

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	ECN 26283	2	1 of 3	

Document:	123GB-0930
Description:	Raptor torque instruction

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

Scope
The scope of this document is to describe the torquing process for Raptor backshells and panel nuts.

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
2	ECN 26283	30/08/2022	CIC



123GB-0930 – Raptor torque instruction
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TORQUE BACKSHELLS

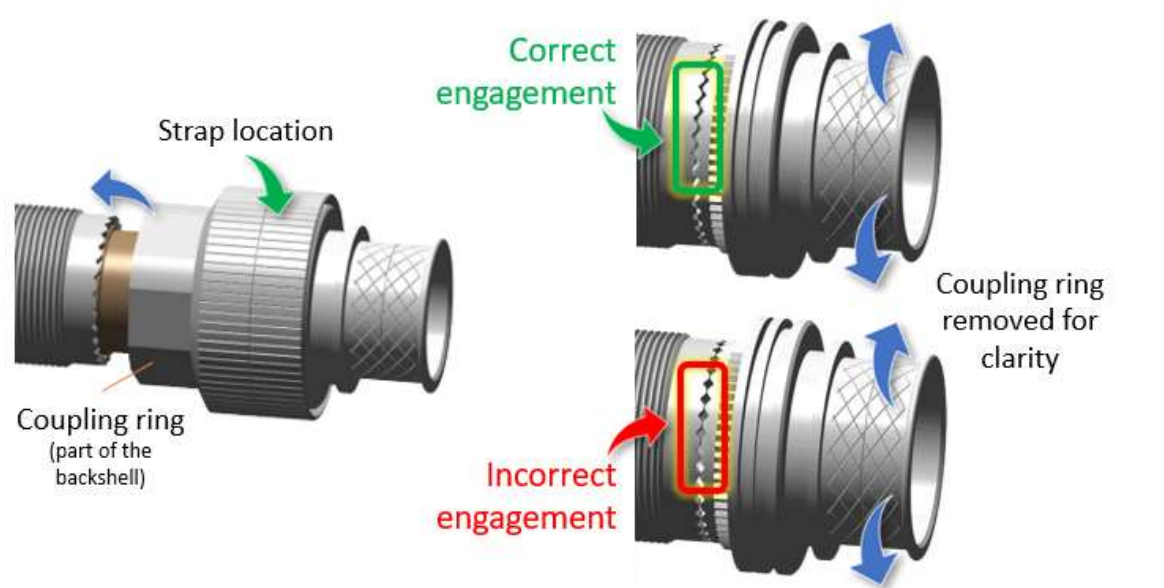
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Fit backshell

Fit backshell over rear thread of connector and make sure the accessory teeth are engaged correctly by rotating the backshell body in both directions until engagement is felt by hand

Torque backshell

Setup components as shown and torque backshell in place using recommended tooling and torque values



Connector	Tooling			Torque
PN	PLUGS (06)	REC's (00,07)	PLUGS/REC's	Nm
RAP-XXxx15-1xXxB	294GB-5081-15X	294GB-5082-15X	Bench vice Strap wrench Torque wrench	18*
RAP-XXxx17-1xXxB	294GB-5081-17X	294GB-5082-17X		18*
RAP-XXxx19-1xXxB	294GB-5081-19X	294GB-5082-19X		18*
RAP-XXxx21-1xXxB	294GB-5081-21X	294GB-5082-21X		20
RAP-XXxx23-1xXxB	294GB-5081-23X	294GB-5082-23X		20
RAP-XXxx25-1xXxB	294GB-5081-25X	294GB-5082-25X		20
X – N, A, B, C, D, E				*Check with ALtd

TORQUE PANEL NUTS

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Fit panel nut

Position connector on the wall/panel then fit panel nut, hand tight, to keep in place

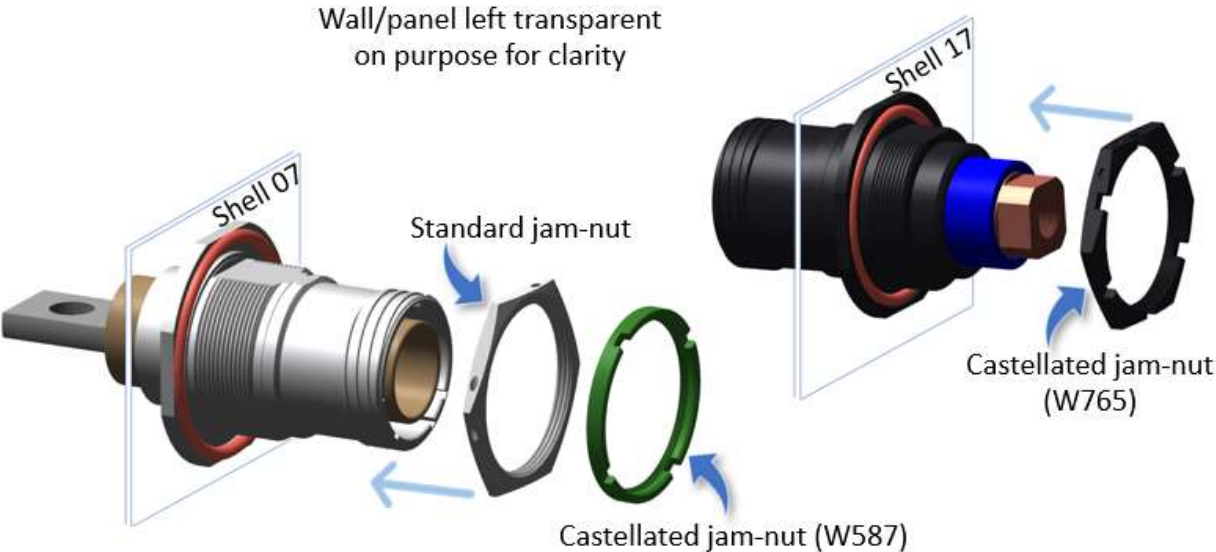
Torque panel nut

For **standard jam-nut**, use of-the-shelf tooling (e.g. spanner, torque wrench, adaptor) and recommended torque values

For **castellated jam-nuts**, use recommended torque values and tooling as shown, apply axial load and ensure tool castellations remain engaged with nut



Images for reference only, contact factory for more details



Connector	Tooling			Torque
PN	REC's (07)	REC's (17)	ALL REC's	Nm
RAP-XXxx15-XxXxX (W...)	294GB-5065-15	294GB-5085-15	Socket adaptor M10 Torque wrench	7.9 - 8.5
RAP-XXxx17-XxXxX (W...)	294GB-5065-17	294GB-5085-17		9.0 - 9.6
RAP-XXxx19-XxXxX (W...)	294GB-5065-19	294GB-5085-19		10.2 - 10.7
RAP-XXxx21-XxXxX (W...)	294GB-5065-21	294GB-5085-21		11.3 - 12.4
RAP-XXxx23-XxXxX (W...)	294GB-5065-23	294GB-5085-23		12.4 - 13.6
RAP-XXxx25-XxXxX (W...)	294GB-5065-25	294GB-5085-25		13.6 - 14.7
	W587 (4*)	W765 (6*)		

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