



MX150/MX150L ASSEMBLY INSTRUCTIONS

RECEPTACLE ASSEMBLY

TERMINAL INSERTION

1. Begin assembly of the crimped female terminals into the receptacle housing by making sure the Terminal Position Assurance feature (TPA) is in the pre-locked position (See Figure 1). If it is not, insert the blade of a screwdriver into the slots in the TPA found adjacent to latch or opposite. Apply slight pressure and pry the TPA out until it clicks. You are now ready to insert terminals or circuit plugs.

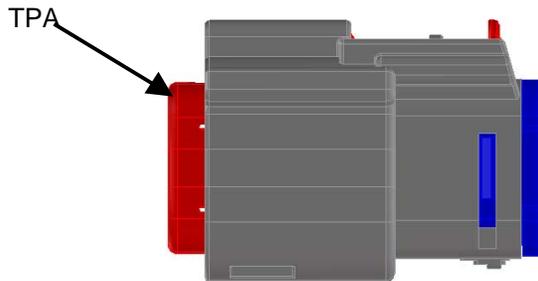


Figure 1: TPA in Pre-Lock Position

2. The terminal must be positioned correctly when inserted into the housing to assure proper latching and retention. Orient the key on the back of the female terminal with the keyway on the wire entry cavity in the rear of the housing (See Figure 2). Insert the terminal into the housing until it clicks or a slight pull back on the wire is met with resistance from terminal retention feature.

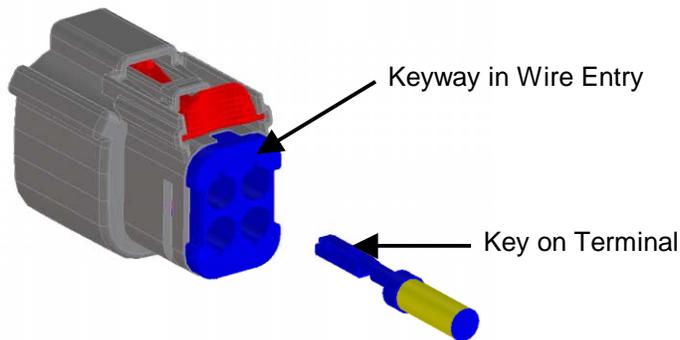


Figure 2: Terminal Orientation

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MX150/MX150L ASSEMBLY INSTRUCTIONS

- Repeat Step 2 until all terminals are inserted into the housing. If using a circuit plug to seal an unused circuit, the same procedure as terminal insertion is applied. If a terminal is inadvertently assembled into the wrong position, use service tool to remove.
- When all terminals or circuit plugs are in their proper location, push down on TPA until it clicks into place and is roughly flush or on same level as edge of outer housing (See figure 3).

TPA Flush with
Outer Housing

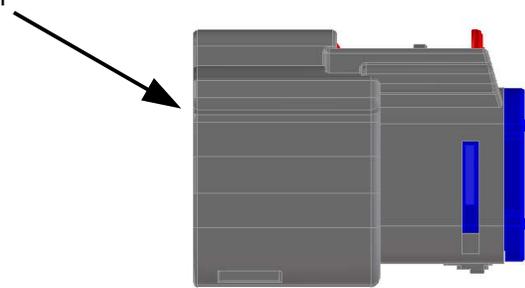


Figure 3: TPA in Locked Position

CONNECTOR POSITION ASSURANCE ACTIVATION

- After mating the plug and receptacle connectors, push the Connector Position Assurance feature (CPA) on the receptacle forward until it clicks or is as far forward towards mating end of receptacle as possible (See Figure 4). This will prevent accidental depression of latch and un-mating of connectors.

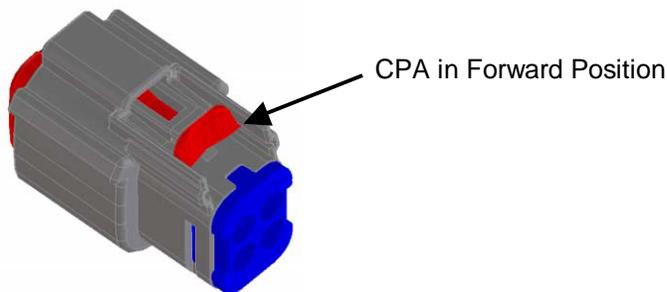


Figure 4: CPA in Locked Position

- To un-mate connectors, pull CPA towards rear or wire entry end of receptacle. While lightly pushing connectors together, depress latch and then pull the mated connectors apart.

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MX150/MX150L ASSEMBLY INSTRUCTIONS

PLUG ASSEMBLY

TERMINAL INSERTION

1. Begin assembly of the crimped male terminals into the plug housing by making sure the Terminal Position Assurance feature (TPA) is in the pre-locked position (See Figure 5). Since the TPA is recessed in housing, the most accurate way to determine if it is in pre-lock position is to measure. In pre-locked position the dimension between plug housing face and TPA is approximately 0.500”(12,7mm). If it is not in pre-locked position, insert the tips of a needle nose pliers into the two “D” shaped holes in the center of the TPA. Carefully, pull gently on the TPA until it starts moving. Pull to first stop. **CAUTION: DO NOT PULL TPA COMPLETELY OUT OF HOUSING. THIS MAY BREAK RETENTION FEATURES AND RESULT IN REDUCED TPA RETENTION IN HOUSING.** You are now ready to insert terminals or circuit plugs.

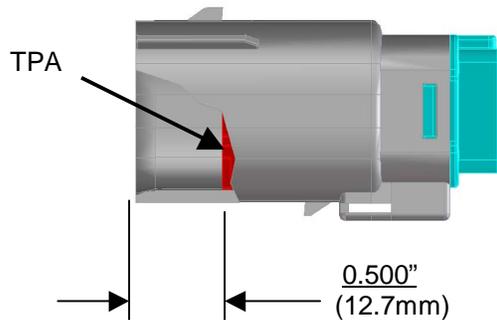


Figure 5: TPA in Pre-Locked Position

2. The terminal must be positioned correctly when inserted into the housing to assure proper latching and retention. Orient the key on the back of the male terminal with the keyway on the rear of the housing (See Figure 6). Insert the terminal into the housing until it clicks or a slight pull back on the wire is met with resistance from terminal retention feature.

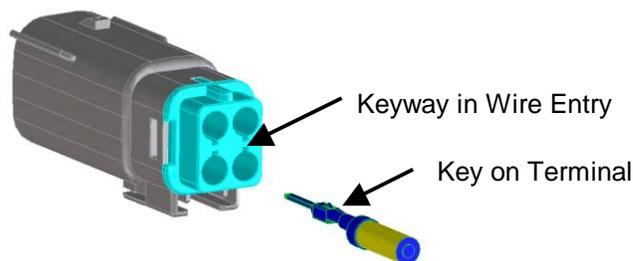


Figure 6: Terminal Orientation

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- Repeat Step 2 until all terminals are inserted into the housing. If using a circuit plug to seal an unused circuit, the same procedure as terminal insertion is applied. If a terminal is inadvertently assembled into the wrong position, use service tool to remove.
- When all terminals or circuit plugs are in their proper location, push down on TPA until it clicks into place and is now approximately 0.700”(17.8mm) from mating edge of outer housing (See figure 7).

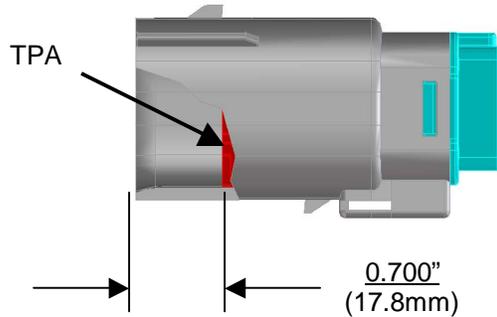


Figure 7: TPA in Locked Position

CONGRATULATIONS! YOU NOW HAVE ONE OF THE MOST RELIABLE, ENVIRONMENTALLY SEALED (IP67) CONNECTOR SYSTEMS AVAILABLE!

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