



# ASSEMBLY, INSTALLATION, AND REMOVAL OF CONTACTS AND MODULES

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FOR PNEUMATIC CONTACTS AND MODULES

## **INDEX** ([CLICK TO NAVIGATE TO PAGE](#))

**PAGE**

### **RECEIVER CONTACTS**

**1** [3/8 CONTACT INSTALLATION & REMOVAL INSTRUCTIONS](#)

**2** [1/8 CONTACT INSTALLATION & REMOVAL INSTRUCTIONS](#)

### **ITA CONTACTS**

**3** [3/8 CONTACT INSTALLATION & REMOVAL INSTRUCTIONS](#)

**4** [1/8 CONTACT INSTALLATION & REMOVAL INSTRUCTIONS](#)

### **MODULES & SPECIFICATIONS**

**5** [90 SERIES MODULE INSTALLATION & REMOVAL](#)

**6** [3/8 PERFORMANCE SPECIFICATIONS](#)

**7** [1/8 PERFORMANCE SPECIFICATIONS](#)

**8** [CROSS REFERENCE TABLES](#)

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For the most current information available, visit [vpc.com](http://vpc.com).*

02/16/2026

## $\frac{3}{8}$ " RECEIVER CONTACT INSTALLATION AND REMOVAL

PART # 610131101 / 610131104

### TOOLS REQUIRED

$\frac{3}{4}$ " Wrench

$\frac{13}{16}$ " Wrench

### CONTACT INSTALLATION INSTRUCTIONS

*Note: This contact is for  $\frac{3}{8}$ " ID [9.5 mm] hose.*

1. Remove the nut from the contact.
2. Insert contact into module.
3. Holding the contact with the  $\frac{3}{4}$ " wrench, replace nut and tighten to 8 in-lbs [0.90 N•m] using the  $\frac{13}{16}$ " wrench (**Figure A**).
4. Slide hose onto contact, making sure that all barbs are covered by the hose (**Figure B**).

### CONTACT REMOVAL INSTRUCTIONS

1. Remove the module from the receiver frame.  
*NOTE: For more information concerning the process of removing the module from the receiver frame, see module installation and removal instructions in Section 2 of this User Manual.*
2. Detach hose from contact.
3. Holding contact with  $\frac{3}{4}$ " wrench, loosen and remove nut with  $\frac{13}{16}$ " wrench.
4. Remove contact from module.

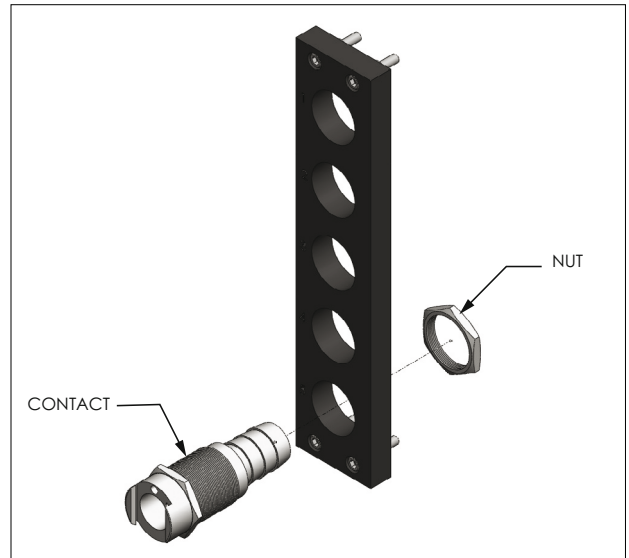


Figure A. Insert contact into module and tighten nut.

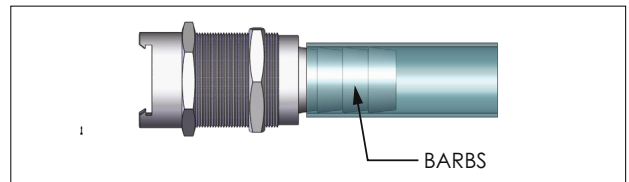


Figure B. Slide hose onto contact.

## 1/8" RECEIVER CONTACT INSTALLATION AND REMOVAL

PART # 610132105 / 610131107 / 610131106

### CONTACT INSTALLATION INSTRUCTIONS

*Note: This contact is for 1/8" ID [3.2 mm] hose.*

1. Press contact into module until it snaps in place (**Figure A**).
2. Slide hose onto contact, making sure that all barbs are covered by the hose (**Figure B**).

### CONTACT REMOVAL INSTRUCTIONS

1. Remove module from the receiver frame.  
*NOTE: For more information concerning the process of removing the module from the frame, see module installation and removal instructions in Section 2 of this User Manual.*
2. Detach hose from contact.
2. Press contact out of the other side of the module (**Figure C**).  
*NOTE: Some force will be required to remove contact from module.*

*NOTE: Can be used in either a receiver or ITA module, but must be mated with Part # 610131106 in the remaining module.*



Figure A. Press contact into module.

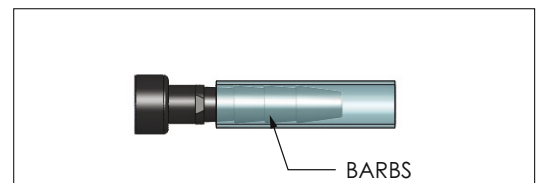


Figure B. Slide hose onto contact.

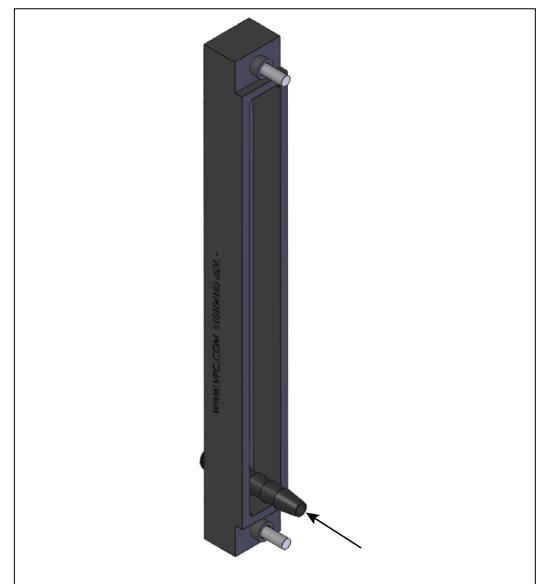


Figure C. Press contact out of module.

[RETURN TO INDEX](#)

## $\frac{3}{8}$ " ITA CONTACT INSTALLATION AND REMOVAL

PART # 610132101 / 610132104

### TOOLS REQUIRED

$\frac{3}{4}$ " Wrench  
 $\frac{13}{16}$ " Wrench

### CONTACT INSTALLATION INSTRUCTIONS

*Note: This contact is for  $\frac{3}{8}$ " ID [9.5 mm] hose.*

1. Remove the nut from the contact.
2. Insert contact into module.
3. Holding the contact with the  $\frac{3}{4}$ " wrench, replace nut and tighten to 8 in-lbs [0.90 N•m] using the  $\frac{13}{16}$ " wrench (**Figure A**).
4. Slide hose onto contact, making sure that all barbs are covered by the hose (**Figure B**).

### CONTACT REMOVAL INSTRUCTIONS

1. Remove the module from the ITA frame.  
*NOTE: For more information concerning the process of removing the module from the ITA frame, see module installation and removal instructions in Section 2 of this User Manual.*
2. Detach hose from contact.
3. Holding contact with  $\frac{3}{4}$ " wrench, loosen and remove nut with  $\frac{13}{16}$ " wrench.
4. Remove contact from module.

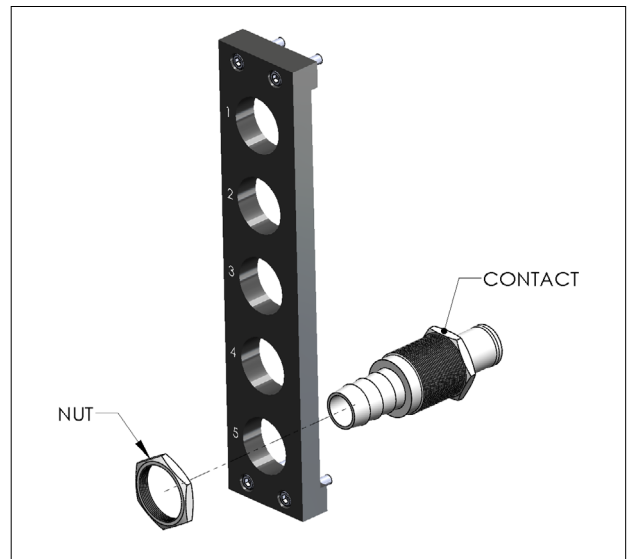


Figure A. Insert contact into module and tighten nut.

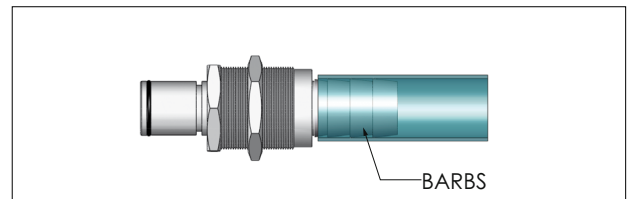


Figure B. Slide hose onto contact.

## 1/8" ITA CONTACT INSTALLATION AND REMOVAL

PART # 610131106

### CONTACT INSTALLATION INSTRUCTIONS

Note: This contact is for 1/8" ID [3.2 mm] hose.

1. Press contact into module until it snaps in place (**Figure A**).
2. Slide hose onto contact, making sure that all barbs are covered by the hose (**Figure B**).

### CONTACT REMOVAL INSTRUCTIONS

1. Remove module from the ITA frame.  
*NOTE: For more information concerning the process of removing the module from the receiver frame, see module installation and removal instructions in Section 2 of this User Manual.*
2. Detach hose from contact.
3. Press contact out of the other side of the module (**Figure C**).  
*NOTE: Some force will be required to remove contact from module.*



Figure A. Press contact into module.

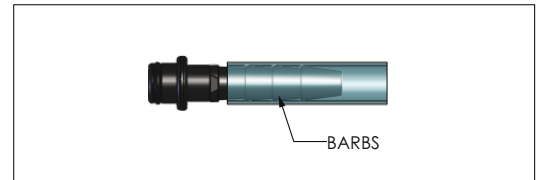


Figure B. Slide hose onto contact.

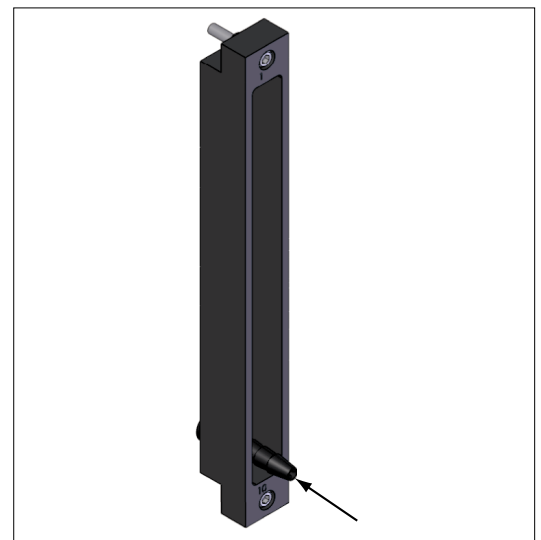


Figure C. Press contact out of module.

[RETURN TO INDEX](#)

## 90 SERIES MODULE INSTALLATION AND REMOVAL

PART # 510104185/ 510108160/ 510108264

510104160/ 510104276/ 510108144

### TOOLS REQUIRED

$\frac{3}{32}$ " Allen Wrench

### INSTALLATION INSTRUCTIONS

1. Place the module in the receiver or ITA until the upper and lower module screws touch the mating holes in the inner frame. Ensure that Position 1 is located at the top for systems in which the modules are oriented vertically or to the left for systems in which the modules are oriented horizontally.
2. Using a  $\frac{3}{32}$ " Allen wrench, tighten the top screw one to two full revolutions, while pushing lightly against the face of the module.
3. Maintain this pressure while tightening the bottom screw one to two full revolutions.
4. Repeat this sequence until the module is seated. Torque the screw to 4 in-lbs [0.45 N•m].

### REMOVAL INSTRUCTIONS

1. To remove, loosen the top screw one to two full revolutions. Loosen bottom screw one to two full revolutions.
2. Repeat this sequence until the module is separated from the receiver or ITA.

*Note: For optimum performance and system longevity, distribute the contact load evenly throughout the module.*

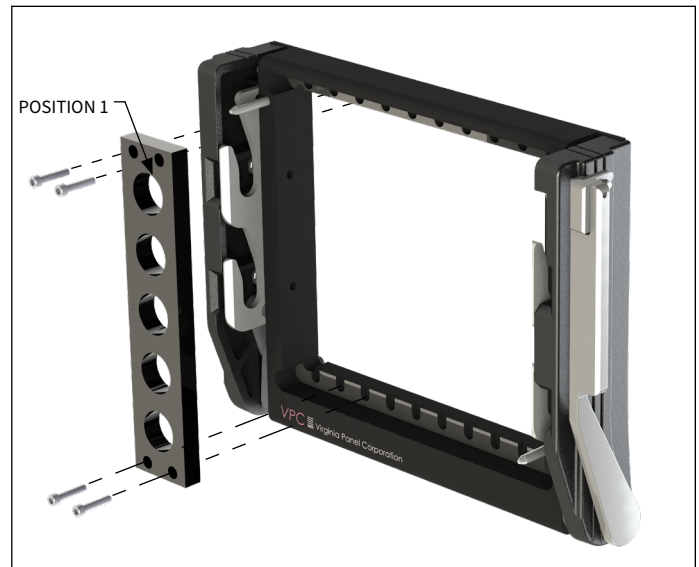


Figure A. Receiver Module.

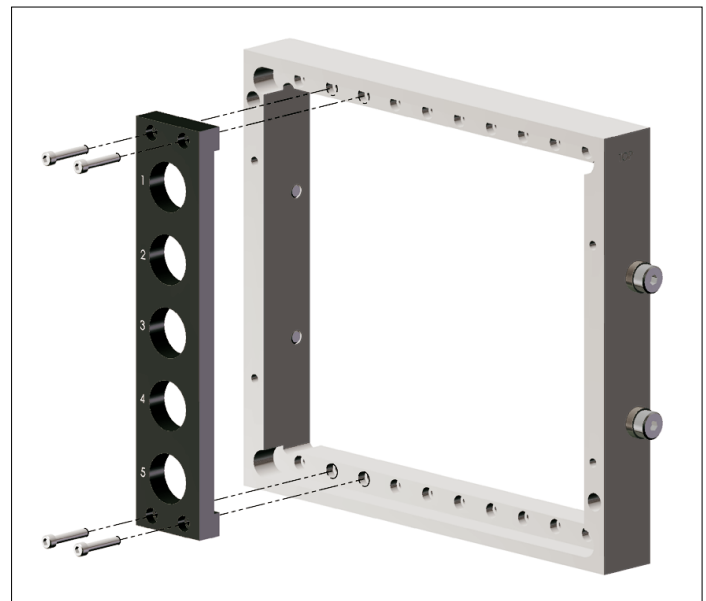
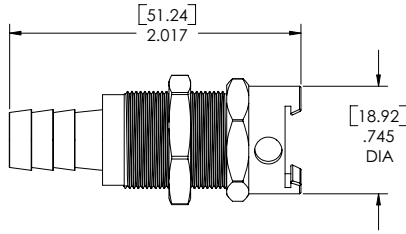
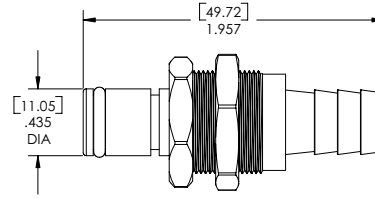


Figure B. ITA Module.

### 3/8" PERFORMANCE SPECIFICATIONS



**Receiver Contact**  
Part # 610131104



**ITA Contact**  
Part # 610132104

Dimensions shown: [millimeters]  
inches

#### Product Specifications

<b>PRESSURE/VACUUM RATED</b>	250 PSI [17.3 Bar]
<b>OPERATING TEMPERATURE</b>	-40°F to 180°F [-40°C TO 82°C]

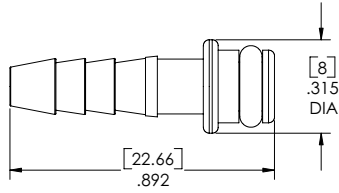
#### Mechanical Characteristics

<b>CYCLE LIFE</b>	20,000 cycles
<b>INSERTION FORCE</b>	9.4 lbs typical [4.26 kg]

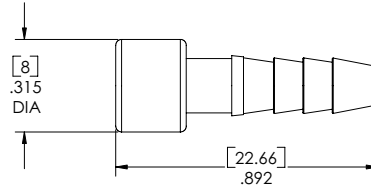
#### Material

<b>CONTACT BODY</b>	Chrome-Plated Brass
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## 1/8" PERFORMANCE SPECIFICATIONS



**Receiver Contact**  
Part # 610131106



**ITA Contact**  
Part # 610132105

Dimensions shown: [millimeters]  
inches

### Product Specifications

<b>PRESSURE/VACUUM RATED</b>	100 PSI [6.9 Bar]
<b>OPERATING TEMPERATURE</b>	-40°F to 180°F [-40°C TO 82°C]

### Mechanical Characteristics

<b>CYCLE LIFE</b>	20,000 cycles
<b>INSERTION FORCE</b>	1.5 lbs typical [0.68 kg]

### Material

<b>CONTACT BODY</b>	Delrin®
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### CROSS REFERENCE TABLES

RECEIVER CONTACTS	STANDARD/ 90 SERIES RECEIVER MODULES		
	510104160	510104185	510 104276
610131101	X		X
610131104	X		X
610132105		X	
610131107		X	

ITA CONTACTS	STANDARD/ 90 SERIES ITA MODULES			REPLACEMENT O-RING KIT 3/8" [9.mm]	REPLACEMENT O-RING KIT (1/8" [3.2mm])
	510108144	510108160	510108264	610132113	610132114
610132101	X		X	X	
610132104	X		X	X	
610131106		X			X