

BF-WI-ENG-013/02 Issue 03	Amphenol	IMPORTANT	RN/ECN	Issue	Page	Test
Printed 20 November 2024	PROCESS SPECIFICATION	Check you are using the latest issue of this form	RN 11895	1	1 of 2	

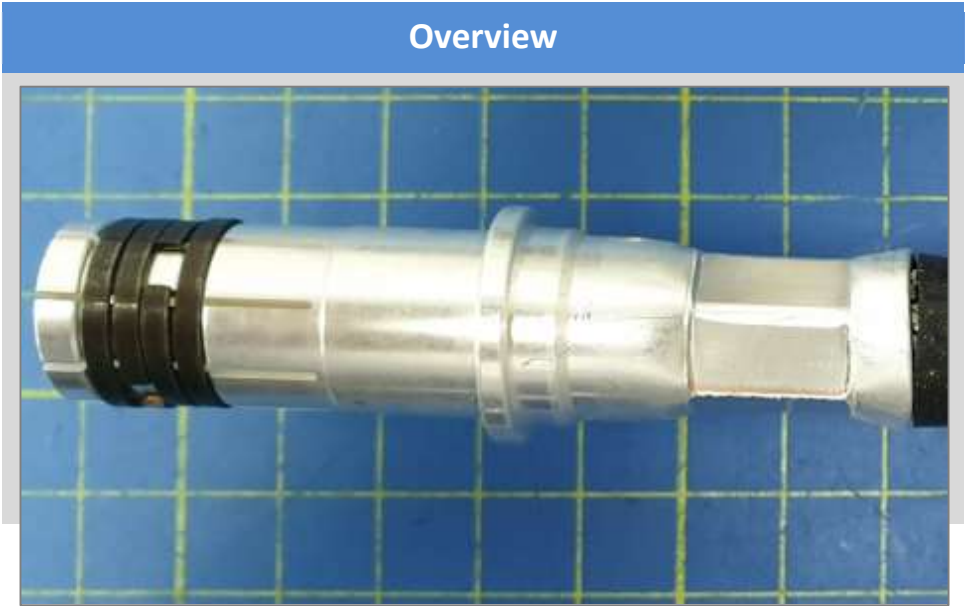
Document:	123GB-0929
Description:	Raptor crimp instruction

**** FOLLOW ALL LOCAL HEALTH AND SAFETY POLICIES ****

Scope
The scope of this document is to describe the crimping process for Raptor contacts.

Relating documents	
Doc no	Doc name
123GB-0952	Raptor plugs assembly instruction
123GB-0953	Raptor receptacles assembly instruction

Document Traceability			
Issue No	RN/ECN no...	Date	Initials
1	RN 11895	25/07/2022	CIC

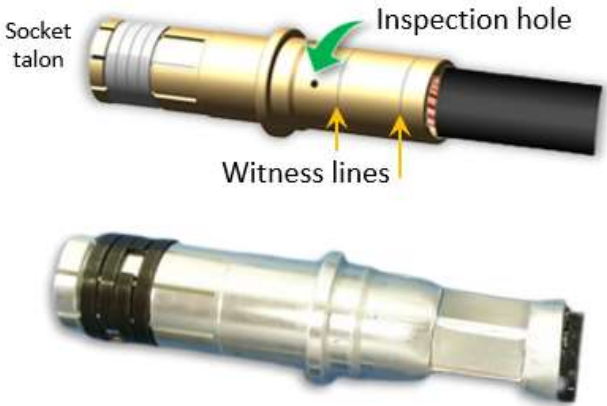
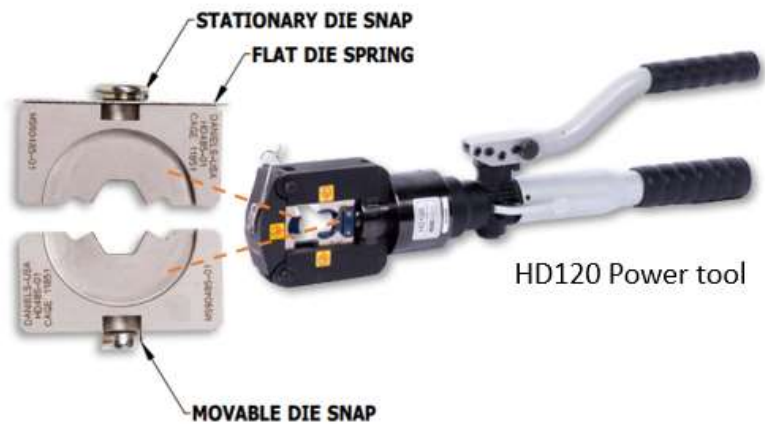


CRIMP CONTACTS

123GB-0929_Raptor crimp instruction

Setup
Select die set and fit onto crimp power tool then strip cable jacket as required (see table)

Single crimp contact
Locate contact onto conductor, make sure the wire strands are visible through the inspection hole and then, place both in the crimp tool so the die jaws are trapping the contact between the witness lines present on the outside of the crimp barrel Press and hold button/handle until the crimp tool is fully closed and releases the contact



Connector	Barrel size	Cable	Power tool	Die set	Strip length
PN	ID	AWG	DMC / Military*	DMC / Military*	mm
RAP-XXxx15-1xXxX	1	4	HD120 / M5259/8-01* Equivalent to TBHD1M / MS25441-1*	HD485-4 / MS90485-4*	22-23
RAP-XXxx17-1xXxX	1	2		HD485-2 / MS90485-2*	24-25
RAP-XXxx19-1xXxX	1	1/0		HD485-01 / MS90485-01*	24-25
RAP-XXxx21-1xXxX	1	2/0		HD485-02 / MS90485-02*	26-27
RAP-XXxx23-1xXxX	1	3/0		HD485-03 / MS90485-03*	30-31
RAP-XXxx25-1xXxX	1	4/0		HD485-04 / MS90485-04*	32-33
				* Primary recommended tooling	

Images for reference only, contact factory for more details