

Module Installation & Contact Removal Instructions— Section 1

Hi-Density and Thermocouple Module/Contact Removal Instructions

2 Piece Module

P/N 510 104 134 (Receiver) 64 Positions

P/N 510 104 136 (Receiver) 96 Positions

P/N 510 104 149 (Receiver) 256 Positions

P/N 510 104 133 (Receiver) Thermo 64 Positions

P/N 510 108 101 (ITA) 64 Positions

P/N 510 108 126 (ITA) 96 Positions

P/N 510 108 131 (ITA) 256 Positions

P/N 510 108 124 (ITA) Thermo 64 Positions

PARTS/TOOLS REQUIRED:

3/32 Allen Wrench

5/64 Allen Wrench

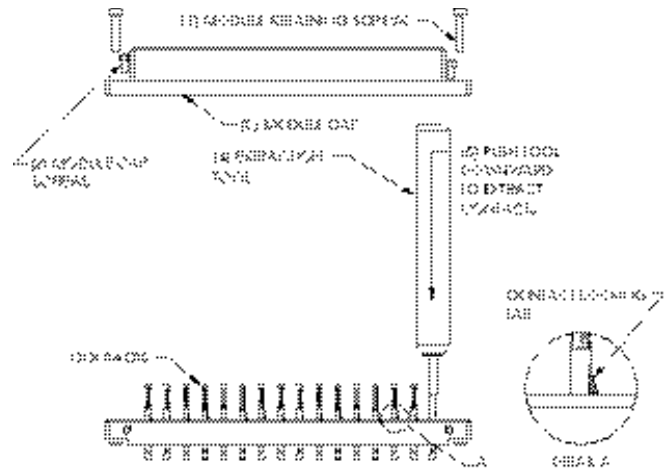
Phillips screwdriver (for 510 104 149 only)

Signal Contact Extraction Tool (P/N 910 110 102)

INSTRUCTIONS:

Receiver

1. Remove the two module retaining screws using a 3/32 Allen Wrench.
2. Remove the two module cap screws using a 5/64 Allen Wrench. (or a Phillips screwdriver for P/N 510 104 149)
3. Remove the module cap.
4. Place the Signal Contact Extraction Tool (P/N 910 110 102) over the Contact to be removed/replaced until the Tool touches the face of the Module - releasing the locking tab. **DETAIL A. Use caution to keep the tool perpendicular to the face of the module to prevent damage to either the tool or contact.** **DETAIL A.**
5. Press downward on the tool handle. The spring action of the tool will extract the contact.
6. On the opposite side of the module from the extraction tool, grasp the contact with your fingers and hold it while removing the extraction tool. (This will avoid pulling the contact back into the locked position.)
7. Replace the contact, module cap, and screws.

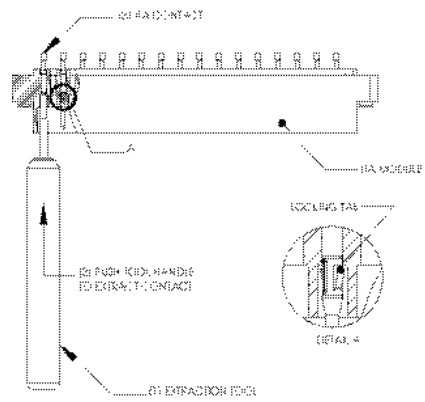


CAUTION: When replacing the upper portion of the two piece module, torque both screws 3 to 4 inch pounds. Torque above 4 inch pounds can cause serious damaged to module lower portion. For 540 104 149 module only, torque screws to 1 ½ inch pounds.

NOTE: In order to maintain contact float, wires should be restrained a minimum of 2 inches from the back face of the module by using a strain relief method (recommended for both Receiver and ITA Modules).

ITA

1. Place the Signal ITA Extraction Tool (VPC P/N 910 110 102) over the ITA Contact to be removed/replaced until the tool touches the face of the module - releasing the locking tab. **DETAIL A. Use caution to keep the tool perpendicular to the face of the module to prevent damage to either the tool or contact.** **DETAIL A.**
2. Press downward on the tool handle. The spring action of the tool will extract the contact.
3. On the opposite side of the module from the extraction tool, grasp the contact with your fingers and hold it while removing the extraction tool. (This will avoid pulling the contact back into the locked position.)



Module (Receiver & ITA) Installation/Removal

1. Place the Module in the Receiver or ITA until the upper and lower module screws touch the mating holes in the inner frame. (Install modules such that Pin 1 is located at the top of the ITA/Receiver frame.)
2. Using a 3/32 Allen wrench, tighten the top screw 1 to 2 full revolutions, while pushing lightly against the face of the module.
3. Maintain this pressure while tightening the bottom screw 1 to 2 full revolutions.
4. Repeat this sequence until the module is seated. Torque the screw until it is 8 to 10 inch pounds (clamping load 350 to 400 pounds).
5. To remove, loosen the top screw 1 to 2 full revolutions. Loosen bottom screw 1 to 2 full revolutions.
6. Repeat this sequence until the module is separated from the Receiver or ITA.

Updated 6/23/08