

Figure 1

### 1. INTRODUCTION

This instruction sheet covers assembling the terminated contact, receptacle housing, and TPA shown in Figure 1 and extracting the contacts from the receptacle housing.

Reasons for reissue of this instruction sheet are provided in Section 6, REVISION SUMMARY.

### 2. DESCRIPTION

The contact has a locking lance that, when inserted into the receptacle housing, latches onto the locking ramp.

The receptacle housing and TPA are available in 2 through 20 positions. The TPA is designed to be installed onto the receptacle housing to prevent the contacts from backing out of the receptacle housing. When installed, the locking latch(es) of the TPA snap onto a nub(s) located on the bottom of the receptacle housing.

### 3. ASSEMBLY

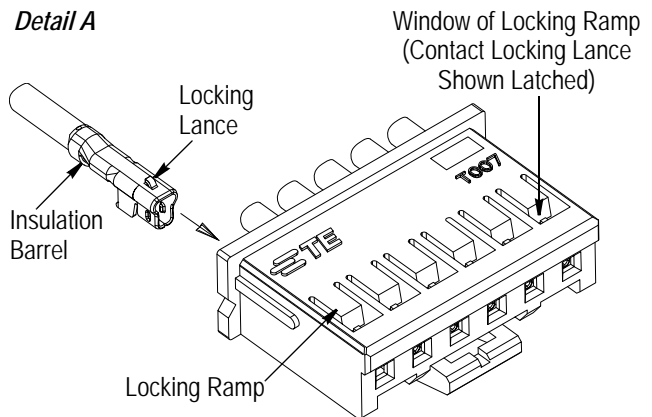
1. Ensure that the contact is properly terminated to the wire according to Application Specification 114-13315. Check that the locking lance of the contact is not depressed as shown in Figure 1.
2. Insert the terminated contact into the receptacle housing as follows:
  - a. Grasp the contact directly behind the insulation barrel, and align the contact with contact cavity from the wire end of the receptacle housing so that the locking lance is aligned with the locking ramp. See Figure 2, Detail A. Make sure that the contact is perpendicular (not at an angle) to the contact cavity. See Figure 2, Detail B.



**CAUTION**

Never insert the contact upside down; otherwise, the locking lance could depress and cause it to not latch properly onto the locking ramp of the contact cavity.

#### Inserting Contact into Receptacle Housing



#### Detail B

Insert Contact Straight

DO NOT Rotate Contact

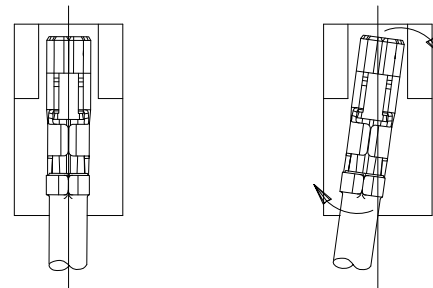


Figure 2

- b. Push the contact straight, and not rotated, into the contact cavity. If it is rotated, damage to the contact will occur or the contact will not latch properly onto the locking ramp. See Figure 2, Detail B. Do not force the contact into the receptacle housing.

c. Ensure that the contact locking lance latches onto the locking ramp. The locking lance can be viewed through the window of the locking ramp. See Figure 2, Detail A.

3. Install the TPA onto the receptacle housing as follows:

a. Align the TPA with the wire end of the receptacle housing so that each position faces a contact cavity and is on top of the wires. See Figure 3, Detail A.

b. Slide the TPA into the receptacle housing so that the positions enter the contact cavities evenly and until the locking latch(es) locks onto the nub(s) of the receptacle housing. There will be an audible and tactile “click”. See Figure 3, Detail B.

**i** **NOTE**  
*TPAs with more than 5 positions have more than one locking latch and corresponding receptacle housings have more than one nub located on both sides of the receptacle housing locking latch. TPAs with 5 positions or less have one locking latch and corresponding receptacle housings have one nub, which is located under the receptacle housing locking latch.*

c. Pull the TPA back lightly to ensure retention.

#### 4. EXTRACTING CONTACTS

1. Remove the TPA from the receptacle housing by releasing the locking latch(es) from the nub(s) of the receptacle housing and pulling the TPA straight from the receptacle housing. No contact can be extracted until the TPA is removed.

2. Extract the contacts using Extraction Tool 2161958-1 according to instruction sheet 408-32061 (packaged with the tool).

**i** **NOTE**  
*DO NOT re-insert any extracted contacts.*

#### 5. REPLACEMENT AND REPAIR

DO NOT use defective or damaged products. Contacts, housing, and optional TPA are not repairable.

DO NOT re-use a contact by removing the wire.

DO NOT re-insert any contact after extracting it from the receptacle housing.

#### 6. REVISION SUMMARY

Revisions to this instruction sheet include:

- Removed optional from TPA
- Corrected description of TPA in Section 2
- Corrected specification number in Step 1, removed CAUTION from Step 3, changed Step 3,b, and added Step 3,c to Section 3
- Added Step 1 to Section 4
- Added instruction to Section 5

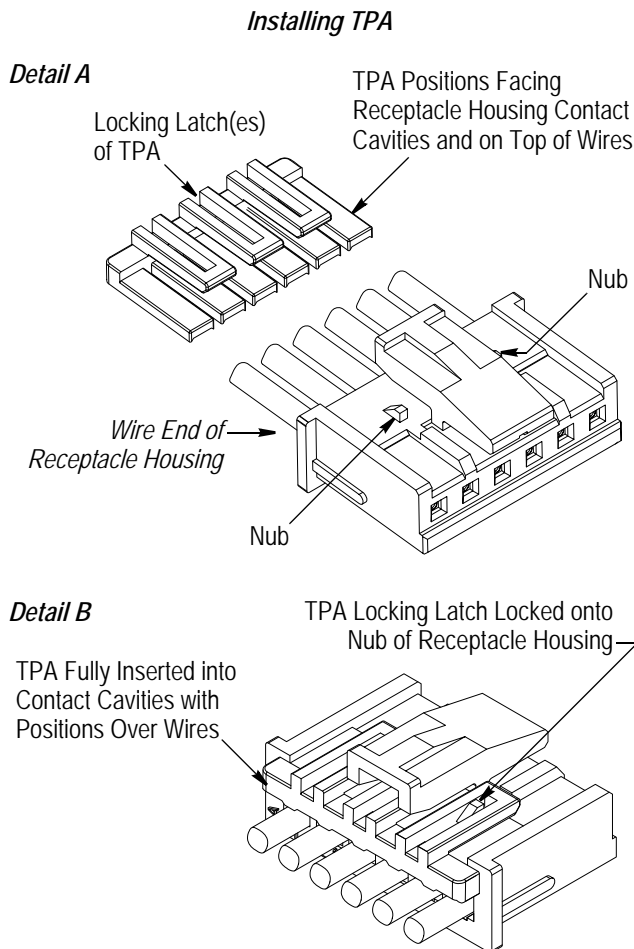


Figure 3