

CONTACT INSTALLATION AND REMOVAL INSTRUCTIONS

QUADRAPADDLE™ SIGNAL ITA TERMINAL ASSEMBLY • PART # 610 138 109, 610 138 112, 610 138 115
192 POSITION MODULE, UNLOADED AND LOADED • PART # 510 151 105, 510 151 107
480 POSITION MODULE, UNLOADED AND LOADED • PART # 510 151 106, 510 151 108

TOOLS REQUIRED

$\frac{3}{32}$ Allen Wrench
QuadraPaddle™ ITA Extraction Tool, Part # 910 110 111

INSTALLATION INSTRUCTIONS

1. With the new replacement contact crimped to the wire, insert the contact in the cavity on the backside of the module at the location it was removed. Push the contact forward until the contact crimp is inside the module housing. Be sure to push the contact forward enough to latch the locking tab in place.
2. Install module in mounting frame per the module mounting instructions.

REMOVAL INSTRUCTIONS

1. Remove the two or four module retaining screws using a $\frac{3}{32}$ Allen Wrench.
2. To remove the ITA contacts place the ITA Extraction tool over the contact to be removed into the counter bore on the mating side of the module, **Figure 6-A**. Once seated, rotate the extraction tool slightly to ensure proper seating while pressing into the counter bore until the retaining ring is released.
3. Push the plunger of the extraction tool forward and the contact will be pushed out the backside of the module.

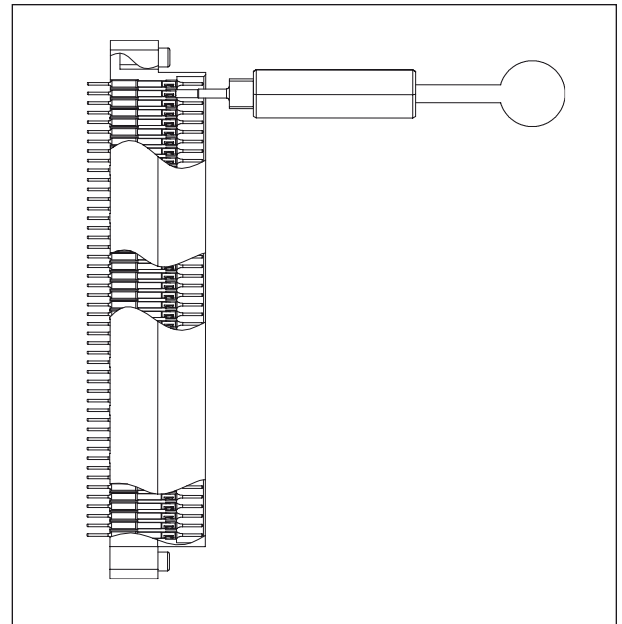


Figure 6-A.