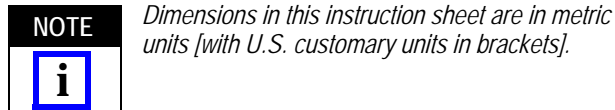


Figure 1

1. INTRODUCTION

Multi-Lock .040 II Series 8-Position Side Lock Plug Housings accept Receptacle Contact 175265-1. These instructions cover inserting the contacts into and extracting the contacts from the housing. Extraction Tool 755430-1 is required to remove the contacts from the housing.

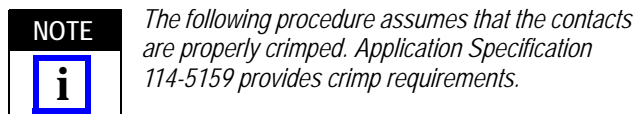


2. DESCRIPTION (Refer to Figure 1)

The contact features reverse insertion tabs which prevent the contact from being inserted into the housing upside-down. When inserted into the housing, the contact snaps onto the housing primary lock to ensure that the contact is fully inserted.

After all contacts are inserted into the housing, the housing incorporates a secondary lock (a hinged side-lock) that provides retention of the contacts in the housing as well as detecting contacts that are not fully seated.

3. INSERTION PROCEDURE



1. If the housing side-lock is not in the pre-lock position (OPEN), open the side-lock as follows: carefully lift the side-lock until it is OPEN (a standard flat-blade screwdriver may be used). Refer to Figure 2.

2. Insert contact into desired contact cavity at the wire end of the housing with the reverse insertion tabs facing the locking latch. See Figure 1. Push the contact until it stops; there will be an audible 'click' when the contact is fully inserted.

3. Lightly pull back on the wire (maximum force of 20 N [4.5 lb]) to ensure that the contact has engaged the housing. See Figure 3, Detail A.

4. After inserting all contacts, press the housing side-lock until it is in the final-lock position (CLOSED). Make sure that the side-lock is fully CLOSED. See Figure 3, Detail B.

If the side-lock will not fully close, open the side-lock, ensure that all contacts are fully inserted, then repeat Step 4. **DO NOT force the side-lock to close.**

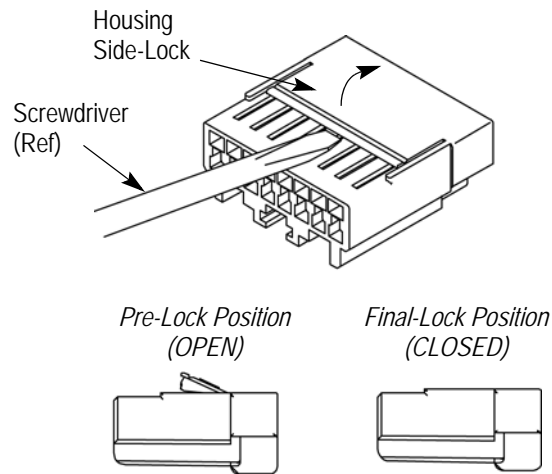


Figure 2

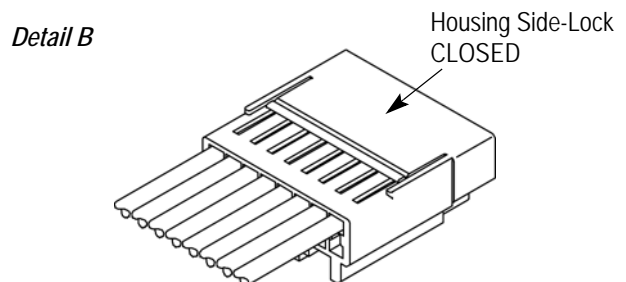
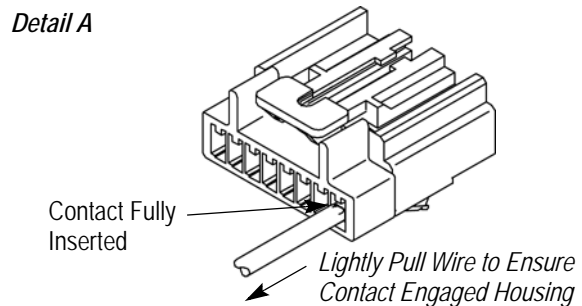
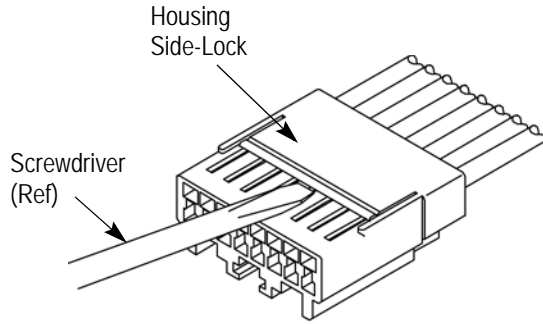


Figure 3

Detail A



Detail B

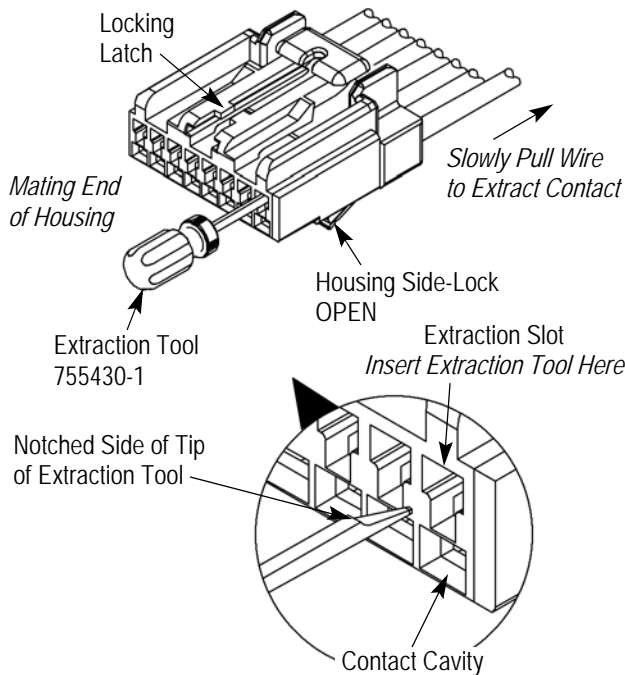


Figure 4

4. EXTRACTION PROCEDURE

1. Carefully lift the housing side-lock until it is in the pre-lock position (OPEN) (a standard flat-blade screwdriver may be used). See Figure 4, Detail A. *The side-lock must be OPEN before extracting any contacts from the housing.*

2. From the mating end of the housing, insert the extraction tool with the notched side of the tip facing the locking latch straight into the extraction slot (opening closest to locking latch) until it stops. See Figure 4, Detail B. This will release the contact. **DO NOT** force the extraction tool; otherwise, deformation of the contact will occur.



CAUTION TAKE CARE NOT to insert the extraction tool into the contact cavity; otherwise, damage to the contact will occur. See Figure 4, Detail B. Damaged contacts should not be used. If a damaged contact is evident, it should be cut from the wire and replaced with a new one. Contacts must not be reterminated.

3. Holding the extraction tool in place, grasp the wire, and slowly pull the contact straight out of the housing. **DO NOT** apply unnecessary force.

4. After removing the contact, press the housing side-lock until it is in the final-lock position (CLOSED). Make sure that the side-lock is fully CLOSED. Refer to Figure 2.

5. REPLACEMENT AND REPAIR

Any contacts extracted from the housing more than 10 times must be discarded and replaced. **DO NOT** reuse a terminated contact by removing the wire. Housings requiring more than two cycles of opening (pre-lock position) and closing (final-lock position) the side-lock must be discarded and replaced.

The contacts and housings are not repairable. Discard and replace any defective or damaged contacts or housings.

6. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Updated document to corporate requirements.