

Amphenol

PROCESS INSTRUCTION

Number: 123GB-0845

Issue: 8

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123GB-0845 'Rhino Torque Setting'.

Key Points with reference to this assembly.

1. This document details all torque values for Rhino Product Range.
2. Unless specified on deviation drawing, please adhere to standard process (tightening method / torque value).
3. Dependant on the environmental conditions and the application the connectors will be subjected to, there may be a necessity to apply an appropriate thread lock adhesive before fitting locking ring to the rear of the connector. Please contact factory for further advice.
4. Refer to the catalogue for part number breakdown.
5. This document covers different accessory type.
See the next page for variant types and reference views.
6. Tooling supplied separate.

List of Process Documents used in this PI

List of Tools used in this PI

	Strap Wrench (torque setting)
294GB-5063-XX	90° Pin Contact Tightening
294GB-5064-XX	90° Skt Contact Tightening
294GB-5065-XX	Castellated Jam Nut Tightening
294GB-5066-XX	90° Skt Contact (legacy) Tightening
	<i>XX refers to connector shell size</i>

Release / Changes:	ECN24869	ECN22005	ECN22057	ECN22119	ECN22181	ECN22485	ECN23675
Originator:	I Quinney	J Turnbull	J Turnbull	J Turnbull	J Turnbull	J Turnbull	T Whitnell
Date:	31/01/2020	6/10/14	25/11/14	19/01/15	26/02/15	23/10/15	09/03/18

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Amphenol**PROCESS INSTRUCTION**

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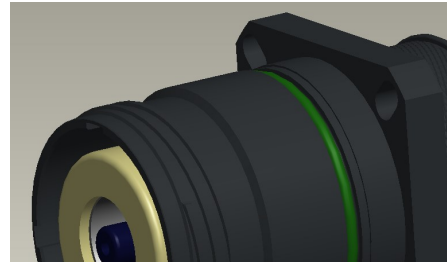
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**Rhino Connectors****Reference views.****WPTV-00XXXX-XXX-XPXA
Pin variant***General assembled view/s of the assembly, for reference.***WPTV-00XXXX-XXX-XSXA
Socket variant***General assembled view/s of the assembly, for reference.***Reference views.****WPTV-00XXXX-XXX-XPXB
Pin variant***General assembled view/s of the assembly, for reference.***WPTV-00XXXX-XXX-XSXB
Socket variant***General assembled view/s of the assembly, for reference.*

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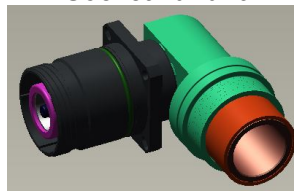
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Reference views.

WPTV-00XXXX-XXX-XPXC**Pin variant***General assembled view/s of the assembly, for reference.***WPTV-00XXXX-XXX-XSXC****Socket variant***General assembled view/s of the assembly, for reference.*

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OP 10. Torque Requirements

The sections below detail the connector type, situation and relevant torque / tool information for all Rhino Connectors in the standard Product Range

OP 11a. Plug (all styles / genders) Plain Backshell. WPTV-06xxXX-XXX-XxXA variant.

Part Numbers	Tools		Torque Value
WPTV-06xx13-85-XxXA	Strap Wrench	294GB-5069-13-X	12.2 Nm
WPTV-06xx15-120-XxXA	Strap Wrench	294GB-5069-15-X	13.1 Nm
WPTV-06xx17-185-XxXA	Strap Wrench	294GB-5069-17-X	13.1 Nm
WPTV-06xx21-340-XxXA	Strap Wrench	294GB-5069-21-X	15.4 Nm
WPTV-06xx23-500-XxXA	Strap Wrench	294GB-5069-23-X	15.4 Nm
WPTV-06xx25-1000-XxXA	Strap Wrench	294GB-5069-25-X	15.4 Nm



OP 11b. Rec (all styles / genders) Plain Backshell WPTV-XXxxXX-XXX-XxXA variant.

Part Numbers	Tools		Torque Value
WPTV-XXxx13-85-XxXA	Strap Wrench	294GB-5070-13-X	12.2 Nm
WPTV-XXxx15-120-XxXA	Strap Wrench	294GB-5070-15-X	13.1 Nm
WPTV-XXxx17-185-XxXA	Strap Wrench	294GB-5070-17-X	13.1 Nm
WPTV-XXxx21-340-XxXA	Strap Wrench	294GB-5070-21-X	15.4 Nm
WPTV-XXxx23-500-XxXA	Strap Wrench	294GB-5070-23-X	15.4 Nm
WPTV-XXxx25-1000-XxXA	Strap Wrench	294GB-5070-25-X	15.4 Nm



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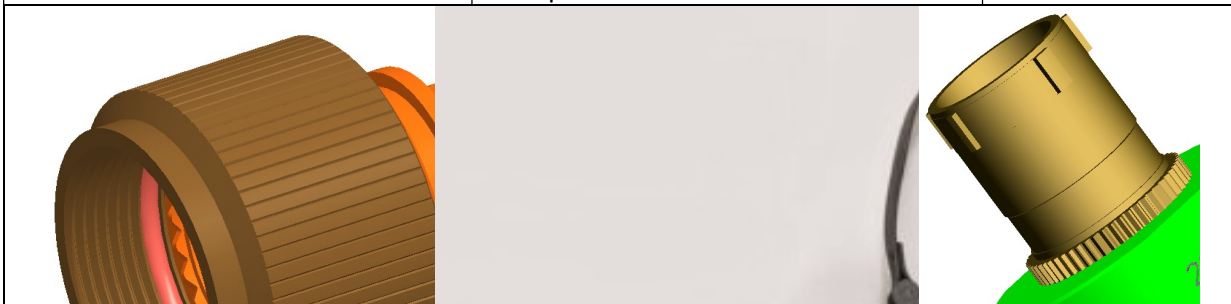


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OP 12a.	Plug (all styles / genders) Straight Backshell WPTV-06xxXX-XXX-XxXB variant.		
Part Numbers	Tools		Torque Value
WPTV-06xx13-85-XxXB	Strap Wrench	294GB-5069-13-X	12.2 Nm
WPTV-06xx15-120-XxXB	Strap Wrench	294GB-5069-15-X	13.1 Nm
WPTV-06xx17-185-XxXB	Strap Wrench	294GB-5069-17-X	13.1 Nm
WPTV-06xx21-340-XxXB	Strap Wrench	294GB-5069-21-X	15.4 Nm
WPTV-06xx23-500-XxXB	Strap Wrench	294GB-5069-23-X	15.4 Nm
WPTV-06xx25-1000-XxXB	Strap Wrench	294GB-5069-25-X	15.4 Nm



OP 12b.	Rec (all styles / genders) Straight Backshell WPTV-XXxxXX-XXX-XxXB variant.		
Part Numbers	Tools		Torque Value
WPTV-XXxx13-85-XxXB	Strap Wrench	294GB-5070-13-X	12.2 Nm
WPTV-XXxx15-120-XxXB	Strap Wrench	294GB-5070-15-X	13.1 Nm
WPTV-XXxx17-185-XxXB	Strap Wrench	294GB-5070-17-X	13.1 Nm
WPTV-XXxx21-340-XxXB	Strap Wrench	294GB-5070-21-X	15.4 Nm
WPTV-XXxx23-500-XxXB	Strap Wrench	294GB-5070-23-X	15.4 Nm
WPTV-XXxx25-1000-XxXB	Strap Wrench	294GB-5070-25-X	15.4 Nm



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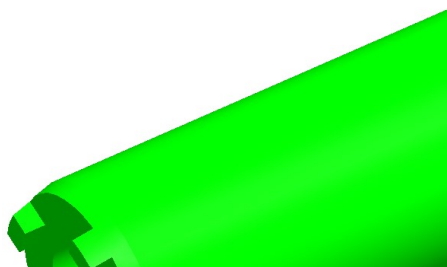
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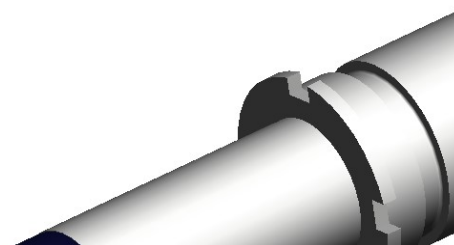
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**OP 13. Rec and Plug (all styles) 90° Backshell Pin
WPTV-XXxxXX-XXX-XPXC variant.**

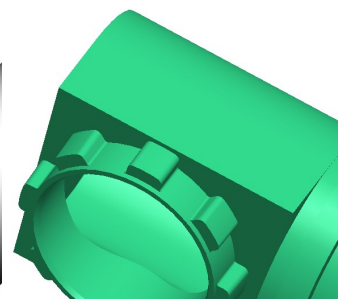
Part Numbers	Tool	Torque Value (Min)	Torque Value (Max)
WPTV-XXxx13-85-XPXC	294GB-5063-13	1.1 Nm	1.9 Nm
WPTV-XXxx15-120-XPXC	294GB-5063-15	3.7 Nm	6.6 Nm
WPTV-XXxx17-185-XPXC	294GB-5063-17	9 Nm	16.2 Nm
WPTV-XXxx21-340-XPXC	294GB-5063-21	17.5 Nm	32.1 Nm
WPTV-XXxx23-500-XPXC	294GB-5063-23	30 Nm	55.7 Nm
WPTV-XXxx25-1000-XPXC	294GB-5063-25	30 Nm	55.7 Nm



Tool



Contact

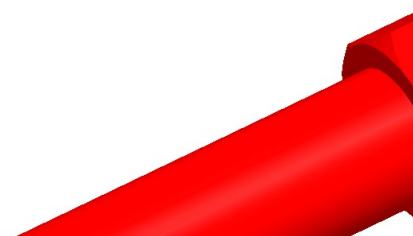


Backshell

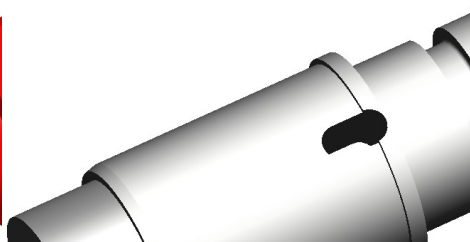
Apply axial load when tightening to specified torque. Ensure tool castellations remain engaged with contact.

**OP 14. Rec and Plug (all styles) 90° Backshell Skt, Current Design
WPTV-XXxxXX-XXX-XSXC variant.**

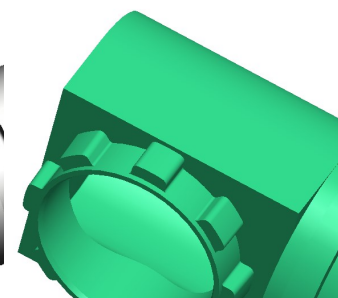
Part Numbers	Tool	Torque Value (MIN)	Torque Value (MAX)
WPTV-XXxx13-85-XSXC	294GB-5064-13	1.1 Nm	1.9 Nm
WPTV-XXxx15-120-XSXC	294GB-5064-15	3.7 Nm	6.6 Nm
WPTV-XXxx17-185-XSXC	294GB-5064-17	9 Nm	16.2 Nm
WPTV-XXxx21-340-XSXC	294GB-5064-21	17.5 Nm	32.1 Nm
WPTV-XXxx23-500-XSXC	294GB-5064-23	30 Nm	55.7 Nm
WPTV-XXxx25-1000-XSXC	294GB-5064-25	30 Nm	55.7 Nm



Tool



Contact



Backshell

Apply axial load when tightening to specified torque. Ensure tool castellations remain engaged with contact.

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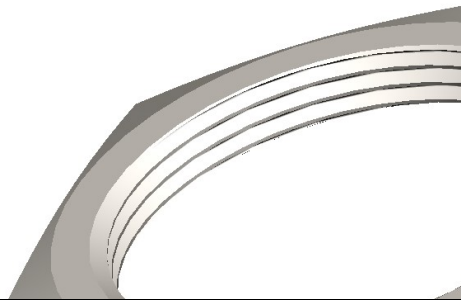
OP 15.

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OP 16.

Rec and Plug (all styles / genders) Jam-Nut WPTV-07xxXX-XXX-XxXx variant.

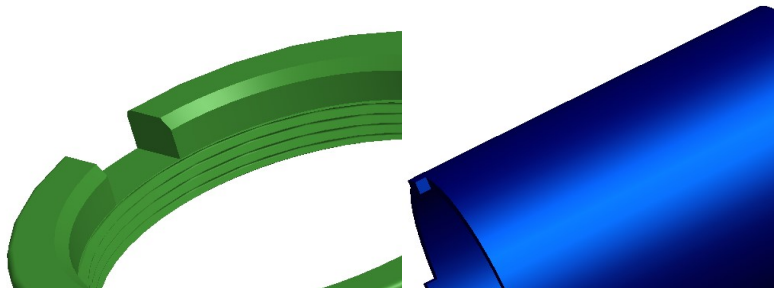
Part Numbers	Tool	Torque Value
WPTV-07xx13-85-XxXx	Customer standard tooling for Jam-Nut assembly e.g. box spanner / torque wrench etc.	6.2/6.8 Nm
WPTV-07xx15-120-XxXx		7.9/8.5 Nm
WPTV-07xx17-185-XxXx		9.0/9.6 Nm
WPTV-07xx21-340-XxXx		11.3/12.4 Nm
WPTV-07xx23-500-XxXx		12.4/13.6 Nm
WPTV-07xx25-1000-XxXx		13.6/14.7 Nm



OP 17.

Rec and Plug (all styles / genders) Castellated Nut WPTV-07xxXX-XXX-XxX(W587) variant.

Part Numbers	Tool	Torque Value
WPTV-07xx13-85-XxXx(W587)	294GB-5065-13	6.2/6.8 Nm
WPTV-07xx15-120-XxXx(W587)	294GB-5065-15	7.9/8.5 Nm
WPTV-07xx17-185-XxXx(W587)	294GB-5065-17	9.0/9.6 Nm
WPTV-07xx21-340-XxXx(W587)	294GB-5065-21	11.3/12.4 Nm
WPTV-07xx23-500-XxXx(W587)	294GB-5065-23	12.4/13.6 Nm
WPTV-07xx25-1000-XxXx(W587)	294GB-5065-25	13.6/14.7 Nm



Apply axial load when tightening to specified torque. Ensure tool castellations remain engaged with nut.

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