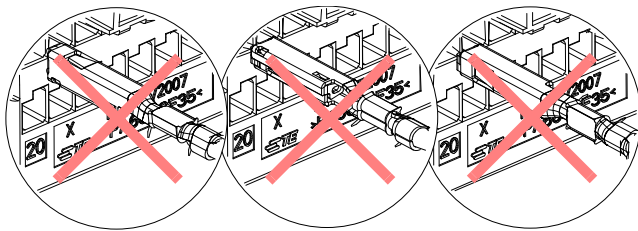
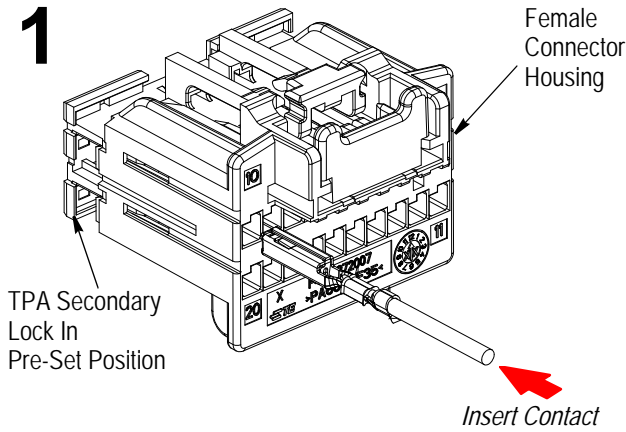


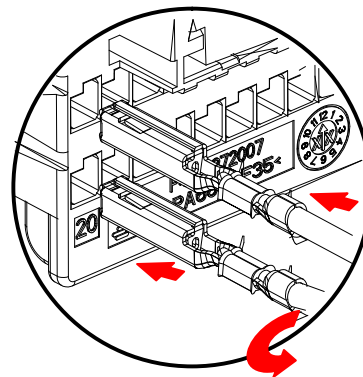
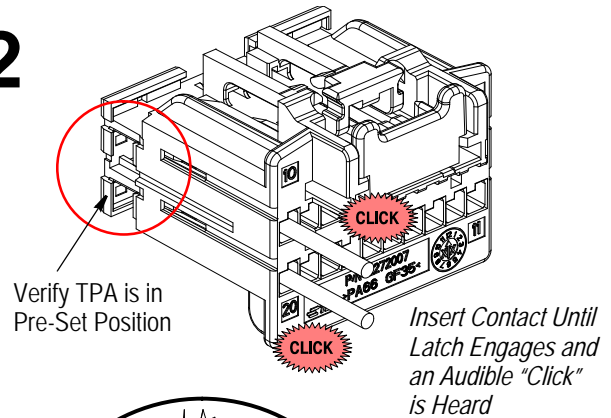
Contact Assembly Instructions

**1**



Incorrect Orientations

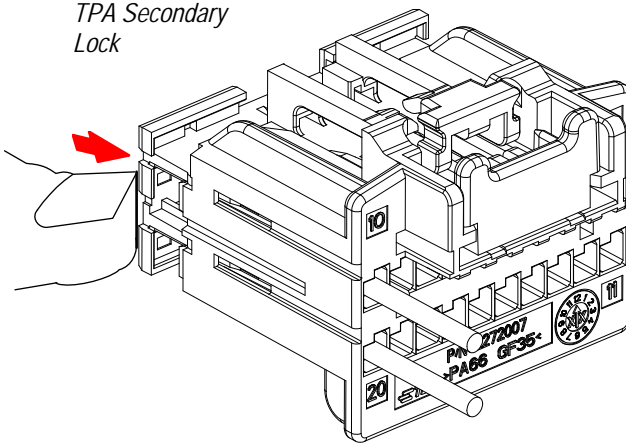
**2**



Lower Contact Row Oriented Same as Upper Contact Row

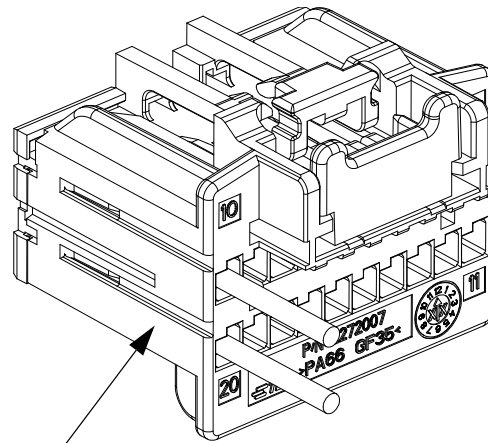
**3**

Push to Activate  
TPA Secondary  
Lock



After all desired contacts are inserted, engage the TPA secondary lock. A physical resistance to fully engaging TPA indicates contact is not fully inserted. Go back to Step 2.

**4**



TPA Secondary  
Lock Engaged  
and Latched

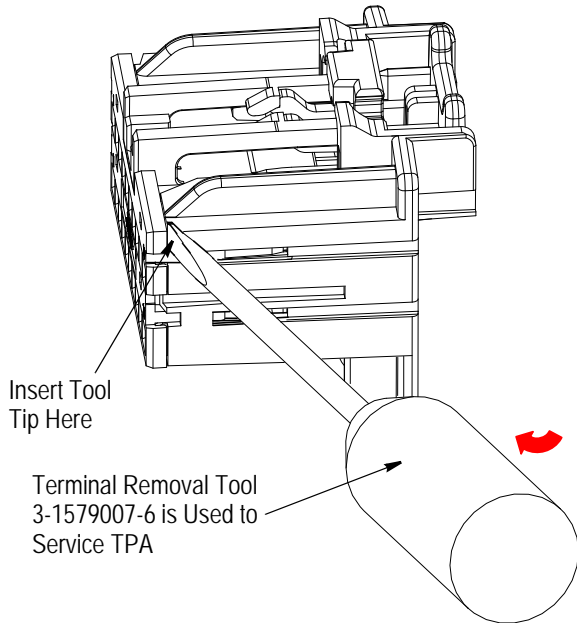
**NOTE:** This document is representative of all connector positions in this product family.

Contact Disassembly Instructions

1



**NOTE**  
TPA's may become seated during shipping due to bulk packaging. Perform this step to reposition TPA to pre-set location before installing terminals.



Insert Tool Tip Here

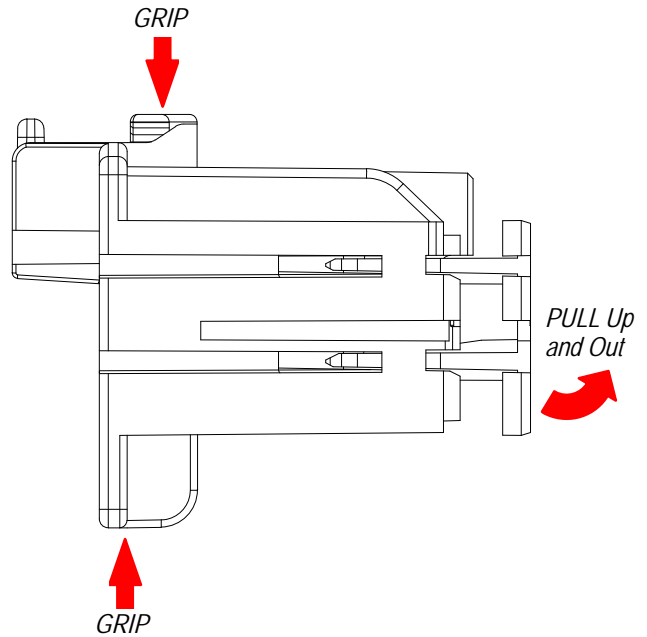
Terminal Removal Tool 3-1579007-6 is Used to Service TPA

Place terminal removal tool tip in gap between housing and TPA. Lever removal tool towards front of connector to unseat TPA.

2



**NOTE**  
TPA must be removed from plug assembly prior to contact removal.

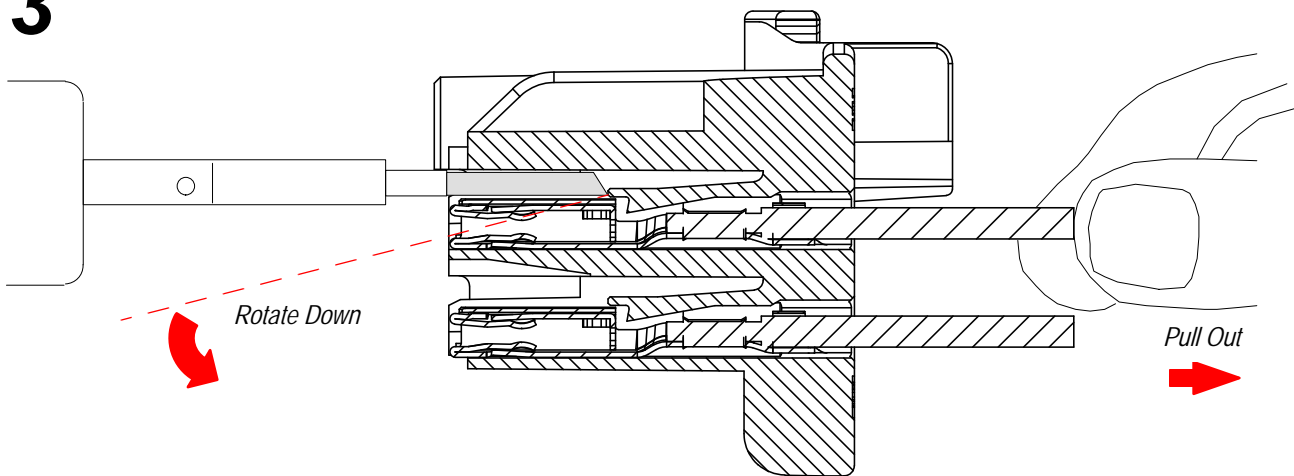


Firmly grip plug assembly and pull from bottom edge of TPA upwards (toward latch) and outwards (away from plug) to remove TPA.



**NOTE**  
Reassemble TPA and ensure full insertion after terminal service is complete

3

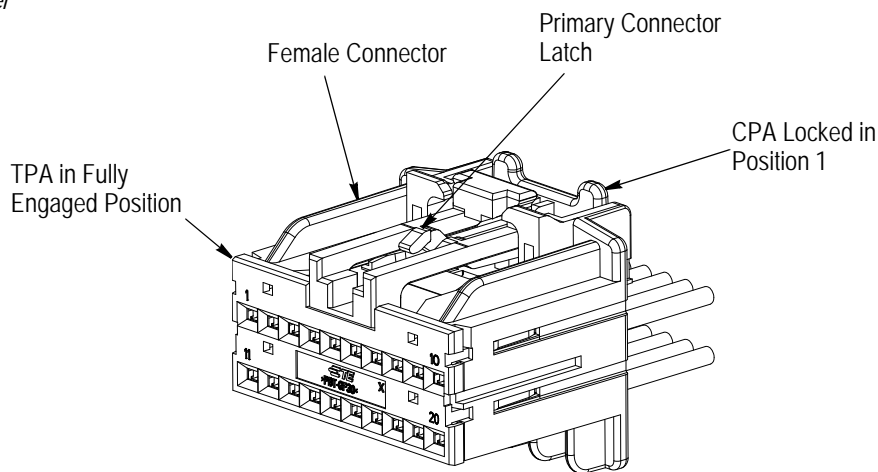
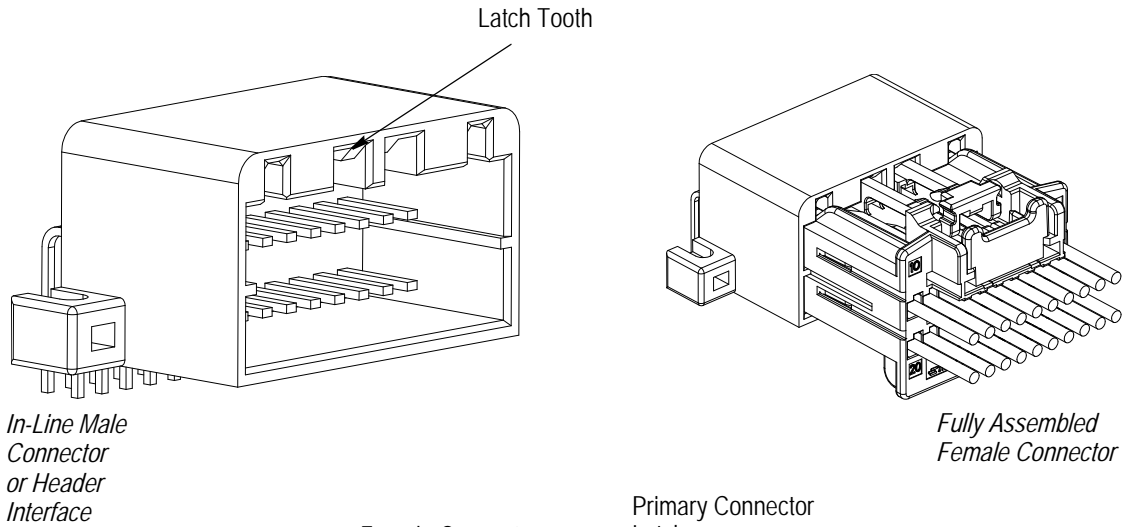


Gently press tool toward the contact latching beam while simultaneously pulling out on wire.



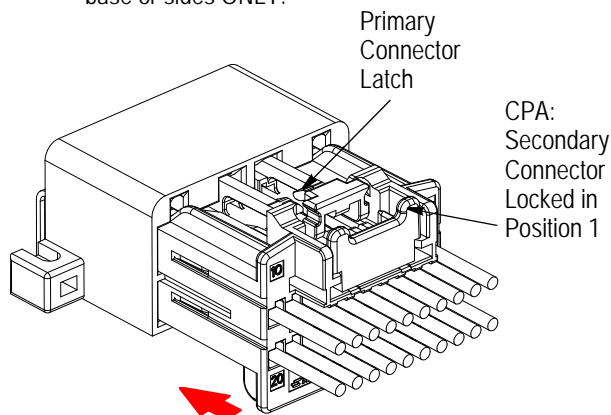
**NOTE**  
DO NOT re-use damaged or worn contacts. Instead, replace them with new contacts and discard the old ones.

Mating Instructions - with CPA



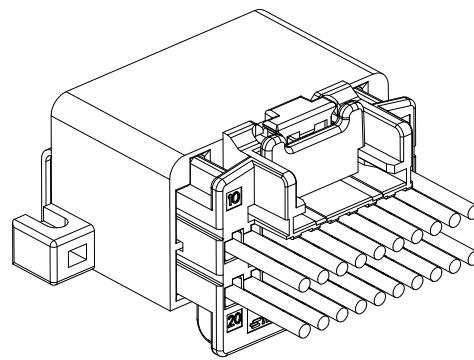
*CPA is locked in Position 1 for shipping and handling before engaging the primary connector latch. CPA can not move forward or backward until the connectors are mated and the primary connector latch "clicks" and engages the interface latch tooth.*

**1 To MATE Connector:** PUSH on housing base or sides ONLY.



*Do not push CPA forward until primary connector latch "clicks" and engages the interface latch tooth. Repeat - be redundant.*

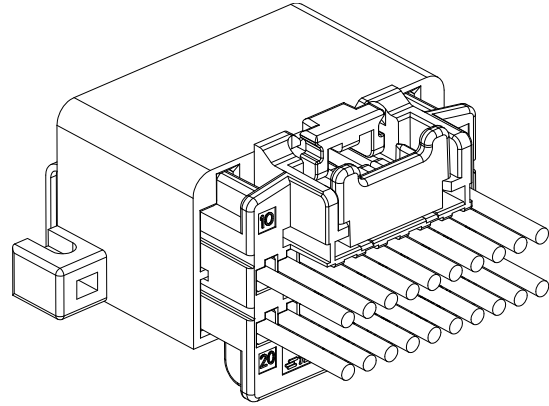
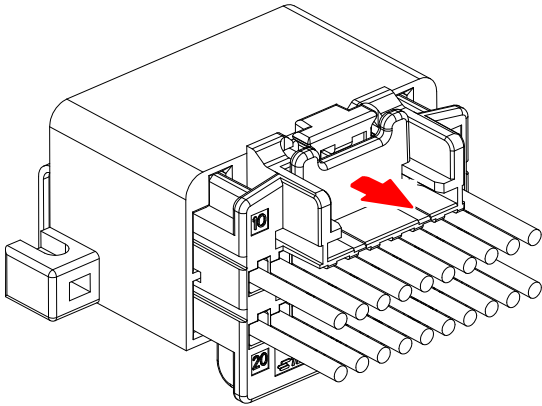
**2 To LOCK CPA After Connector Mate:** PUSH CPA forward until an audible "click" is heard.



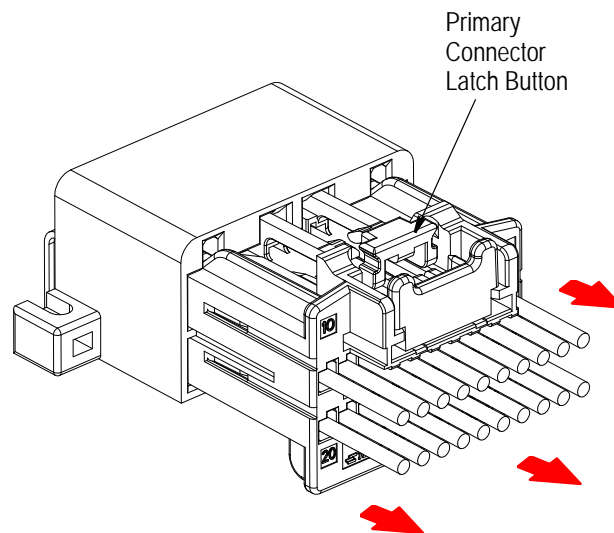
*Finally, push CPA forward to engage secondary lock and ensure proper CPA locking.*

## Unmating Instructions - with CPA

- 1 To UNMATE CPA:** Lightly PULL CPA back to Position 1 (pre-installed position) until audible "click" is heard.



- 2 To UNMATE Connector:** With CPA in Position 1, DEPRESS Primary Connector Latch button, then simultaneously pull connector/wires while gripping the housing with thumb, index finger, and palm (wire bundle).



## REVISION SUMMARY

- Initial release of document