



NOTE

All numerical values are in metric units [with U.S. customary units in brackets]. Dimensions are in millimeters [and inches]. Unless otherwise specified, dimensions have a tolerance of ± 0.13 [$\pm .005$] and angles have a tolerance of $\pm 2^\circ$. Figures and illustrations are for identification only and are not drawn to scale.

1. INTRODUCTION

This instruction sheet covers the use of the Universal MATE-N-LOK* terminal position assurance (TPA) accessory assembly procedure. Application Specification 114-1010 provides the requirements for application, including wire size range and crimping requirements.

2. DESCRIPTION

The optional TPA accessories are available for specified wire sizes on both cap and plug housings for 1x2, 1x3, 1x4, and 1x5 housing configurations. These devices provide added security to ensure proper contact insertion and retention in the circuit cavities. TPA accessories cannot be used in conjunction with seals.

3. COMPATIBLE TERMINAL

TPA	Compatible Terminal	Wire OD
2-2400680-X 2-2400681-X	350218-X, 350547-X, 350536-X, 350550-X, 350654-X, 350687-X, 350705-X	1.53-3.30 [.060-.130]

4. ASSEMBLY PROCEDURE

4.1. TPA Accessory Assembly on Plug Housing

1. Crimp the contacts onto the wire per specifications in 114-1010.
2. Insert the terminated pin or socket contact into the appropriate cavity at the back end (wire side) of the plug housing.
3. Align the TPA accessory with the back end (wire side) of the plug housing. For 2-position and 3-position plug housings with a raised peg, the TPA must be aligned such that the raised peg on the back end of the plug housing is in line with the cutout on the TPA accessory.

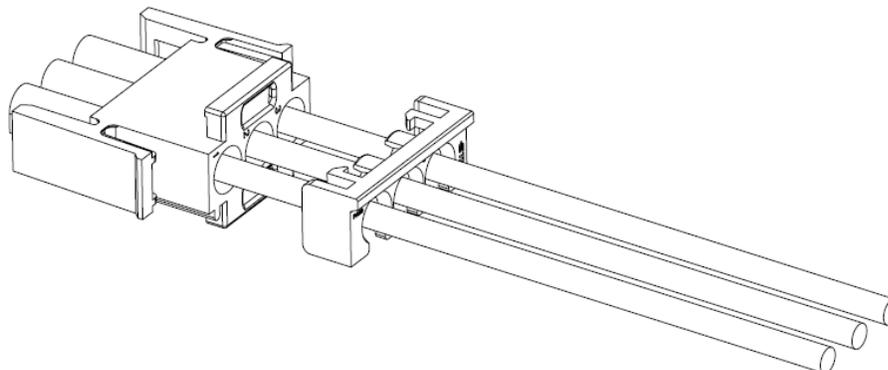


Figure 1

Assemble the TPA accessory onto the plug housing by pushing the TPA accessory straight onto the back of the housing until it locks in place. See Figure 2.

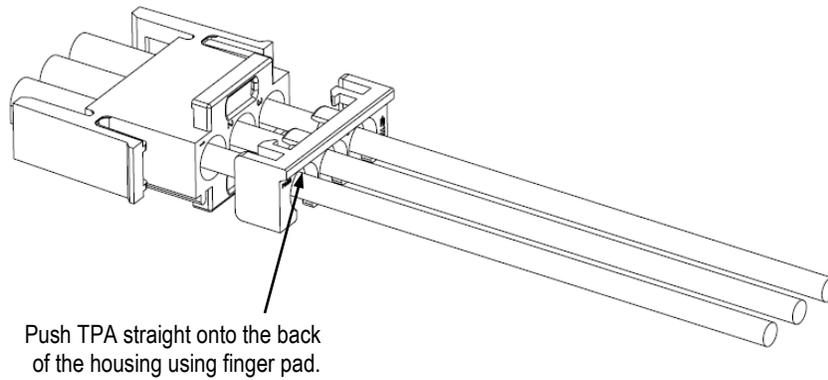


Figure 2

4. Ensure that the TPA accessory is locked in place by visually inspecting the TPA accessory locking latches. The locking latches must be fully seated on the back of the plug housing. See Figure 3.

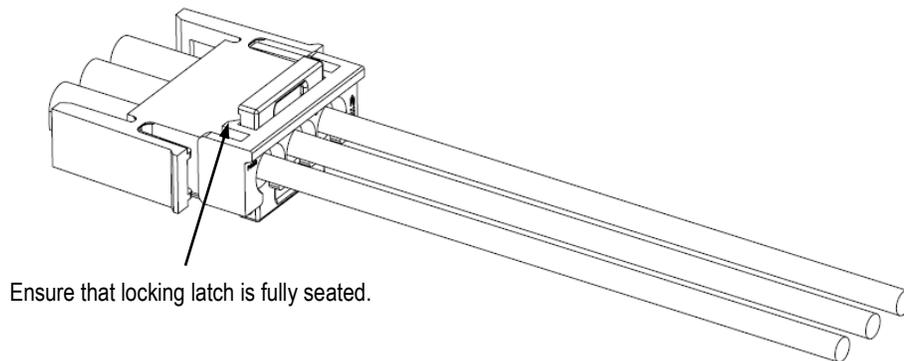


Figure 3

4.2. TPA Accessory Assembly on Cap Housing

1. Crimp the contacts onto the wire per specifications in [114-1010](#).
2. Insert the terminated pin or socket contact into the appropriate cavity at the back end (wire side) of the cap housing.
3. Align the TPA accessory with the back end (wire side) of the cap housing. See Figure 4.

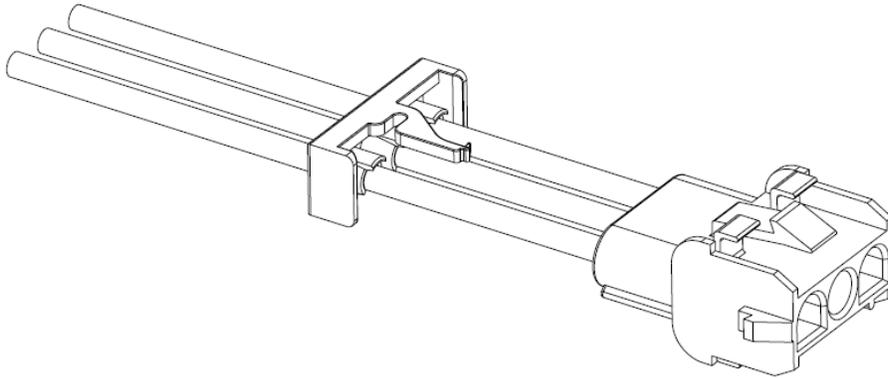


Figure 4

4. Assemble the TPA accessory onto the cap housing by pushing the TPA accessory straight onto the back of the housing, using the finger pad, until the locking arm is properly latched. The locking arm must latch into the back of the panel mount locking features. The TPA accessory should be inserted onto the housing by pushing directly on the finger pad on the TPA accessory. See Figure 5

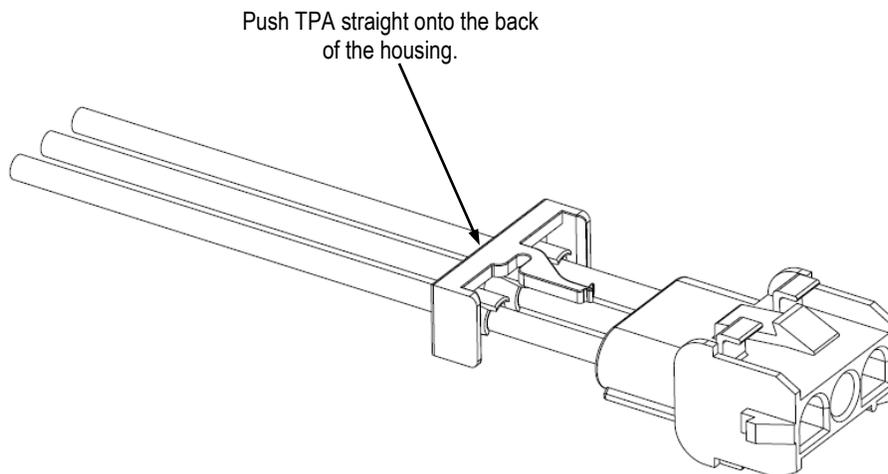


Figure 5



NOTE

Failure to insert the TPA accessory by pushing directly on the finger pad may result in a misalignment of the locking arm on the panel mount locking feature.

5. Ensure that the TPA accessory is locked in place by visually inspecting the TPA accessory locking arm. The locking arm must be latched under the panel mount locking feature and should be visible from the connector exterior. See Figure 7.

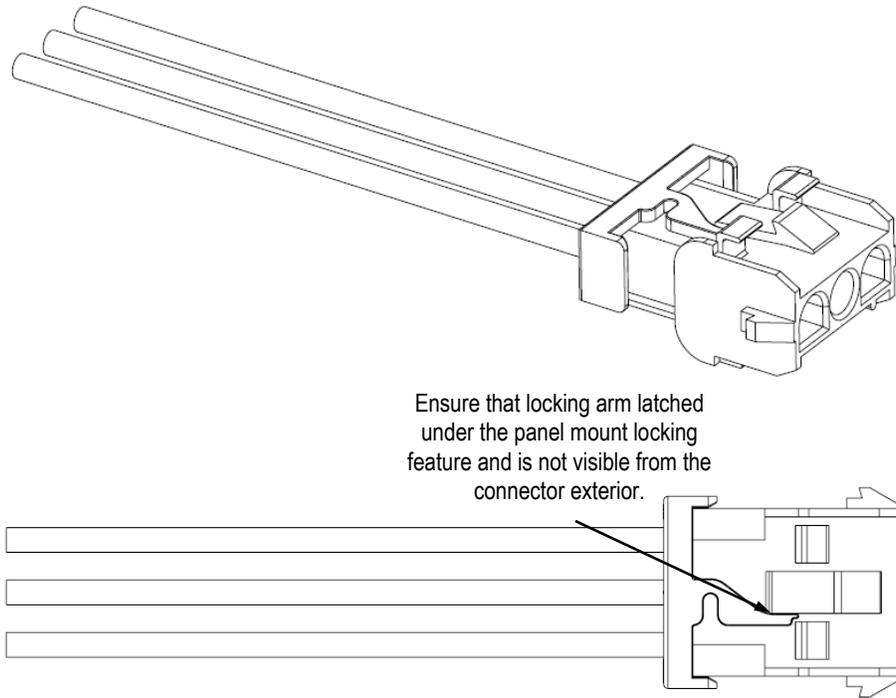


Figure 6