

BF-WI-ENG-013/01

IMPORTANT

Issue 1

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Amphenol

PROCESS INSTRUCTION

Number: 123GB-0845

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**** FOLLOW ALL LOCAL HEALTH AND SAFETY POLICIES ******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
	XX refers to connector shell size



Rhino Connectors

Release / Changes:	ECN22057	ECN22119	ECN22181	ECN22485	ECN23675	ECN24869	ECN26190
Originator:	J Turnbull	J Turnbull	J Turnbull	J Turnbull	T Whitnell	I Quinney	IC Ciochina
Date:	25/11/14	19/01/15	26/02/15	23/10/15	09/03/18	31/01/2020	12/07/2022

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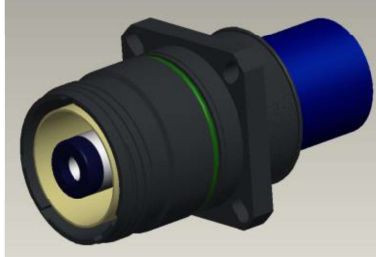
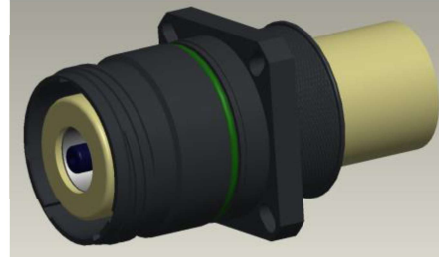
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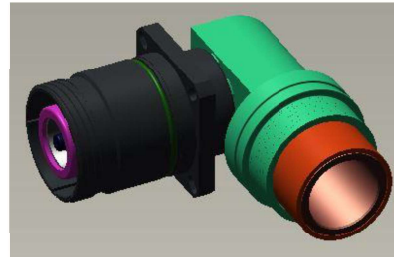
Reference views.

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.*

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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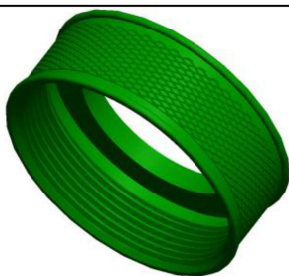
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OP 10. Torque Requirements

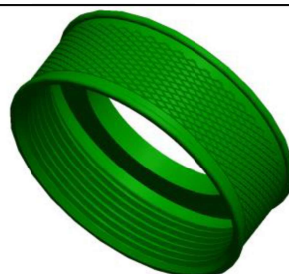
The sections below detail the connector type and relevant torque / tool information for all Rhino Connectors in the standard Product Range

**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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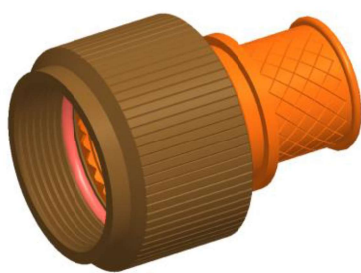
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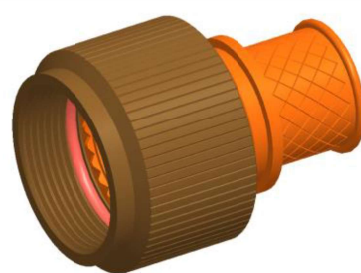
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**OP 12a. Plug (all styles / genders) Straight Backshell
WPTV-06xxXX-XXX-XxB variant.**

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

**OP 12b. Rec (all styles / genders) Straight Backshell
WPTV-XXxxXX-XXX-XxB variant.**

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

**Note: Please refer to appendix A for how to use a strap wrench.**

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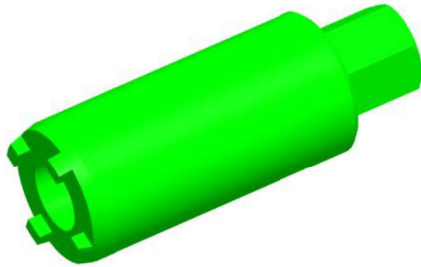
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OP 13. **Rec and Plug (all styles) 90° Backshell Pin**
WPTV-XXxxXX-XXX-XPXC variant.

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

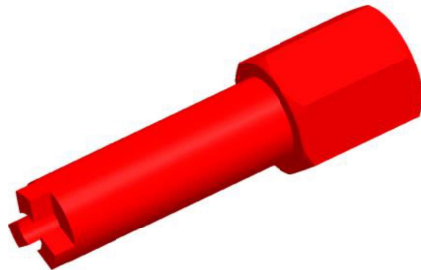


Backshell

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.

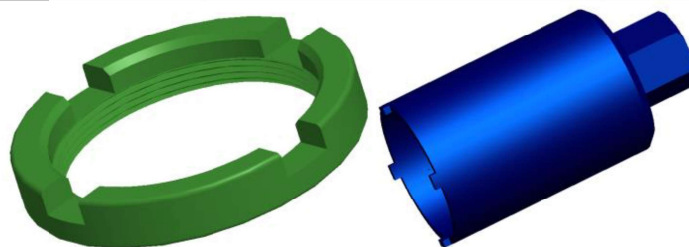
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OP 16.**Rec and Plug (all styles / genders) Jam-Nut
WPTV-07xxXX-XXX-XxXx variant.**

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.

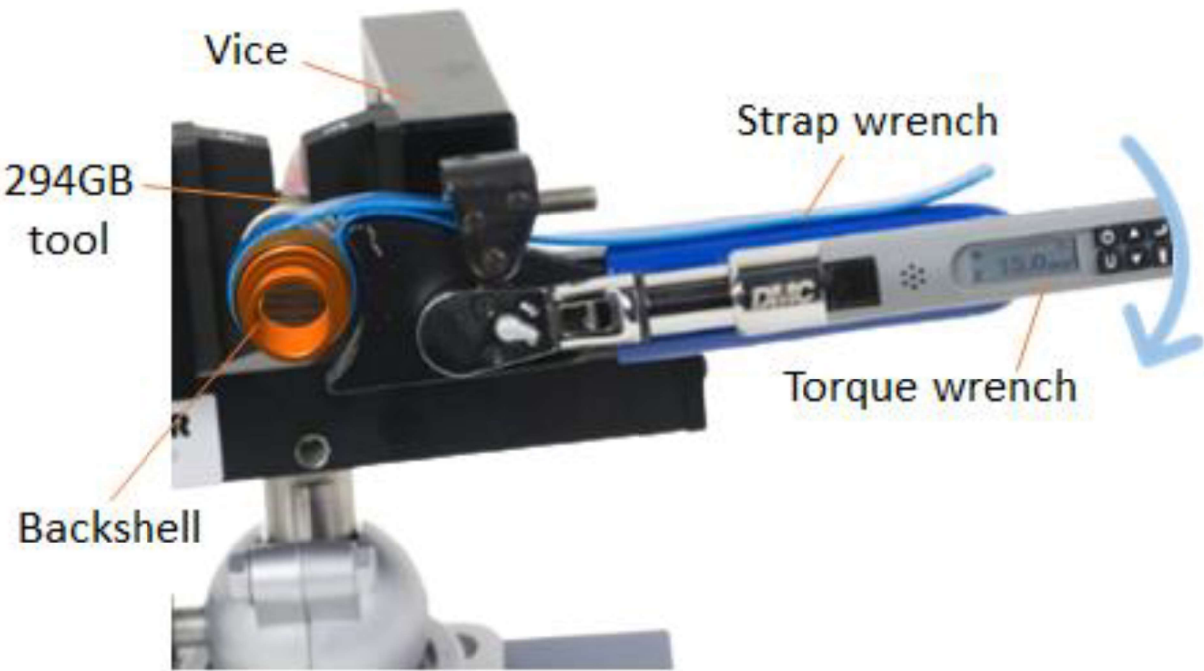
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Appendix A



Images for reference only, contact factory for more details



Release / Changes:	ECN22057	ECN22119	ECN22181	ECN22485	ECN23675	ECN24869	ECN26190
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