receptacle (1).
2.	Solder conductors to contacts (2)
3.	Either socket or pin Insert (3) into Receptacle (1): important, Pin (1a) must snap into groovet (3a)
4.	With Socket Insert spacer ring (4) must be used.
5.	Fasten threaded ring (5,6) with assembly tool.

Assembly of Plug	
1.	Push cable clamp (14-23) and plug housing (12) over Cable (13)
2.	Connect ground strap (11) to ground cable (13)
3.	Solder stripped conductors to contacts
4.	Mount either pin over socket insert (10) into plug housing (12), important: Pin (1a) must snap into groovet (3a).
5.	With pin Insert guide ring (9) on insert (10). Watch out for keying!
6.	Fasten threaded ring (7,8) with assembly tool.
7.	Connect cable clamp (14 to 23)



ODU Heavy Duty Connector Assembly Guidelines

1.	Strip insulation on wires back 5-6mm (approx.)
2.	Fit heatshrink insulation to wire before soldering and push past bare wire by 25mm
3.	Pre tin bare wires before soldering
4.	Solder using a solder tip matched to the size of the wire and solder bucket
5.	If soldering wires greater than 6mm Square and using a blow torch take the plastic cap that came with the insert and fill it with water as shown below. Place the insert in the cap and solder to control the temperature of the insert whilst soldering.
6.	Place the insert in the cap and solder to control the temperature of the insert whilst soldering.

Instruction about blowtorch soldering > 6mm²

During heat-stress the contact-elements on the insulating materials can also be damaged
(Limit temperature 120°C)

Remedy: Put the inserts into the water. (If possible, distilled water)

Recommended water level



Attention! Warmed water at 35°C must be renewed.
After the Solder process the connector has to be carefully dried