

BF-WI-ENG-013/02 Issue 03	Amphenol	IMPORTANT	RN/ECN	Issue	Page	Test
Printed 28 July 2022	PROCESS SPECIFICATION	Check you are using the latest issue of this form	RN 11895	1	1 of 2	

Document:	123GB-0952
Description:	Raptor plugs assembly instruction

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

Scope
The scope of this document is to describe the customer assembly process for Raptor plug connectors.

Supporting documents	
Doc no	Doc name
123GB-0929	Raptor crimp instruction
123GB-0930	Raptor torque instruction

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

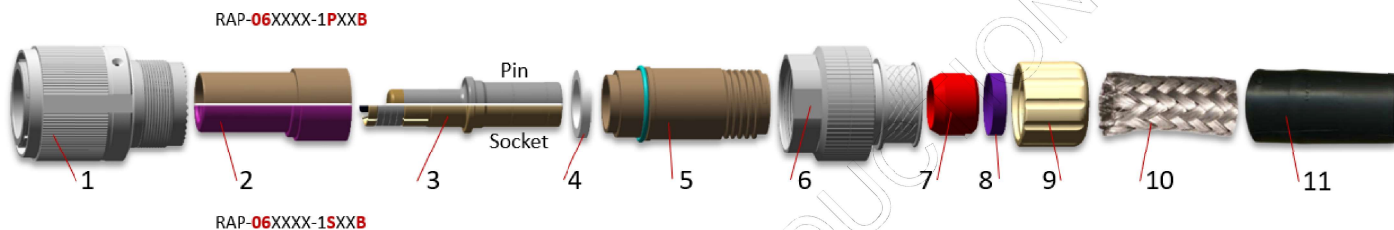
**123GB-0952 – Raptor plugs assembly instruction**

This document and its contents remain the property of Amphenol Ltd. This document contains confidential proprietary information, and shall not be copied, disclosed, reproduced or used for any other purpose; unless written permission is granted by Amphenol Ltd. Amphenol Ltd retains the right to request the prompt return of this document.

BF-WI-ENG-013/02 Issue 03	Amphenol	IMPORTANT	RN/ECN	Issue	Page	Test
Printed 28 July 2022	PROCESS SPECIFICATION	Check you are using the latest issue of this form	RN 11895	1	2 of 2	

PLUG style 06 option B

123GB-0952_Raptor plugs assembly instruction



Connector items:

1. Plug shell-06
2. Front insulator
3. Contact (pin/socket)
4. Compress seal
5. Rear insulator
6. Straight backshell-B
7. Cable seal
8. Cable slip ring
9. Cable nut
10. Braid sock (supplied by customer)
11. H/s boot (supplied by customer)

For screened cable:

- ✓ Fit items 11/10 onto the cable outer jacket
- ✓ Strip outer jacket and trim braid to suit chosen screen termination method

Note: Specific cable diameters will require the outer jacket strip and braid trim lengths to be determined to allow crimping with components 9/8/7/6/5/4 fitted onto the cable

- ✓ Crimp contact (3) as per [123GB-0929](#)
- ✓ Assemble connector as per sequence shown above
- ✓ Backshell (6) to be torqued as per [123GB-0930](#)
- ✓ Cable nut (9) to be fully hand tightened until seal compresses onto cable jacket
- ✓ Braid sock (10) termination is recommended with band straps onto the cable and backshell
- ✓ Heatshrink boot (11) is then recovered over the screen termination and onto the cable outer jacket

For un-screened cable:

- ✓ Fit items 11/9/8/7/6/5/4 onto the cable
- ✓ Crimp contact (3) as per [123GB-0929](#)
- ✓ Assemble connector as per sequence shown above
- ✓ Backshell (6) to be torqued as per [123GB-0930](#)
- ✓ Cable nut (9) to be fully hand tightened until seal compresses onto cable jacket
- ✓ Heatshrink boot (11) is then recovered over the screen termination and onto the cable outer jacket

Images for reference only, contact factory for more details, items 10 and 11 are options only and dependant on customer final application

123GB-0952 – Raptor plugs assembly instruction

This document and its contents remain the property of Amphenol Ltd. This document contains confidential proprietary information, and shall not be copied, disclosed, reproduced or used for any other purpose; unless written permission is granted by Amphenol Ltd. Amphenol Ltd retains the right to request the prompt return of this document.