

BF-WI-ENG-013/02 Issue 03	<b>Amphenol</b>	<b>IMPORTANT</b>	RN/ECN	Issue	Page	Test
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Document number	<b>123GB-0879</b>
Document name	<b>STINGRAY RECEPTACLE ASSEMBLY</b>

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

Scope
The scope of this document is to describe the build process of ... STINGRAY RECEPTACLE ASSEMBLY BUILD

Supporting documents	
Doc no	Doc name

Document Traceability			
Issue No	RN/ECN no...	Date	Initials
Issue 1	RN 11255	28/03/2019	LJG
Issue 2	ECN 24667	10/10/2019	AR



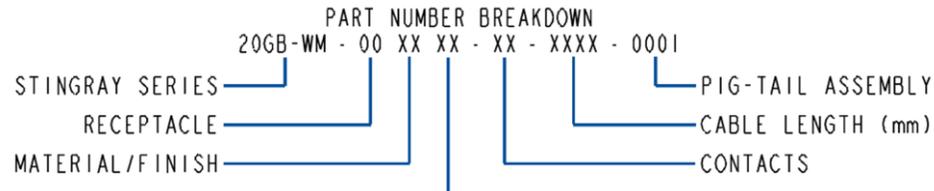
## 10 SLIDE BOOT OVER THE CABLE (IF REQUIRED)



IF BOOT IS REQUIRED SLIDE OVER THE CABLE

(BOOT IS ONLY REQUIRED FOR PART NUMBERS ENDING IN B1)

E.G. 20GB-WM-00XXXX-XX-XXXX-XXXX-00B1



## 20 STRIP BACK JACKET 30MM



STRIP BACK JACKET BY 30MM

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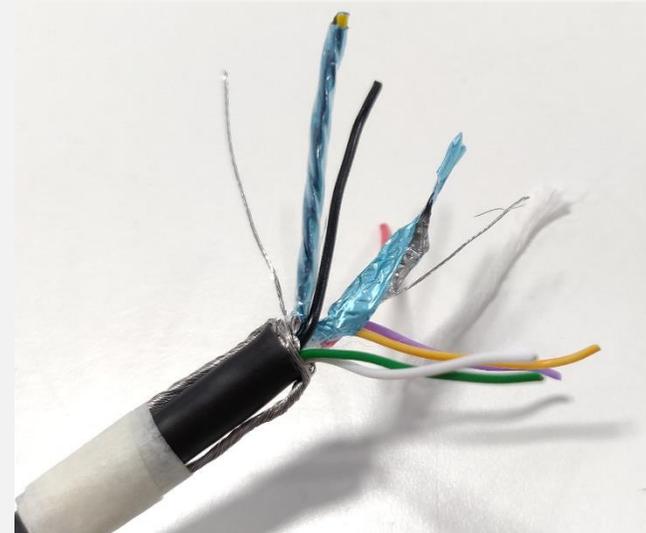
### 30 FOLD BACK THE BRAID



PART AND TWIST THE BRAID BACK INTO TWO EVEN STRIPS

(LOCATE AND RETAIN THE OUTER DRAIN WIRE, KEEPING SEPARATE FROM THE BRAID)

### 40 REMOVE FOILS FILLER & INNER BRAIDS



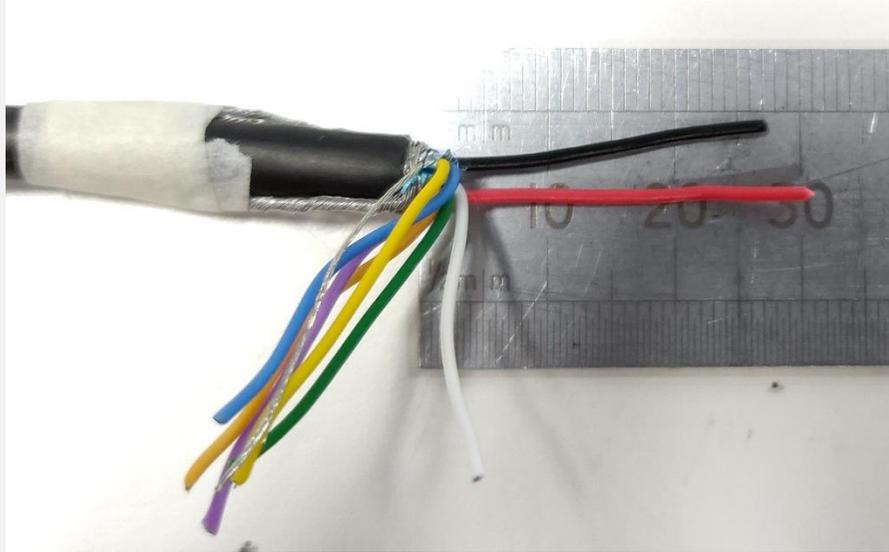
TAPE DOWN THE TWISTED BRAID PAIRS WITH MASKING TAPE

REMOVE ALL THE OUTER FOIL, PLASTIC SLEEVES AND INNER FOILS

CUT OFF COTTON FILLER AND THE BOTH INNER DRAIN WIRES

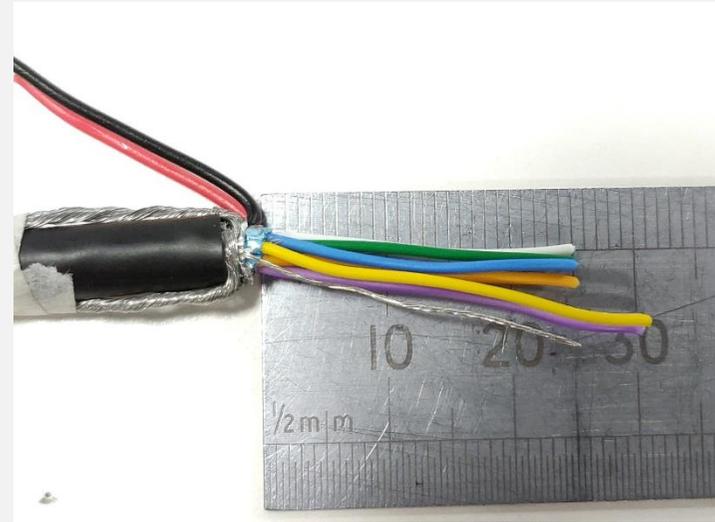
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**50 CUT BACK RED/BLACK CABLE**



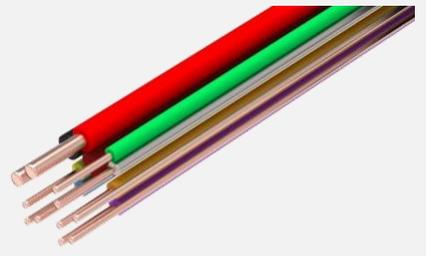
CUT BACK RED & BLACK CORES BACK TO **22MM**

**60 CUT REMAINING CABLE**



CUT THE REMAINING CORES AND OUTER DRAIN WIRE BACK TO **25MM**

**70 STRIP BACK CORES**



STRIP BACK RED AND BLACK CORES **2MM** AND ALL REMAINING CORES **5MM**, THEN TIN ALL CORES

(MINIMIZE INSULATION SHRINKAGE DURING THE TINNING PROCESS, DO NOT ALLOW MORE THAN 1MM OF INSULATION SHRINKAGE)

**80 THREAD BRAIDS THROUGH HOLES IN THE CLIP**

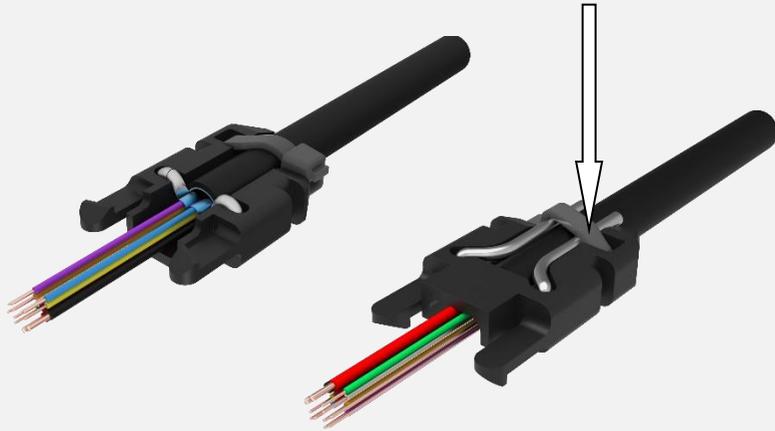


THREAD THE TWISTED BRAID PAIRS THROUGH THE TWO HOLES IN THE CLIP

(PULL THE BRAIDS FIRMLY, SO THAT THE CABLE IS FULLY SEATED IN THE CLIP GROOVE AND FLAT TO THE TOP SURFACE)

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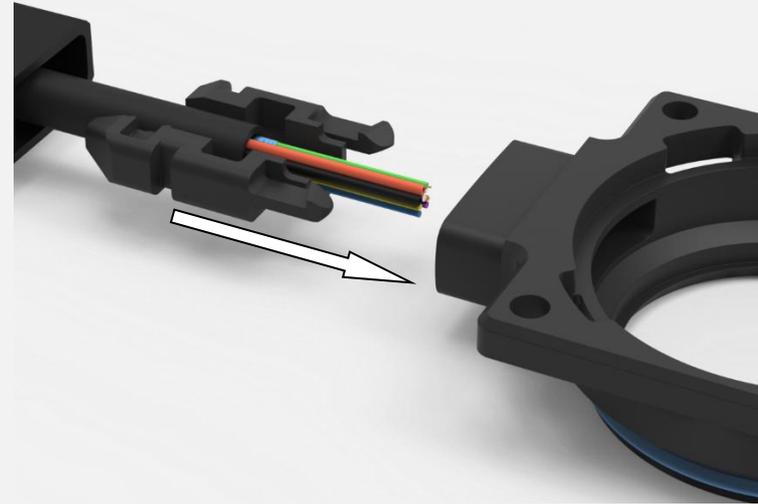
## 90 ATTACH CABLE TIE



ATTACH CABLE TIE TO CLIP, BRAIDS AND WIRE

(ENSURE THAT THE TWISTED BRAID PAIRS ARE PULLED TIGHT WHEN SECURING THE CABLE TIE, CUT OFF EXCESS CABLE TIE)

## 100 SLIDE CABLE/CLIP INTO SHELL



SLIDE CABLE & CLIP INTO THE SHELL

(OBSERVE CLIP 'TABS' LOCKING INTO THE INNER RING OF THE RECEPTACLE, WHEN FULLY SEATED)

MANIPULATE THE WIRES OUT OF THE BACK OF THE RECEPTACLE IN PREPARATION OF SOLDERING

**110 SOLDER LONGER CORES**

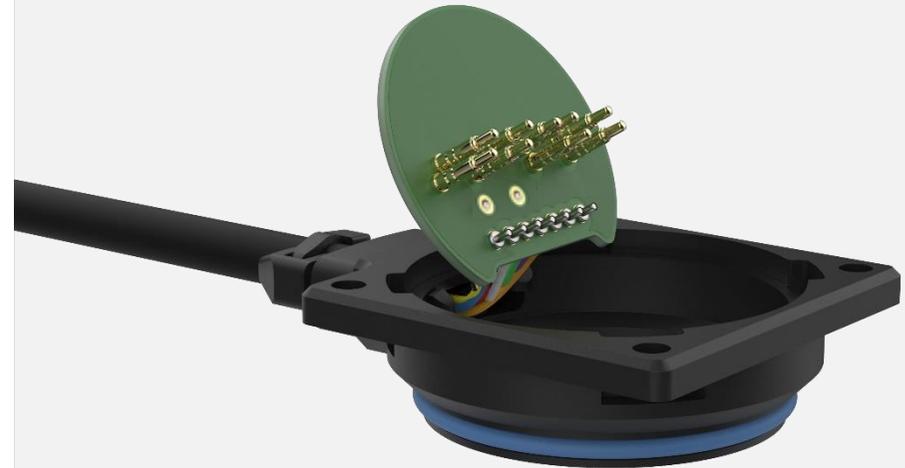


MOVE THE SHORTER, RED AND BLACK CORES OUT OF THE WAY OF THE PCB, DO NOT SOLDER THESE YET

FEED THE LONGER, TINNED CORES INTO THEIR CORRESPONDING HOLES, SHOWN IN THE WIRING DIAGRAM AND SOLDER THEM TO THE UNDERSIDE OF THE PCB

(FEED IN THE LONGER CORES INTO: J2, J3, J4, J5, J6, J7 & J9)

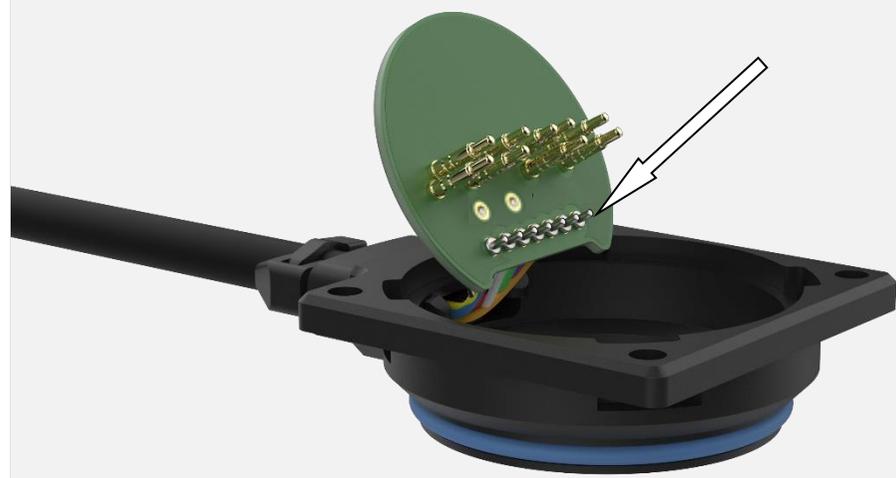
**120 INSPECT SOLDERING**



INSPECT THE SOLDER JOINTS

(IT IS RECOMMENDED THAT JOINTS ARE INSPECTED IN ACCORDANCE WITH IPC-A-610)

**130 SNIP EXCESS WIRE AND CLEAN**



SNIP ANY EXCESS WIRE PROTRUDING FROM THE SOLDER JOINT

(AVOID CUTTING INTO SOLDER JOINTS)

CLEAN OFF FLUX WITH FLUX REMOVER

(AVOID DAMAGING ANY OF THE SPRING CONTACTS)

**140 ASSEMBLE INSERT TO PCB**

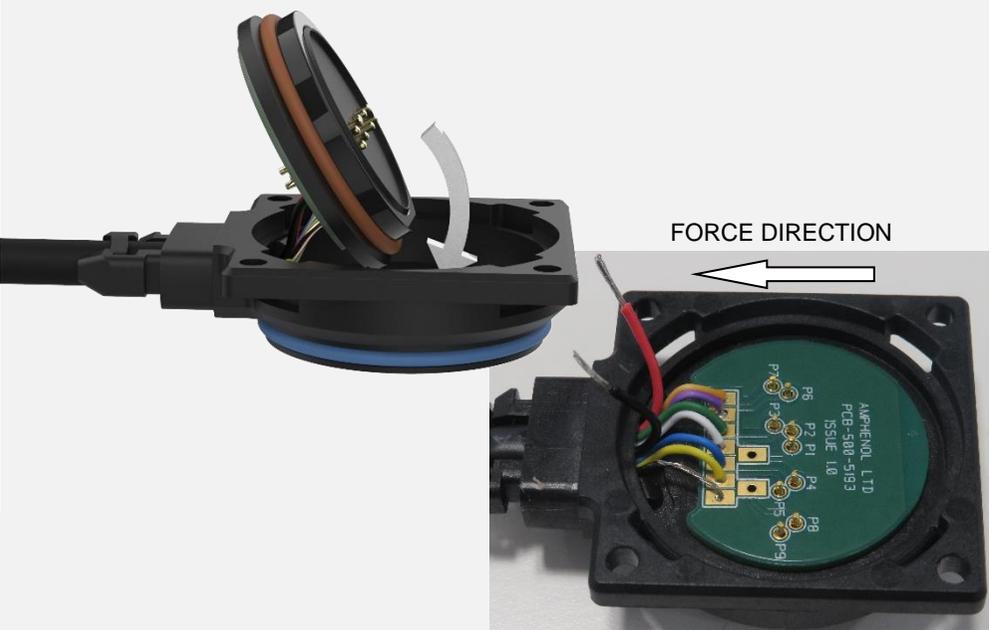


FIT SEAL OVER SPRING CONTACTS, PUSH THE SEAL ALL THE WAY DOWN TO THE PCB, MAKING SURE IT IS ENTIRELY FLAT.

FIT INSERT OVER SPRING CONTACTS DOWN TO THE SEAL/PCB

(AVOID DAMAGING SEAL OR SPRING CONTACTS)

**150 ASSEMBLE INSERT TO RECEPTACLE SHELL**

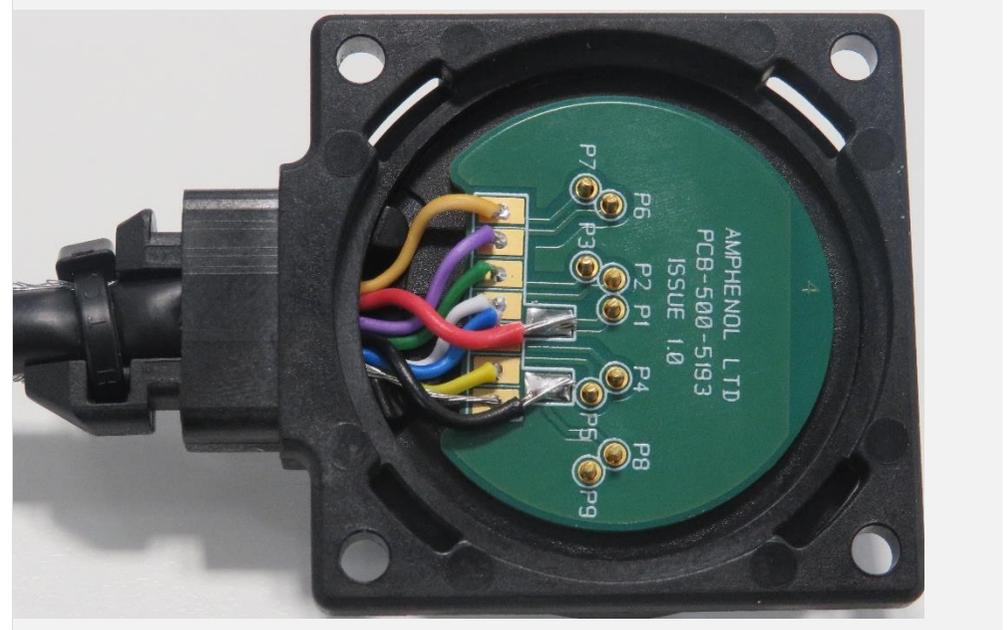


CAREFULLY ASSEMBLE THE INSERT INTO THE RECEPTACLE SHELL, APPLY A SMALL AMOUNT OF FORCE TO COMPRESS THE O-RING TOWARDS THE CABLE AND THE INSERT WILL EASILY MOVE INTO POSITION

ONCE THE INSERT IS SEATED CORRECTLY PUSH THE PCB FULLY HOME INTO THE INSERT, NO GAPS TO BE VISIBLE AROUND PCB AND INSERT

**(DO NOT TRAP/PINCH ANY CORES BETWEEN THE INSERT AND THE CLIP 'TABS', MANIPULATE THE DRAIN WIRE AWAY FROM THE ADJACENT PAD, ANY DAMAGE TO THE O-RING WILL REQUIRE REPLACEMENT)**

**160 SOLDER RED AND BLACK CORES**



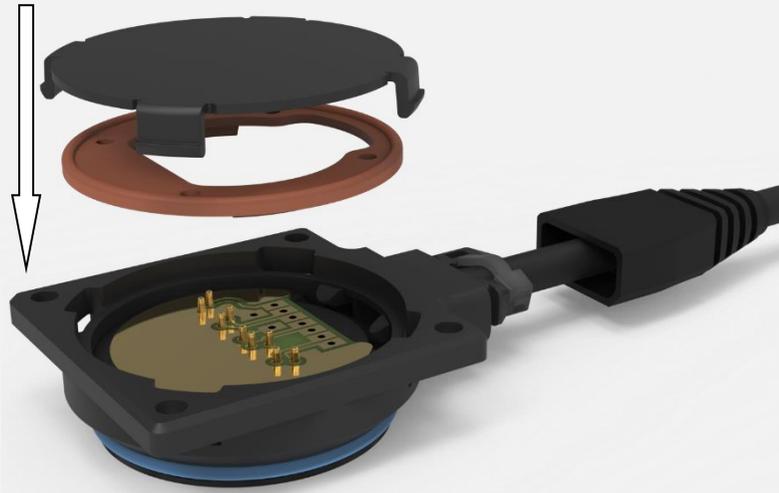
SOLDER THE SHORTER RED AND BLACK CORES WITH LAY JOINTS ONTO THE TOP SOLDER PADS

INSPECT THE SOLDER JOINTS AND CLEAN WITH FLUX REMOVER

**(IT IS RECOMMENDED THAT JOINTS ARE INSPECTED IN ACCORDANCE WITH IPC-A-610, AVOID SHORTS BETWEEN WIRE CORES AND THE PINS LOCATED IN THE CENTRE OF THE PCB)**

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**170 CLIP BACK PLATE AND SEAL**



PLACE THE SEAL ONTO THE REAR PLATE AND CLIP REAR PLATE INTO THE RECEPTACLE, SLIDE OVER BOOT UNTIL SECURED

(NOTE ORIENTATION OF SEAL, PLATE SHOULD BE FLUSH WITH RECEPTACLE REAR)

**180 TEST/INSPECT**

INSPECT CABLE FOR DAMAGE AND CARRY OUT ELECTRICAL TEST