

Contact and Module Installation/Removal Instructions— Section 1

75 OHM & 20 GHz Contact Module/Contact Removal/Installation Instructions

P/N 510 104 249 (Receiver) 75 OHM 32 Positions	P/N 510 108 179 (ITA) 32 Positions
P/N 510 104 251 (Receiver) 20 GHz 32 Positions	P/N 510 108 179 (ITA) 32 Positions
P/N 610 102 109 & 610 102 116 (Receiver) 20 GHz Contacts	P/N 610 102 110 & 610 102 117 (ITA) 20 GHz Contacts

PARTS/TOOLS REQUIRED:

20 GHz/75 OHM Receiver and ITA Contact Extraction Tool (P/N 910 112 117)
 5/64 Allen wrench
 3/32 Allen Wrench

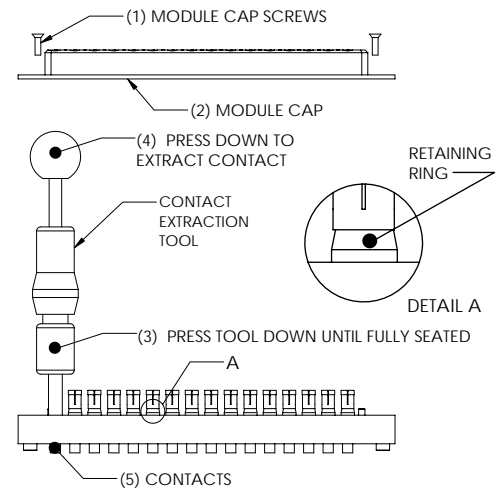
CONTACT INSTALLATION INSTRUCTIONS:

1. Place the nose of the contact into the module cavity hole. Before continuing into the cavity, make sure the opening on the clip ring is underneath the contact. This will cause the clip ring to center better around the contact.
 2. Center the Clip Ring's leading edge in the cavity and insert.
 3. As you press in and meet resistance, gently wiggle the contact in an approximate circular motion while pressing in. This allows the ring to overcome frictional forces as it collapses and enters the narrowest area of the cavity.
 4. Finish the installation by pressing in fully to seat the connector in the housing.
- NOTE:** Most times you will hear and/or feel a snap to indicate seating.
6. Verify this with a gentle tug on the connector to see that it doesn't slide back out.

CONTACT REMOVAL INSTRUCTIONS:

Receiver

1. Remove the two module cap screws using a 5/64 Allen wrench.
2. Remove the module cap.
3. Use the 20 GHz/75 OHM Receiver/ITA Contact Extraction Tool (VPC P/N 910 112 117) and insert firmly over the contact by applying pressure with the shaft. **Do not apply pressure with the handle area. Use caution to keep the tool perpendicular to the module face to prevent possible damage to either the tool or contacts.**
4. Apply pressure with the handle area only when the tool has slipped over the retaining ring and has collapsed the tabs. (Twisting the lower portion of the tool will ensure that the tabs have collapsed.)
5. 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.)
6. Replace the contact, module cap, and screws.



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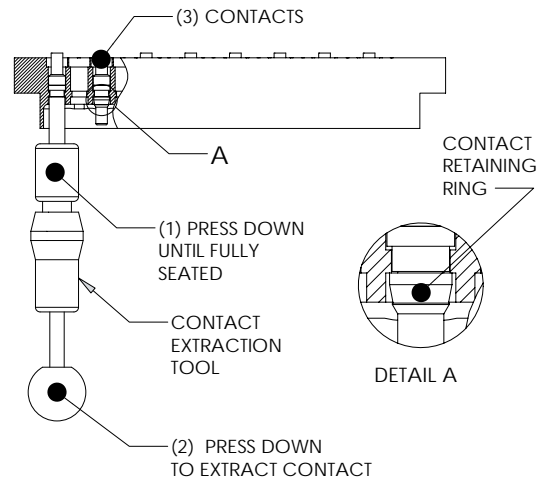
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ITA

1. Use the 20 GHz/75 OHM Receiver and ITA Contact Extraction Tool (P/N 910 112 117 and insert firmly over the contact by applying pressure with the shaft. **Do not apply pressure with the handle area. Use caution to keep the tool perpendicular to the module face to prevent possible damage to either the tool or contacts.**
2. Apply pressure with the handle area only when the tool has slipped over the retaining ring (See Detail A) and has collapsed the ring. (Twisting the lower portion of the tool will ensure that the tabs have collapsed.)
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.)

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



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.