

Amphenol

MANUFACTURING INSTRUCTION

Number: 123GB-0840

Issue: 1

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**123GB-0840 refers to product part number family
WPTV-01XXXX-XXX-XXXX**

WPTV-01 style = In-line receptacle.

Key Points with reference to this assembly.

1. Refer to the catalogue for part number breakdown.
2. This document covers different accessory types.
See the next page for variant types and reference views.
3. The backshell of the connectors are supplied loose.
These must be terminated by the user prior to use.

List of Documents used in this spec

123GB-0845	Torque settings & tools
123GB-0846	Crimp settings & tools

List of Tools used in this MI

Torque tools	See document 123GB-0845
Crimp tools	See document 123GB-0846

Release / Changes:	DRAFT A	Issue 1					
Originator:	MSS	JT					
Date:	26/02/14	24/7/14					

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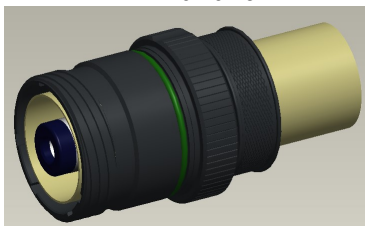
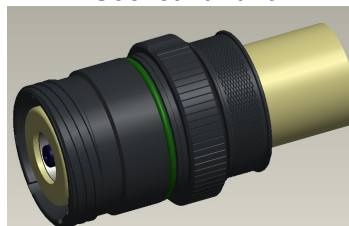
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Reference views.

WPTV-01XXXX-XXX-XPXA
 Pin variant

General assembled view/s of the assembly, for reference.
WPTV-01XXXX-XXX-XSXA
 Socket variant

General assembled view/s of the assembly, for reference.

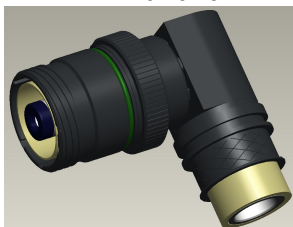
Reference views.

WPTV-01XXXX-XXX-XPXB
 Pin variant

General assembled view/s of the assembly, for reference.
WPTV-01XXXX-XXX-XSXB
 Socket variant

General assembled view/s of the assembly, for reference.

Reference views.

WPTV-01XXXX-XXX-XPXC
 Pin variant

General assembled view/s of the assembly, for reference.
WPTV-01XXXX-XXX-XSXC
 Socket variant

General assembled view/s of the assembly, for reference.

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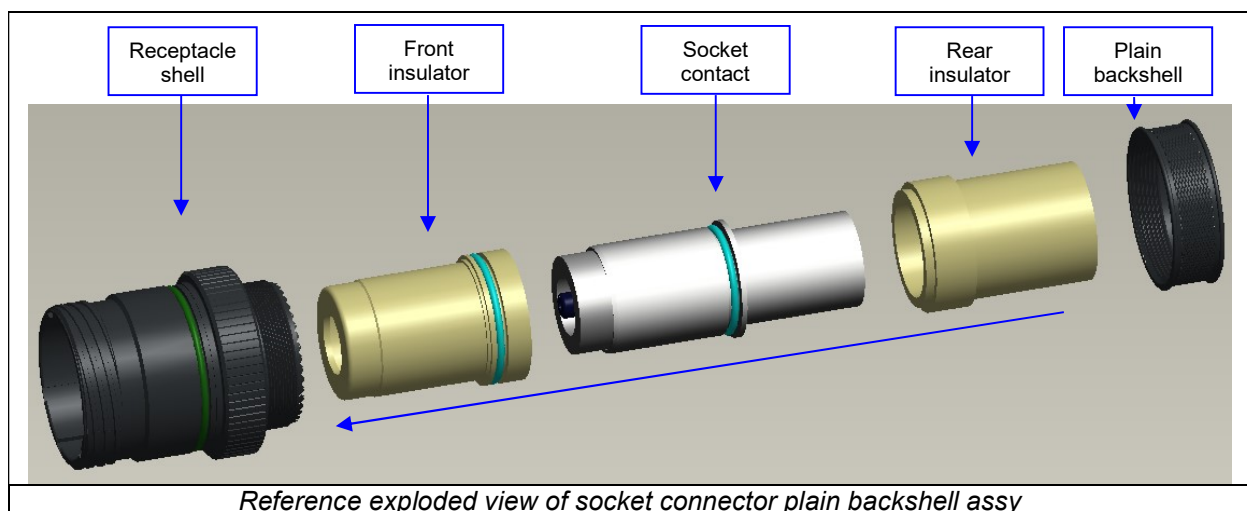
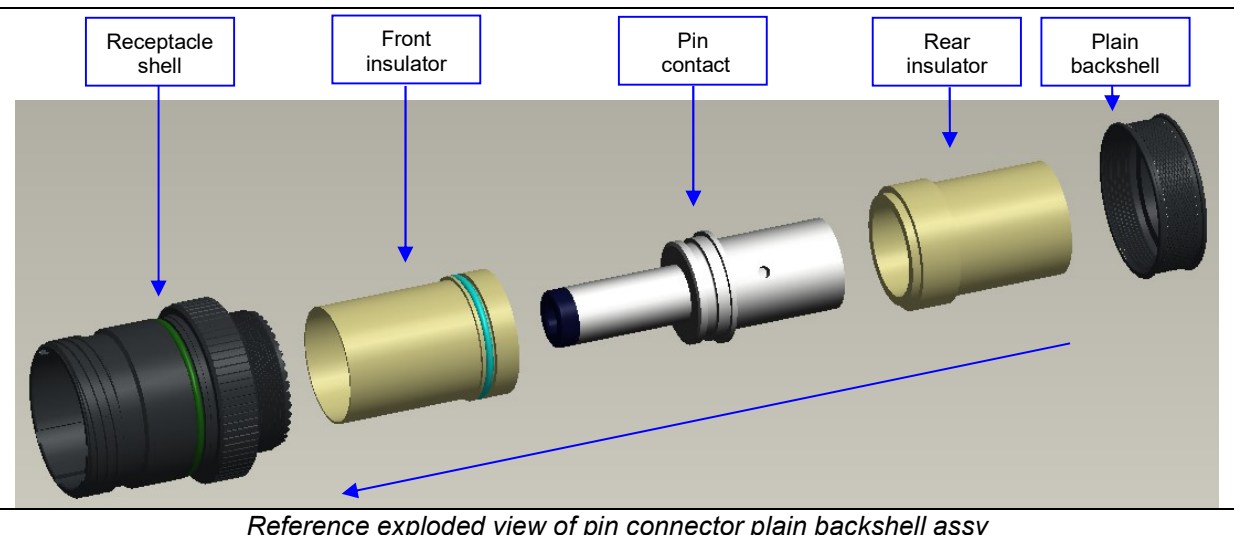
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OP 10.**WPTV-01XXXX-XXX-1XXA variant.***(also WPTV-01XXXX-XXX-6XXA, WPTV-01XXXX-XXX-7XXA, WPTV-01XXXX-XXX-8XXA variants).***Main Steps**

- 1). Unpack the connector. Remove the plain backshell, rear insulator & contact assembly, and retain for assembly later.
 1a). O-rings must be fitted as per illustrations (including suitable grease) for connector to seal.
- 2). Feed the plain backshell then insulator onto the prepared cable and terminate the contact as per document 123GB-0846.
- 3). Assemble the terminated contact into the front insulator in the receptacle shell.
- 4). Assemble the rear insulator over the rear of the contact assembly.
- 5). Secure the plain backshell as per document 123GB-0845.



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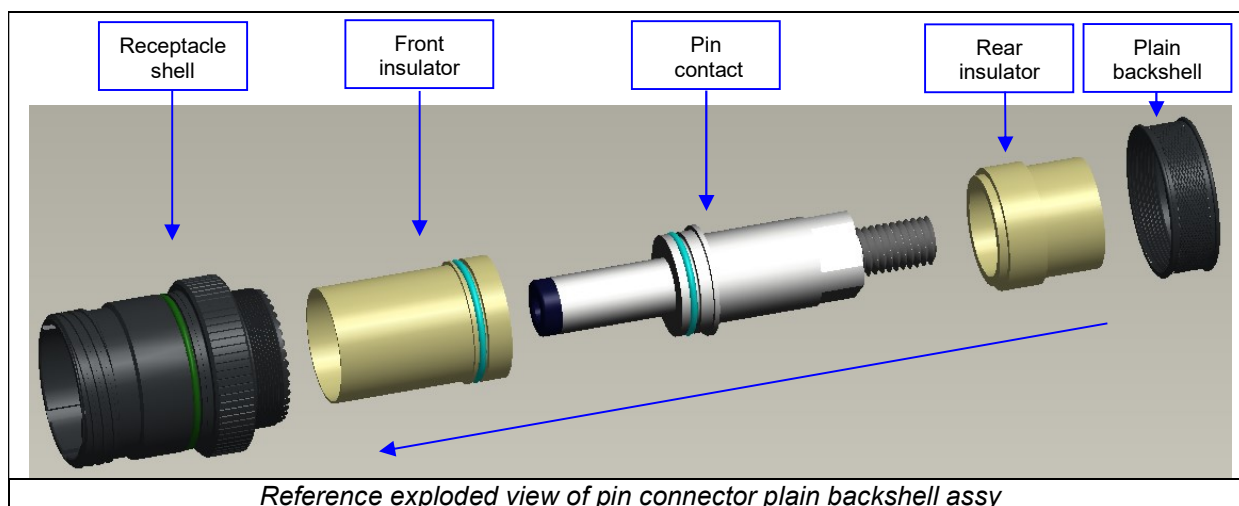
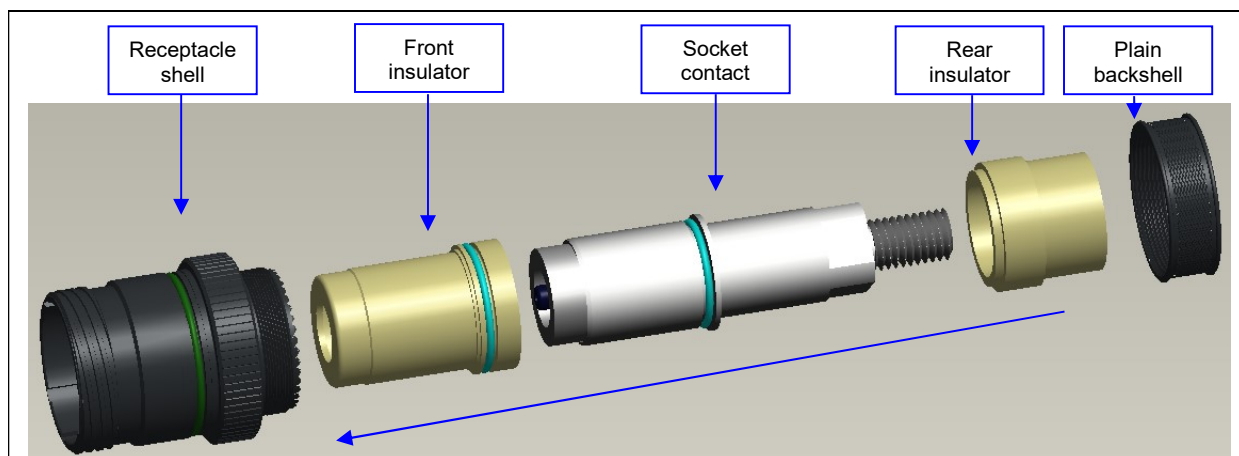
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OP 10. WPTV-01XXXX-XXX-2XXA variant.**Main Steps**

- 1). Unpack the connector. Remove the plain backshell, rear insulator & contact assembly, and retain for assembly later.
 1a). *O-rings must be fitted as per illustrations (including suitable grease) for connector to seal.*
- 2). Feed the plain backshell then insulator onto the prepared cable and terminate the contact as per document 123GB-0846.
- 3). Assemble the terminated contact into the front insulator in the receptacle shell.
- 4). Assemble the rear insulator over the rear of the contact assembly.
- 5). Secure the plain backshell as per document 123GB-0845.

*Reference exploded view of pin connector plain backshell assy**Reference exploded view of socket connector plain backshell assy*

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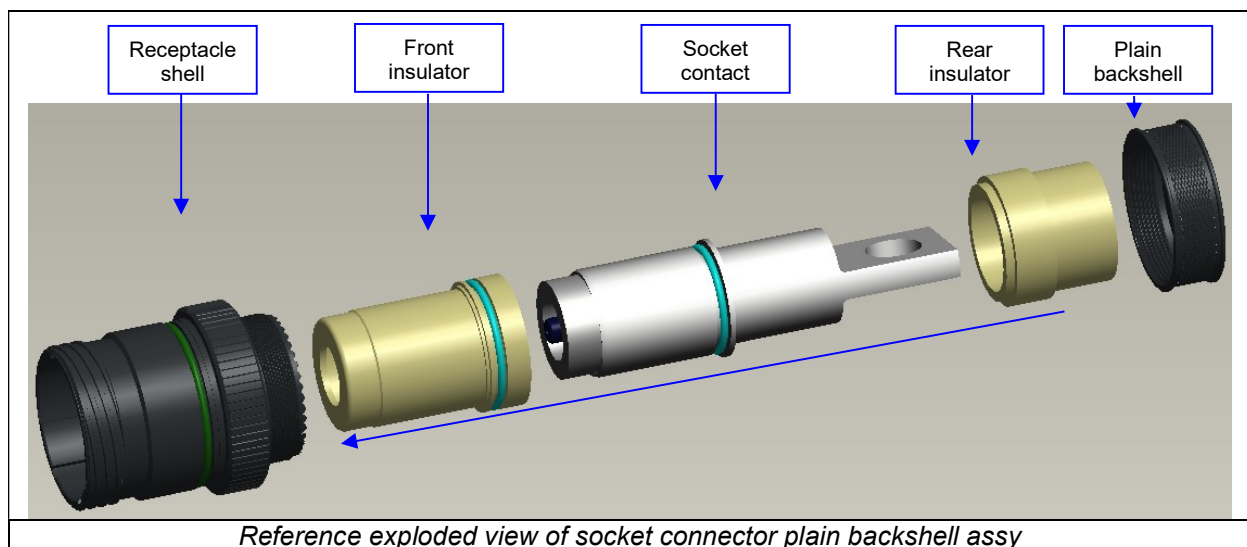
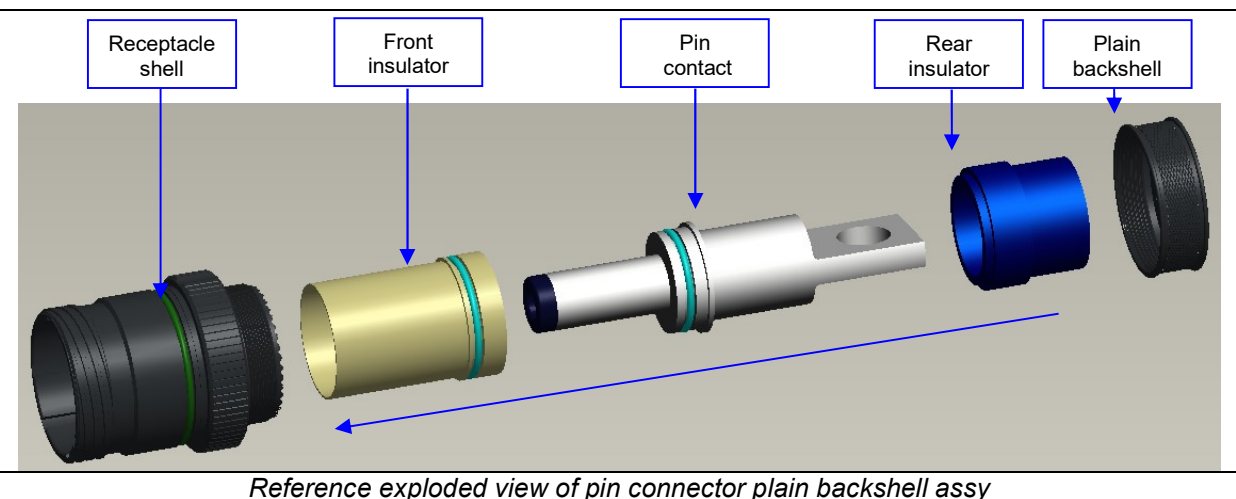
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OP 10. WPTV-01XXXX-XXX-3XXA variant.**Main Steps**

- 1). Unpack the connector. Remove the plain backshell, rear insulator & contact assembly, and retain for assembly later.
 - 1a). O-rings must be fitted as per illustrations (including suitable grease) for connector to seal.
- 2). Feed the plain backshell then insulator onto the prepared cable and terminate the contact as per document 123GB-0846.
- 3). Assemble the terminated contact into the front insulator in the receptacle shell.
- 4). Assemble the rear insulator over the rear of the contact assembly.
- 5). Secure the plain backshell as per document 123GB-0845.



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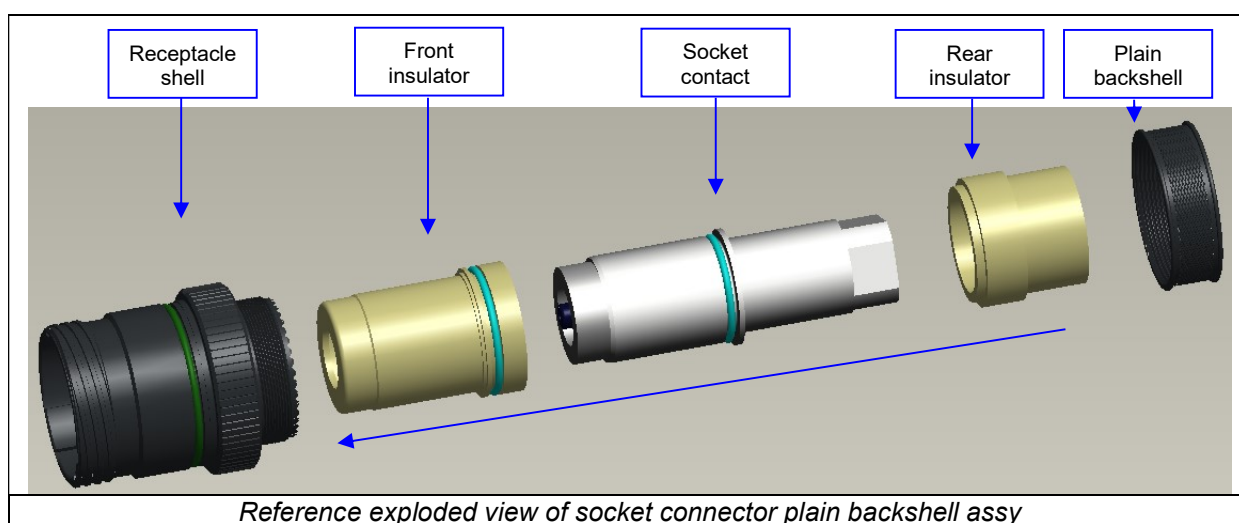
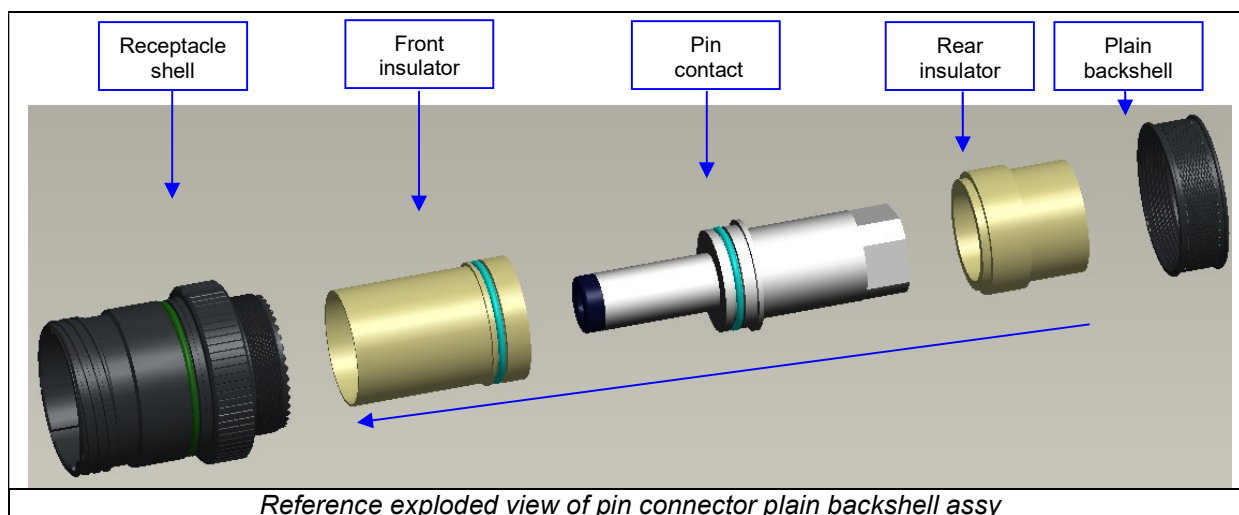
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OP 10. WPTV-01XXXX-XXX-5XXA variant.**Main Steps**

- 1). Unpack the connector. Remove the plain backshell, rear insulator & contact assembly, and retain for assembly later.
 - 1a). O-rings must be fitted as per illustrations (including suitable grease) for connector to seal.
- 2). Feed the plain backshell then insulator onto the prepared cable and terminate the contact as per document 123GB-0846.
- 3). Assemble the terminated contact into the front insulator in the receptacle shell.
- 4). Assemble the rear insulator over the rear of the contact assembly.
- 5). Secure the plain backshell as per document 123GB-0845.



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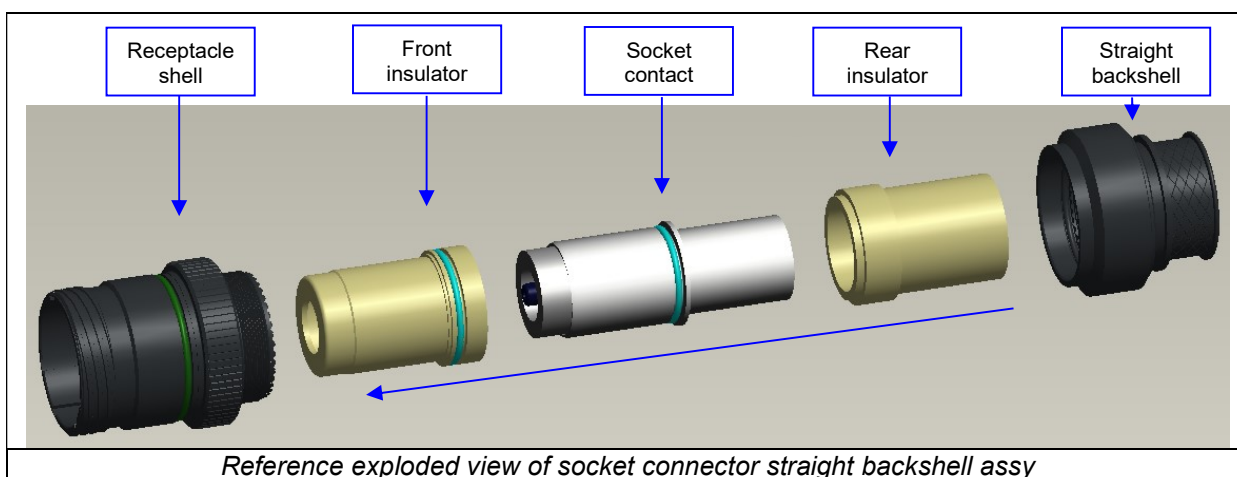
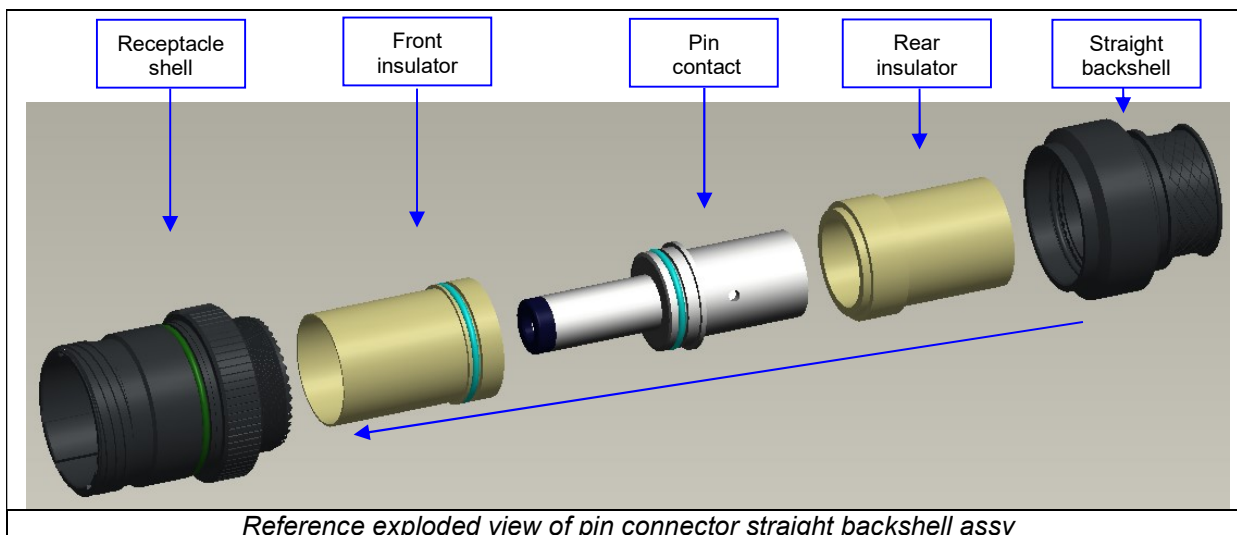


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OP 10. **WPTV-01XXXX-XXX-1XXB variant.**
(also WPTV-01XXXX-XXX-6XXB, WPTV-01XXXX-XXX-7XXB, WPTV-01XXXX-XXX-8XXB variants).

Main Steps

- 1). Unpack the connector. Remove the straight backshell, rear insulator & contact assembly, and retain for assembly later.
1a). O-rings must be fitted as per illustrations (including suitable grease) for connector to seal.
- 2). Feed the straight backshell then insulator onto the prepared cable and terminate the contact as per document 123GB-0846.
- 3). Assemble the terminated contact into the front insulator in the receptacle shell.
- 4). Assemble the rear insulator over the rear of the contact assembly.
- 5). Secure the straight backshell as per document 123GB-0845.



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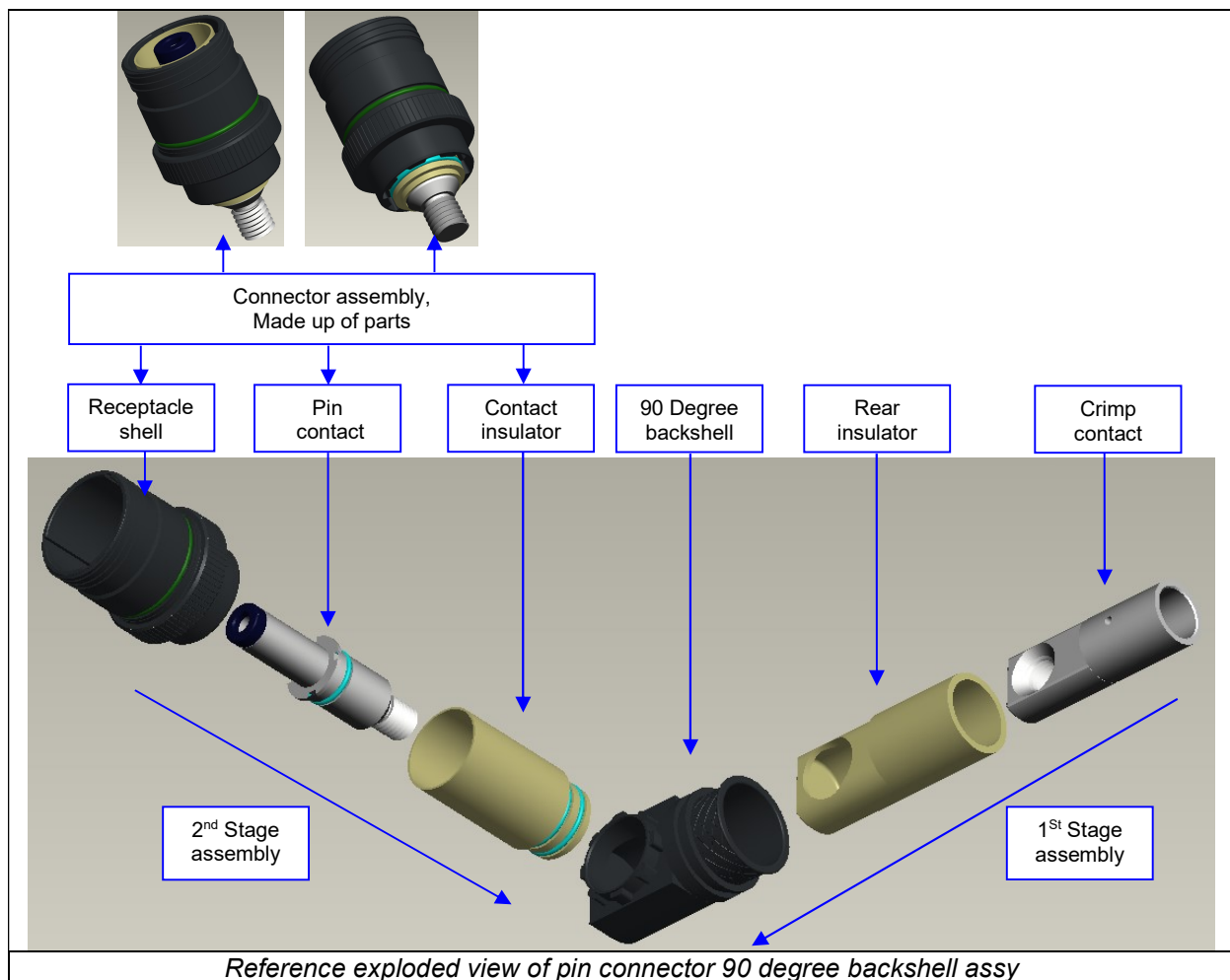
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OP 10.**WPTV-01XXXX-XXX-1XXC variant.***(also WPTV-01XXXX-XXX-6XXC, WPTV-01XXXX-XXX-7XXC, WPTV-01XXXX-XXX-8XXC, WPTV-01XXXX-XXX-9XXC variants).***Main Steps**

- 1). Unpack the connector. Remove the 90 degree backshell, backshell insulator & crimp contact, and retain for assembly later.
 1a). O-rings must be fitted as per illustrations (including suitable grease) for connector to seal.
- 2). Terminate the contact as per document 123GB-0846. Place over front of the terminated contact the backshell insulator.
- 3). (1st stage assembly). Assemble the terminated contact & backshell insulator in to the rear of the 90 degree backshell.
- 4). (2nd stage assembly). ***Remember to set the desired main key position prior to performing this step*.** Assemble the connector assembly to the backshell.
- 5). Using the tooling & setting as per document 123GB-0845. Secure the connector assembly to the backshell via the terminated contact.



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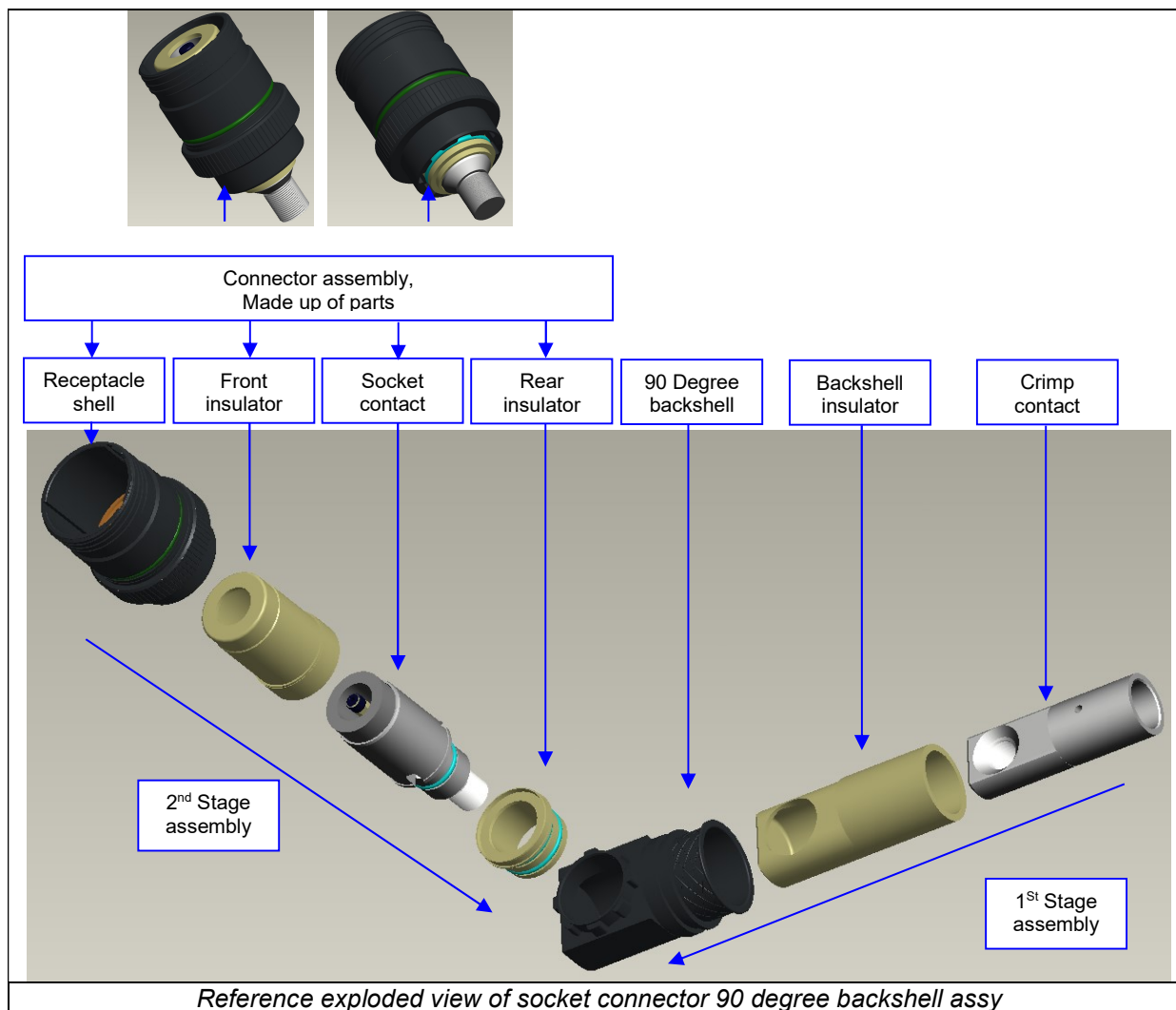
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**OP 20.****Inspection.**

Main Steps	Key Points	Sketch / Picture
Inspect the connector assembly.	Check for any damage that would effect functionally of the product.	

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