

DELPHI

ASSEMBLY MANUALS

PRE - ASSEMBLY

HARNESS ASSEMBLY

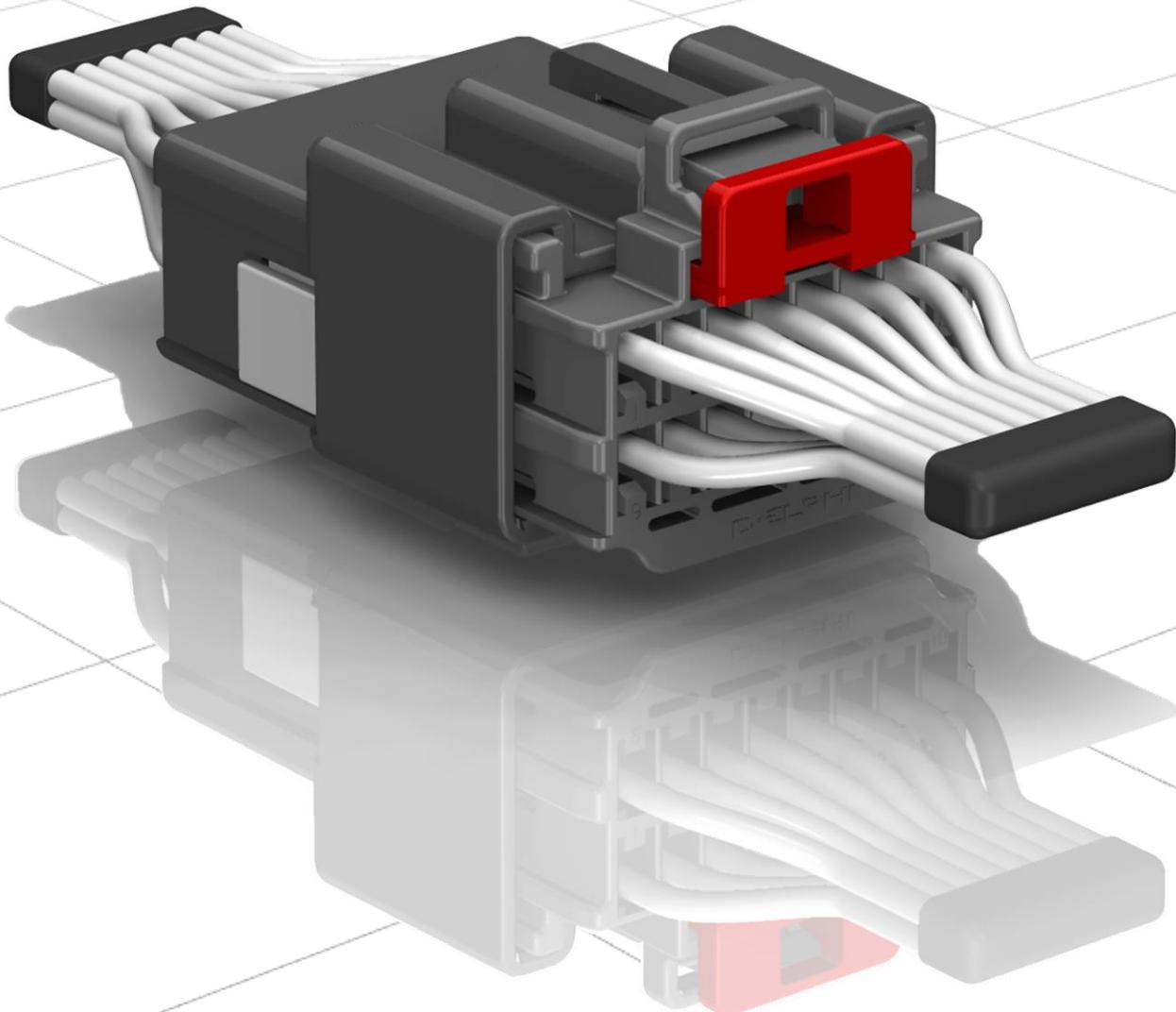
CAR ASSEMBLY

ASSEMBLY MANUAL - 13984858

1.5 OCS Unsealed Connection System

1.5 OCS Terminal System

February 2016

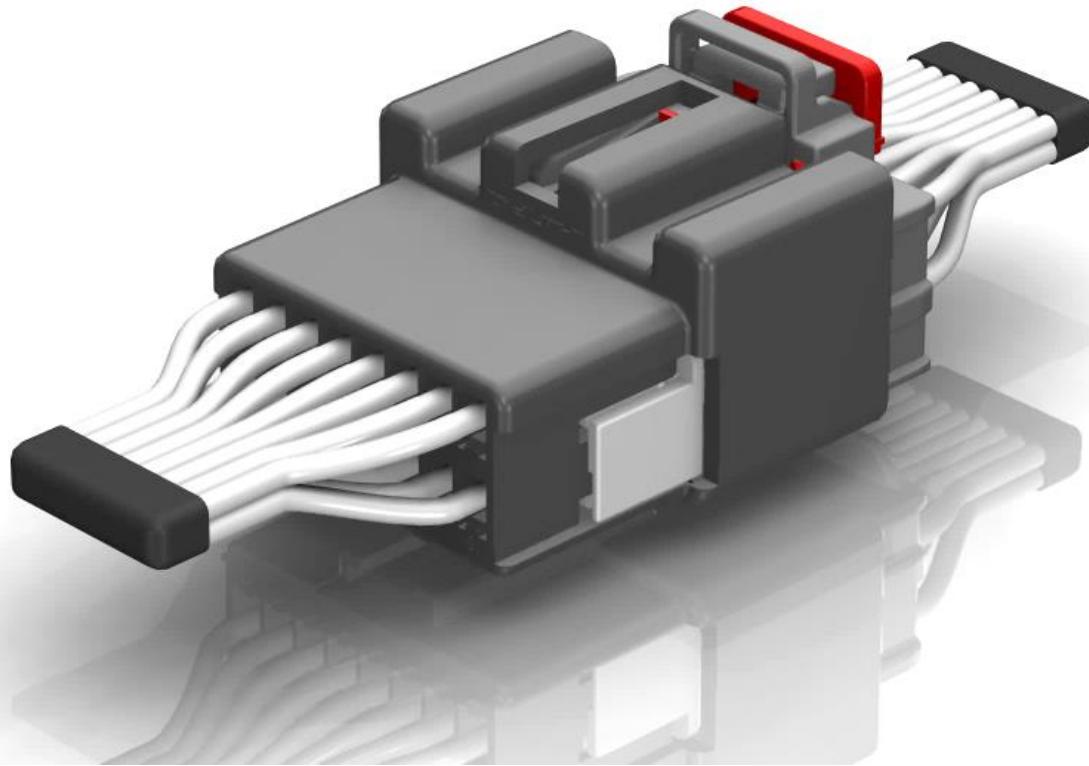


Issued by
CTC Warren, Ohio
STC Saltillo, Mex.



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ASSEMBLY

ASSEMBLY OF THE FEMALE CONNECTOR

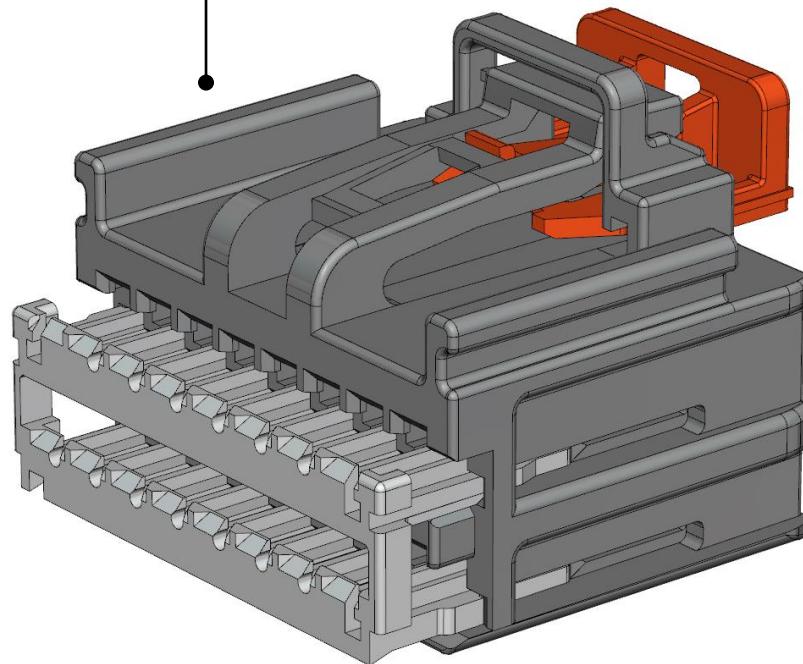
PRE - ASSEMBLY

HARNESS ASSEMBLY

CAR ASSEMBLY

1.5 OCS Unsealed Connection System

FEMALE ASSEMBLY



ASSEMBLY

VIEW OF VERSIONS

2 Way Connector

TYPE 101

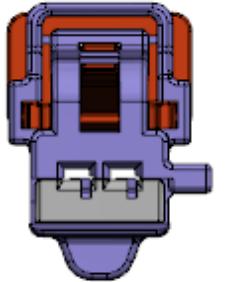
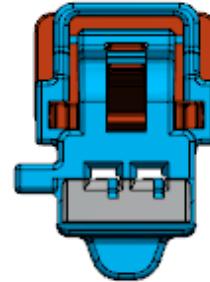
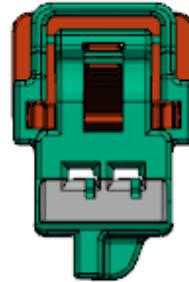
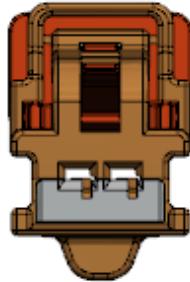
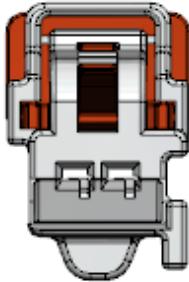
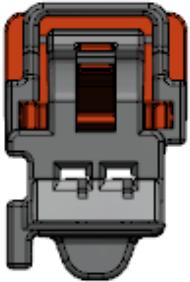
TYPE 102

TYPE 103

TYPE 104

TYPE 105

TYPE 106



3 Way Connector

TYPE 101

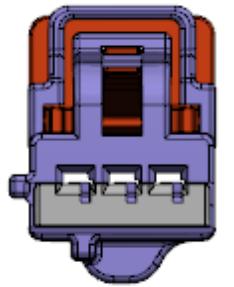
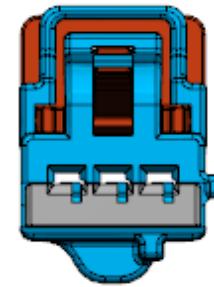
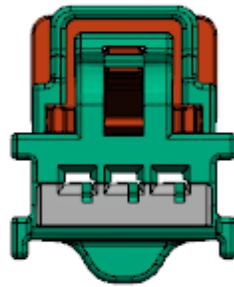
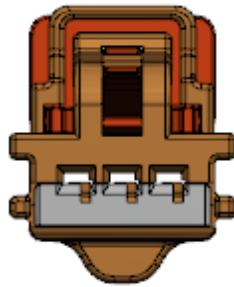
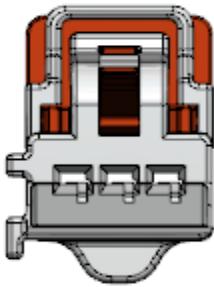
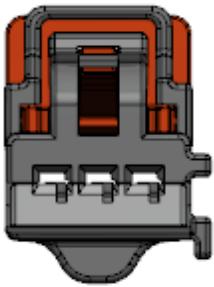
TYPE 102

TYPE 103

TYPE 104

TYPE 105

TYPE 106



4 Way Connector

TYPE 101

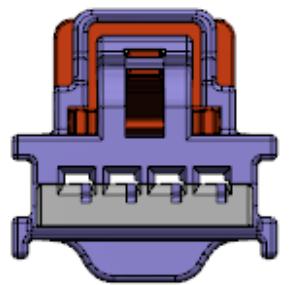
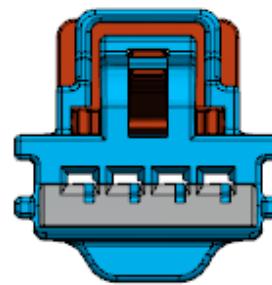
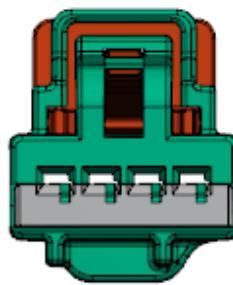
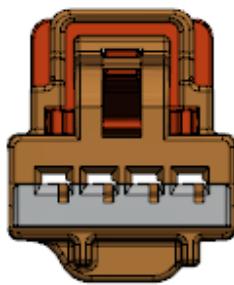
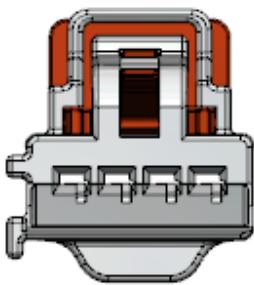
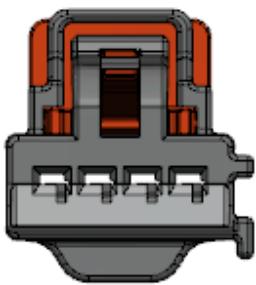
TYPE 102

TYPE 103

TYPE 104

TYPE 105

TYPE 106



6 Way Connector

TYPE 101

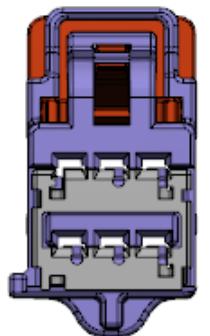
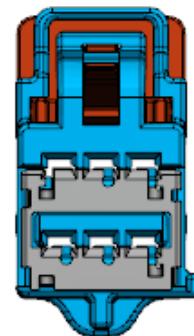
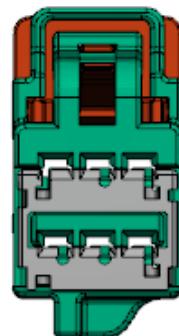
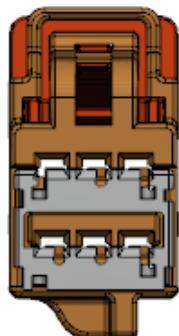
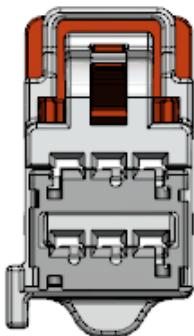
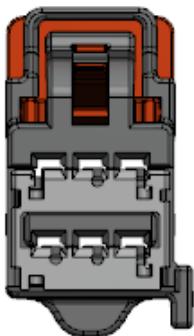
TYPE 102

TYPE 103

TYPE 104

TYPE 105

TYPE 106



EACH CONNECTION SYSTEM HAVE 6 DIFFERENT TYPES, WHICH DIFFER IN THE INDEXING AND COLOR, REFER TO LATEST DRAWINGS FOR DETAILS

ASSEMBLY

VIEW OF VERSIONS

8 Way Connector

TYPE 101

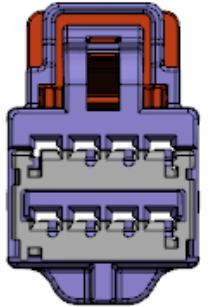
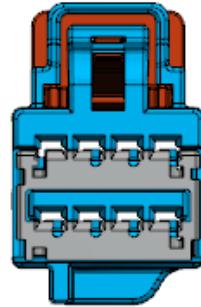
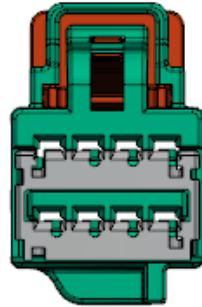
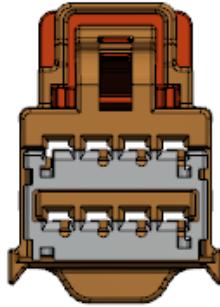
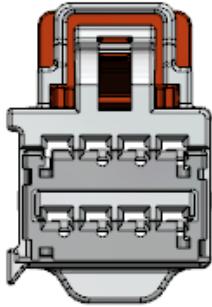
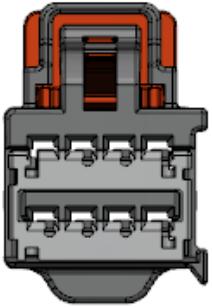
TYPE 102

TYPE 103

TYPE 104

TYPE 105

TYPE 106



10 Way Connector

TYPE 101

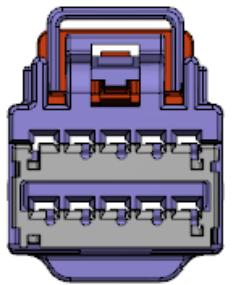
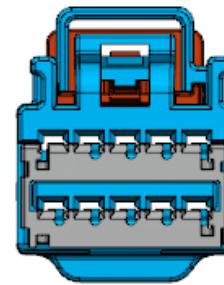
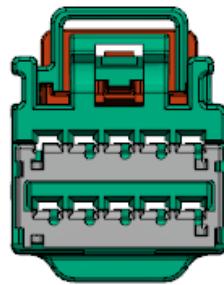
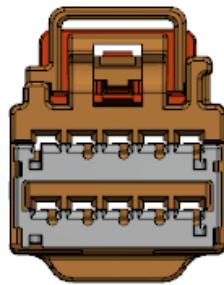
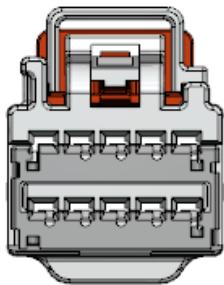
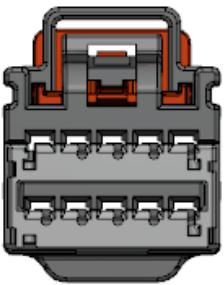
TYPE 102

TYPE 103

TYPE 104

TYPE 105

TYPE 106



12 Way Connector

TYPE 101

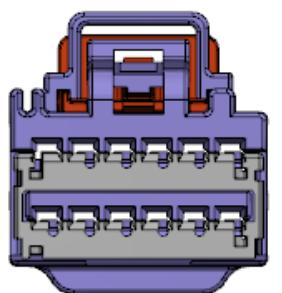
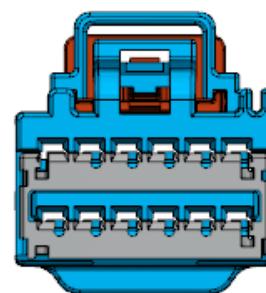
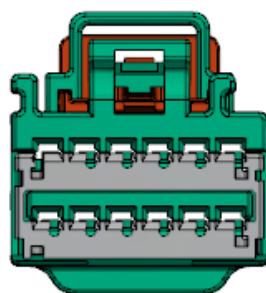
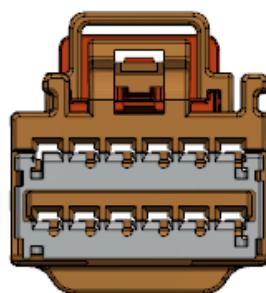
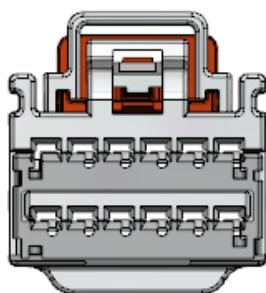
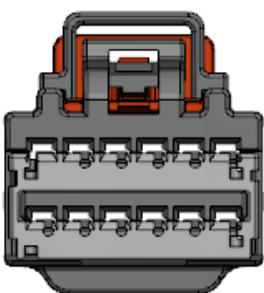
TYPE 102

TYPE 103

TYPE 104

TYPE 105

TYPE 106



16 Way Connector

TYPE 101

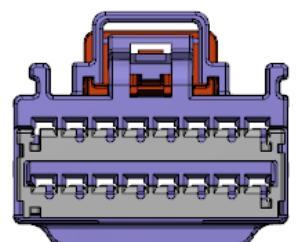
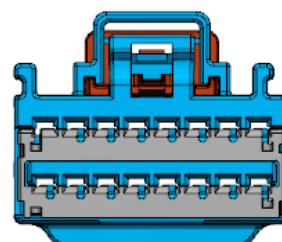
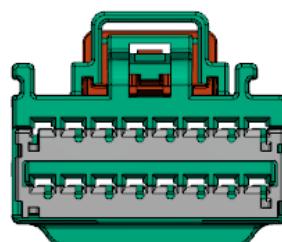
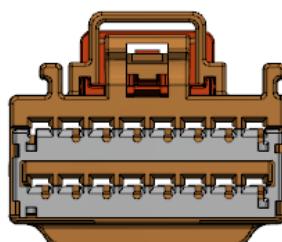
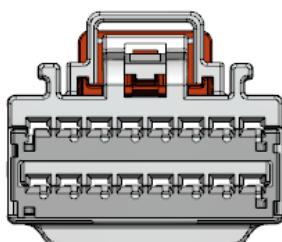
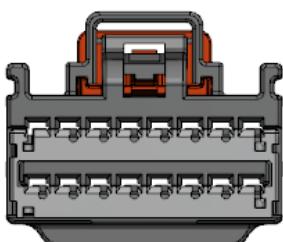
TYPE 102

TYPE 103

TYPE 104

TYPE 105

TYPE 106

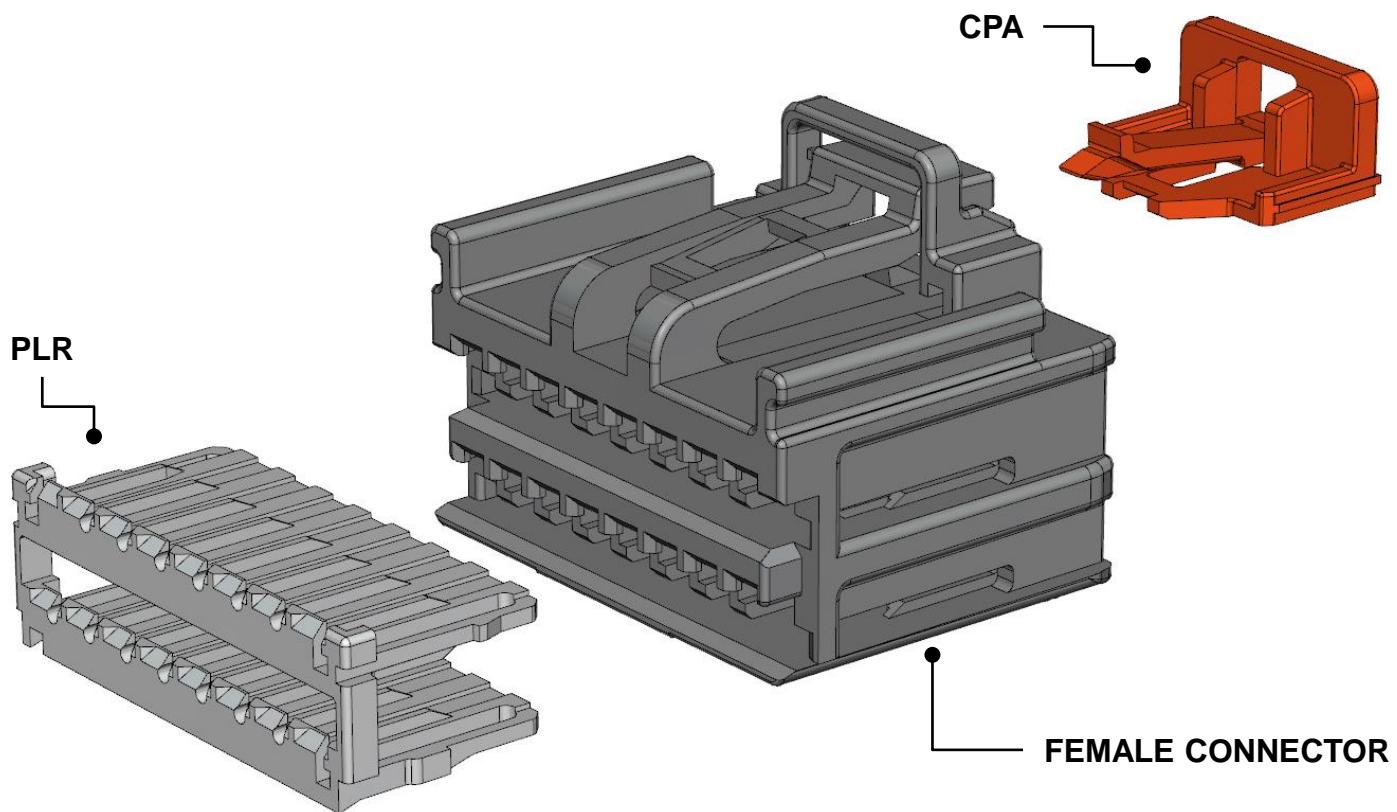


EACH CONNECTION SYSTEM HAVE 6 DIFFERENT TYPES, WHICH DIFFER IN THE INDEXING AND COLOR, REFER TO LATEST DRAWINGS FOR DETAILS

ASSEMBLY

LIST OF COMPONENTS & EXPLODED VIEW

| QUANTITY | COMPONENTS OF 1.5 OCS FEMALE CONNECTOR |
|----------|--|
| 1 | PLR |
| 1 | FEMALE CONNECTOR |
| 1 | CPA |

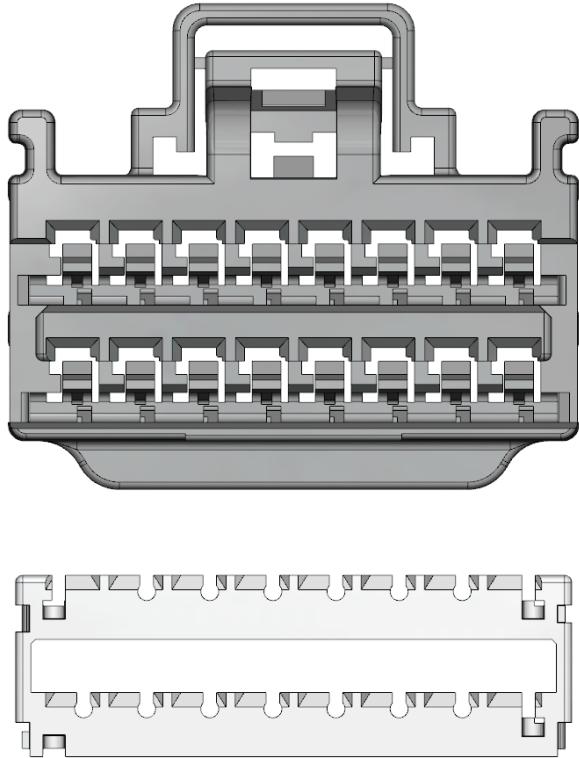


Pictures used in this Assembly Manual and original parts may differ in some details, these differences have no influence on the assembly process.

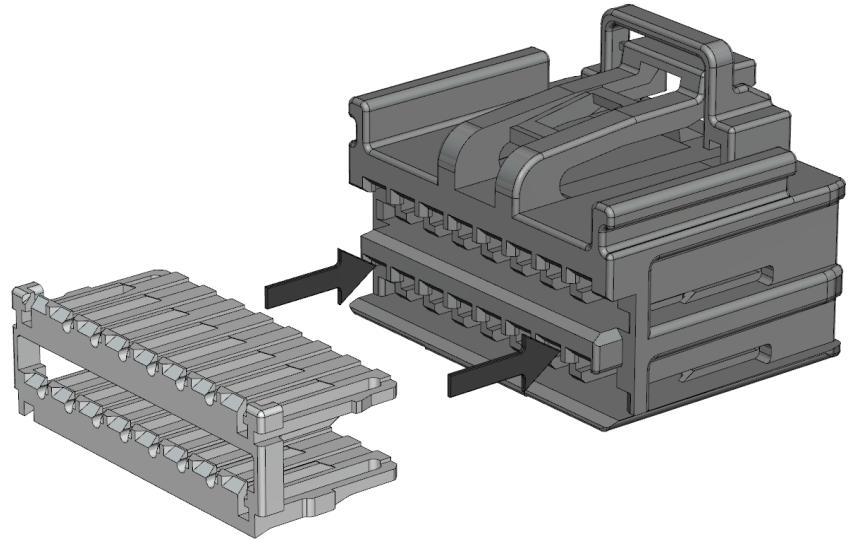
ASSEMBLY

STEP 1a – Align and Insert PLR (to Pre-Stage Position)

VERIFY THE ORIENTATION OF THE PLR

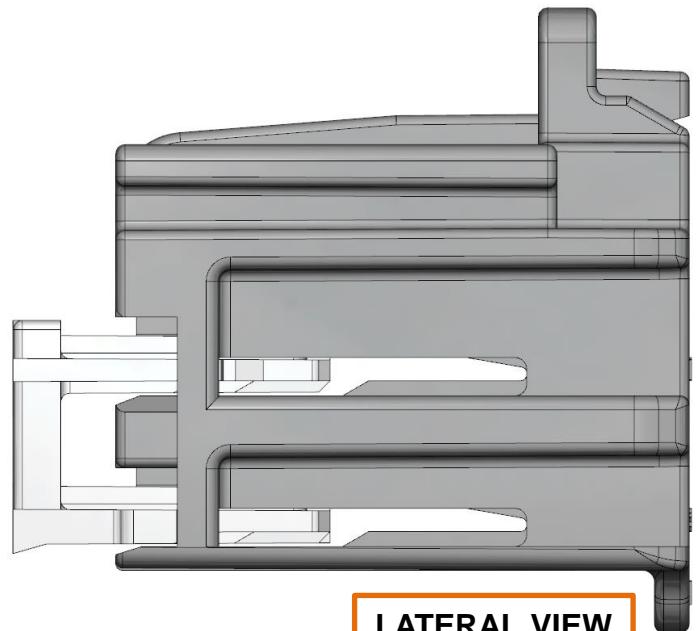
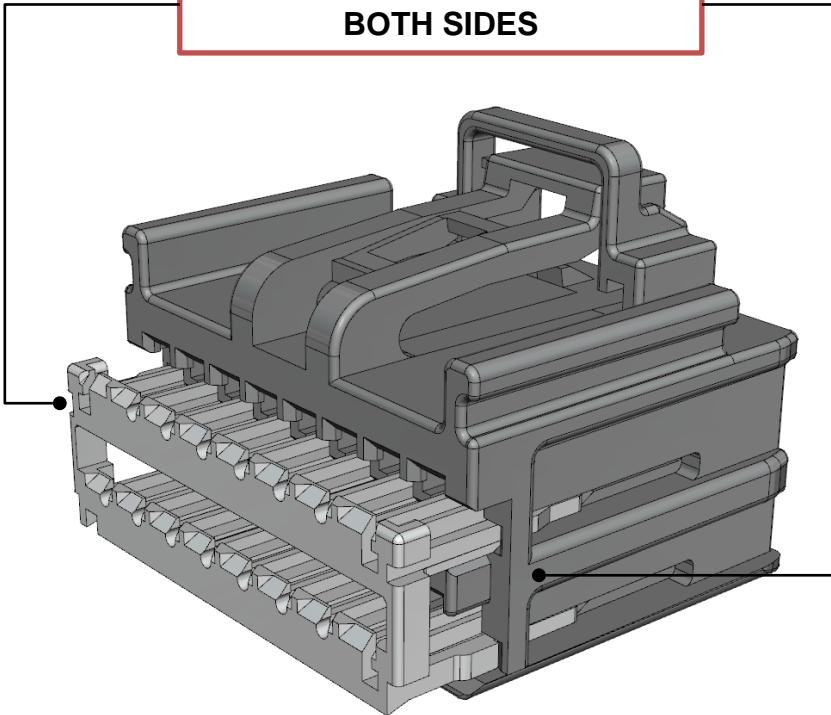


INSERT IT ONTO THE HOUSING



STEP 1b – Align and Insert PLR (to Pre-Stage Position)

VERIFY AUDIBLE CLICK ON BOTH SIDES



LATERAL VIEW

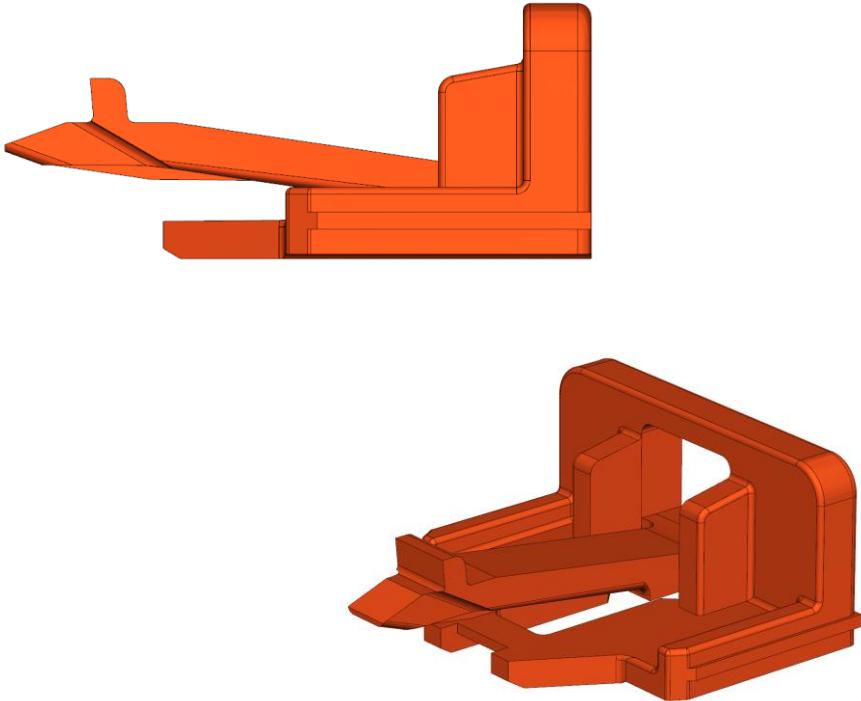
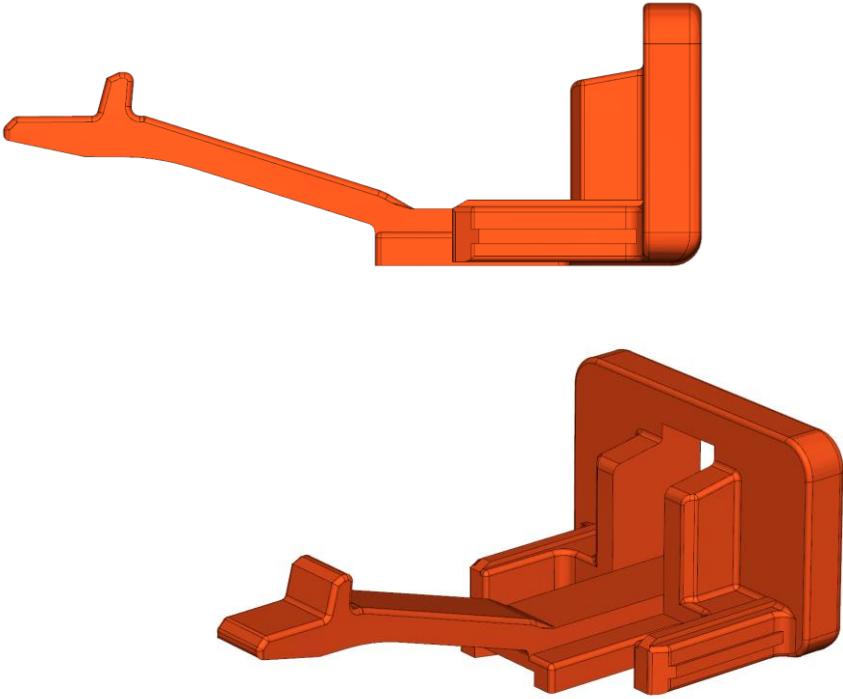
PLR IS NOW IN
PRE-STAGE POSITION

ASSEMBLY

STEP 2 – Identify the Required CPA

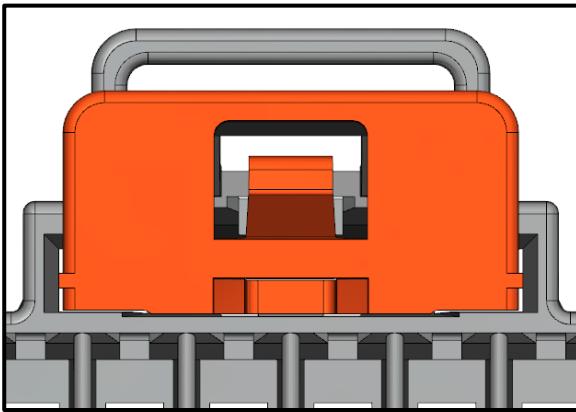
**CPA FOR SMALL SYSTEMS:
2W, 3W, 4W, 6W & 8W Connectors**

**CPA FOR LARGE SYSTEMS:
10W, 12W & 16W Connectors**

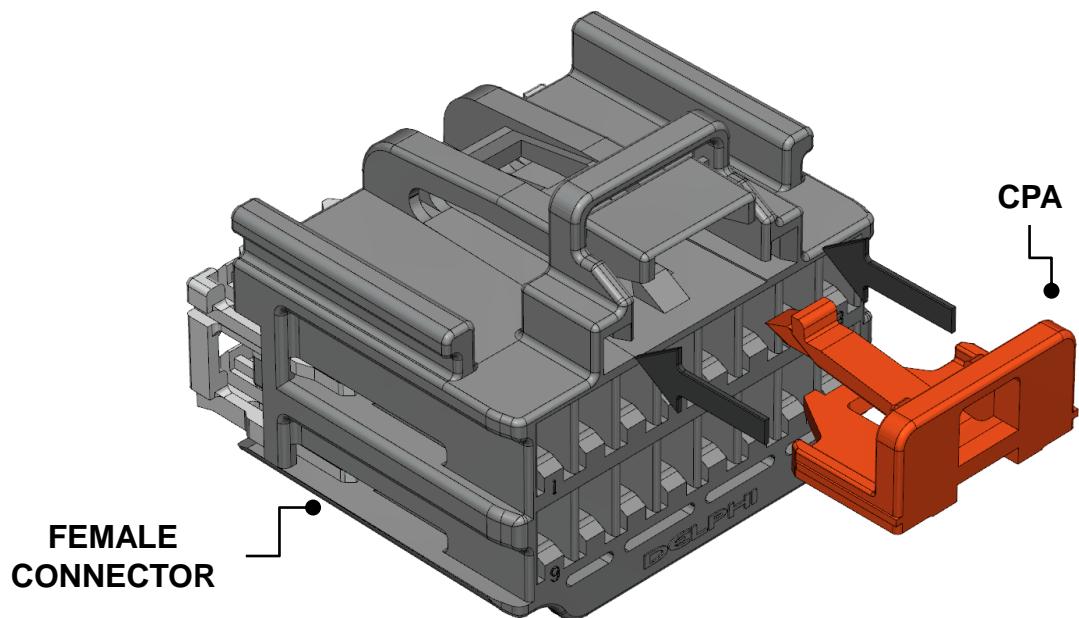


THE CPA'S SHARE THE SAME METHOD OF ASSEMBLY REGARDLESS THEIR DIFFERENCES

STEP 3a – Align and Lock CPA (to Pre-Stage Position)

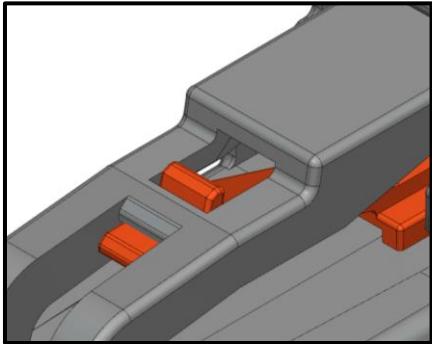


BACK VIEW

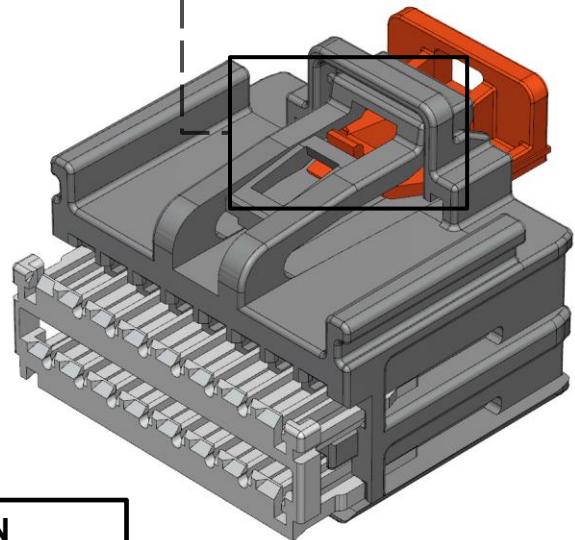
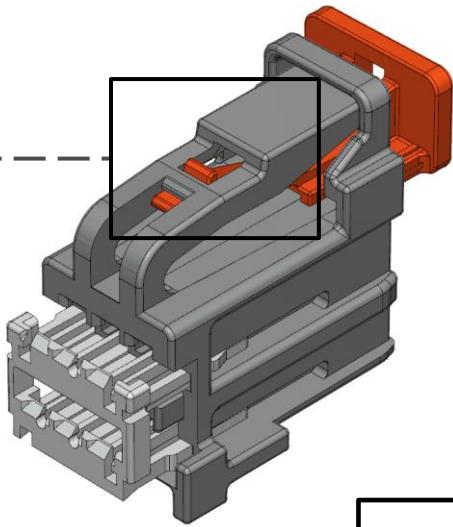
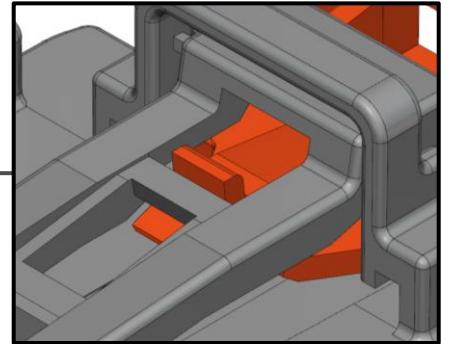


ASSEMBLY

STEP 3b – Align and Lock CPA (to Pre-Stage Position)

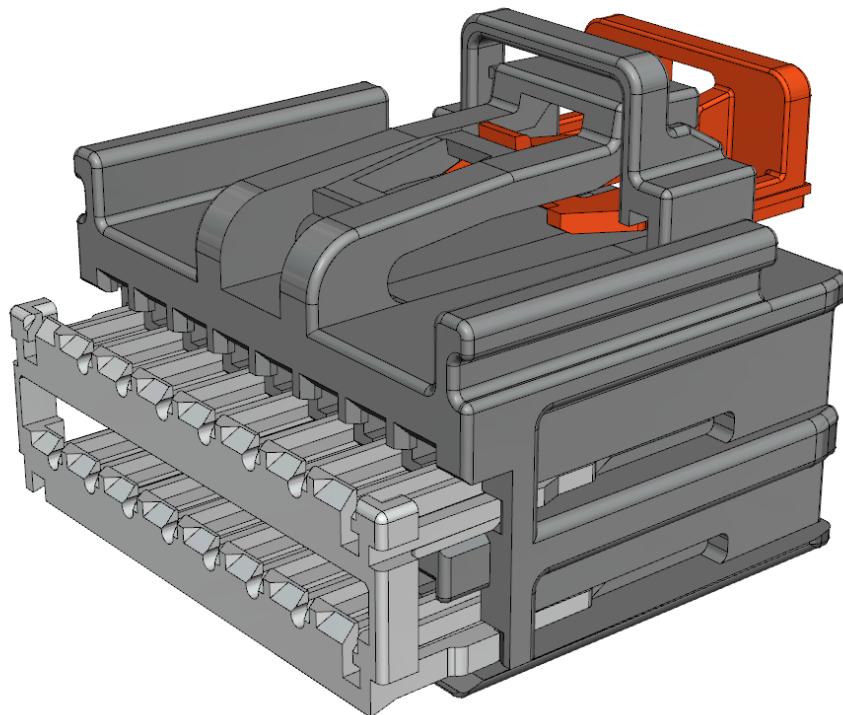


VERIFY AUDIBLE CLICK



CPA IS NOW IN
PRE-STAGE POSITION

FEMALE CONNECTOR – COMPLETED ASSEMBLY



ASSEMBLY

**ASSEMBLY OF THE
MALE CONNECTOR**

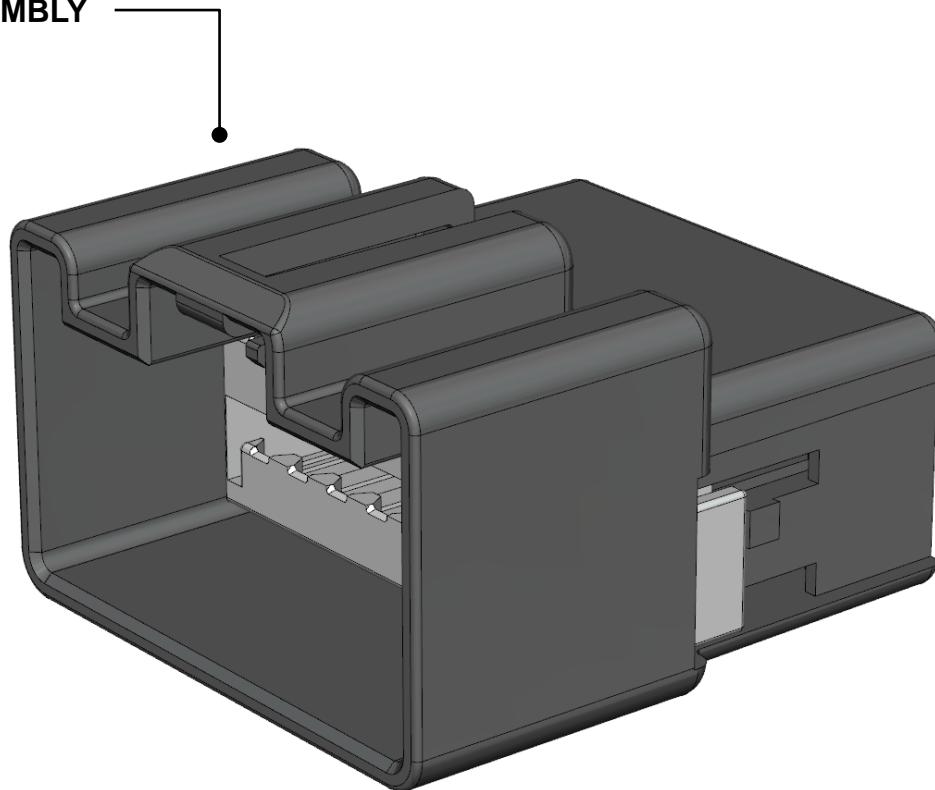
PRE - ASSEMBLY

HARNESS ASSEMBLY

CAR ASSEMBLY

1.5 OCS Unsealed Connection System

MALE ASSEMBLY



ASSEMBLY

VIEW OF VERSIONS

2 Way Connector

TYPE 101

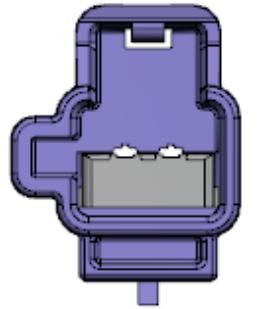
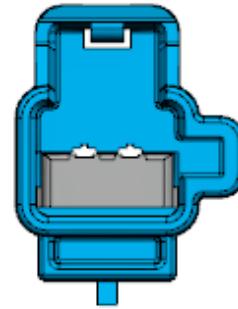
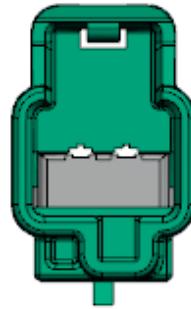
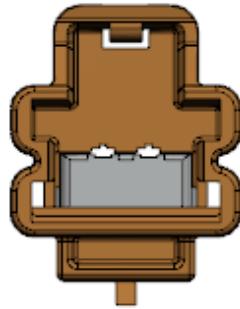
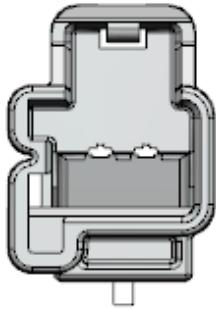
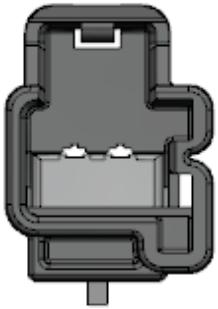
TYPE 102

TYPE 103

TYPE 104

TYPE 105

TYPE 106



3 Way Connector

TYPE 101

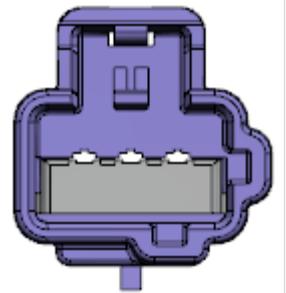
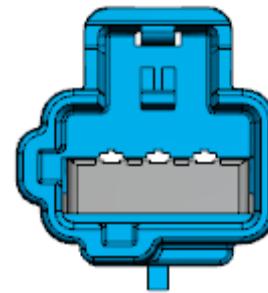
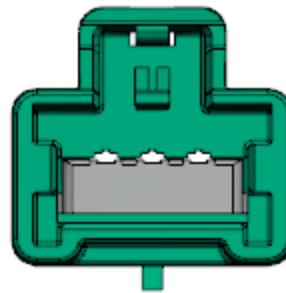
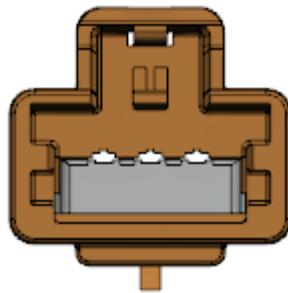
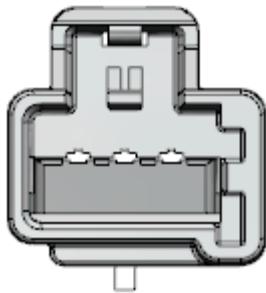
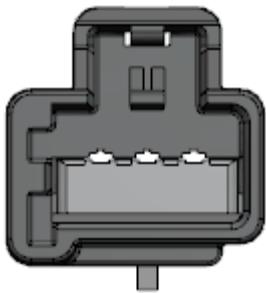
TYPE 102

TYPE 103

TYPE 104

TYPE 105

TYPE 106



4 Way Connector

TYPE 101

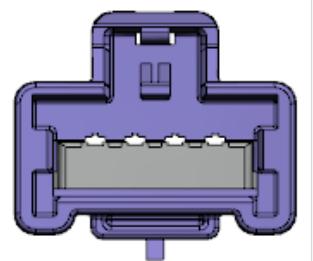
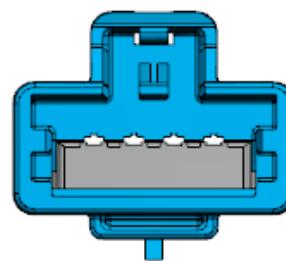
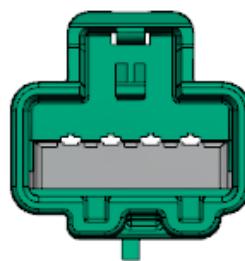
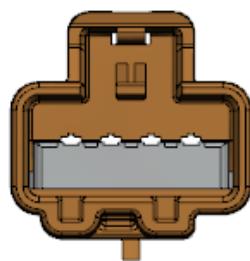
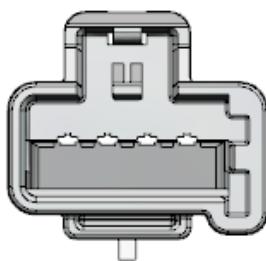
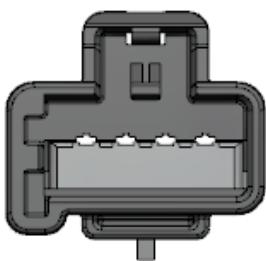
TYPE 102

TYPE 103

TYPE 104

TYPE 105

TYPE 106



6 Way Connector

TYPE 101

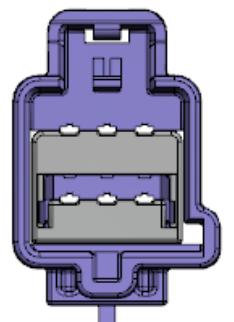
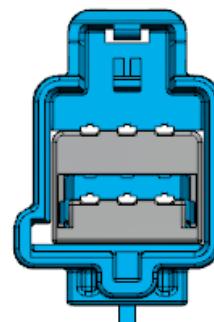
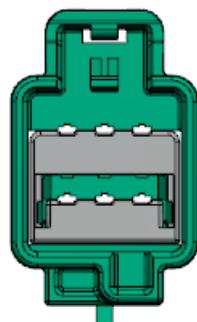
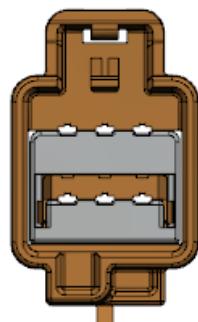
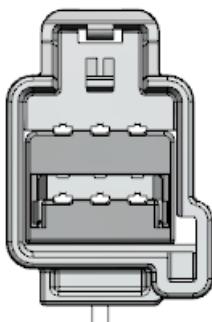
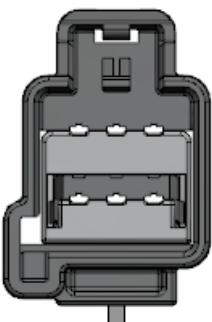
TYPE 102

TYPE 103

TYPE 104

TYPE 105

TYPE 106



EACH CONNECTION SYSTEM HAVE 6 DIFFERENT TYPES, WHICH DIFFER IN THE INDEXING AND COLOR, REFER TO LATEST DRAWINGS FOR DETAILS

ASSEMBLY

VIEW OF VERSIONS

8 Way Connector

TYPE 101

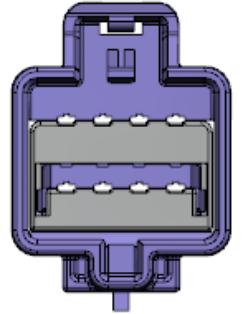
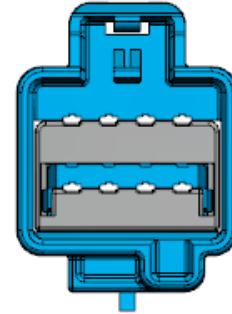
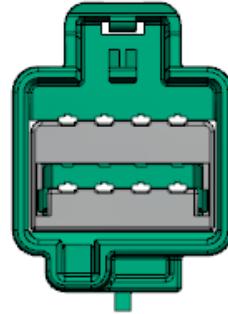
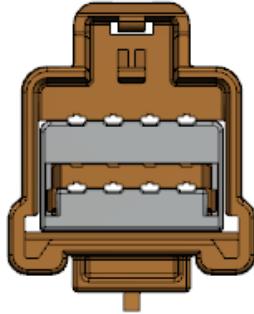
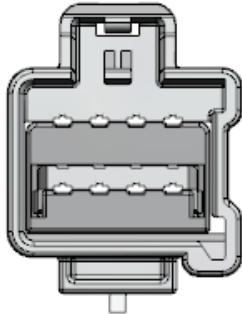
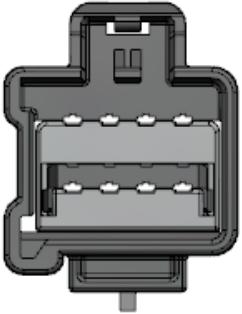
TYPE 102

TYPE 103

TYPE 104

TYPE 105

TYPE 106



10 Way Connector

TYPE 101

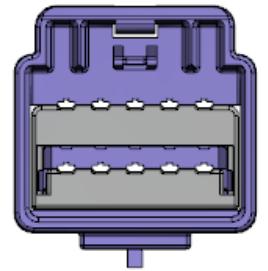
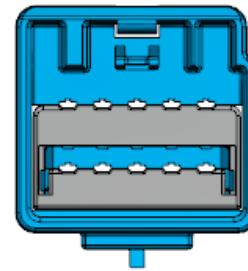
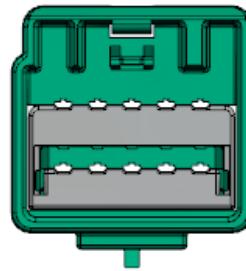
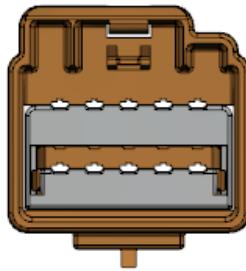
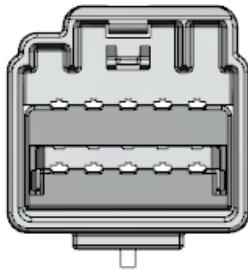
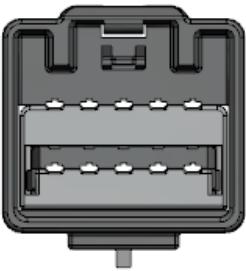
TYPE 102

TYPE 103

TYPE 104

TYPE 105

TYPE 106



12 Way Connector

TYPE 101

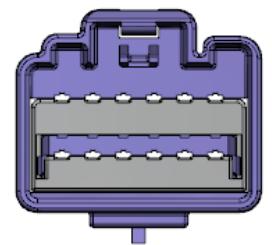
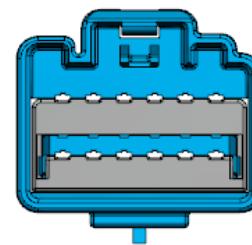
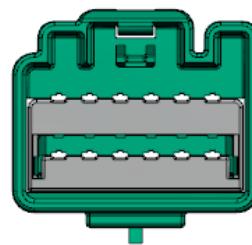
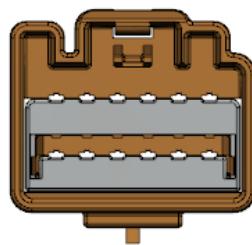
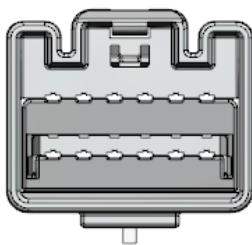
TYPE 102

TYPE 103

TYPE 104

TYPE 105

TYPE 106



16 Way Connector

TYPE 101

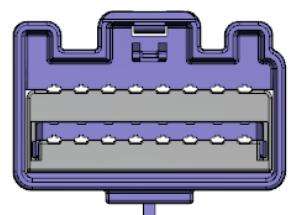
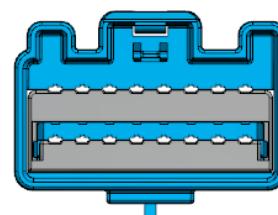
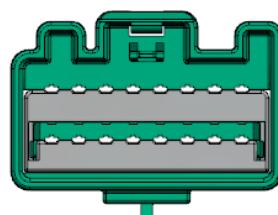
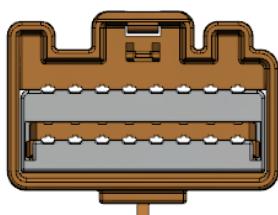
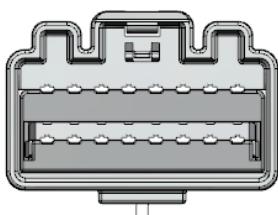
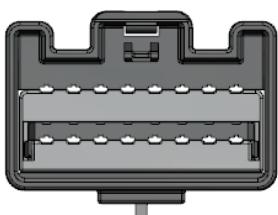
TYPE 102

TYPE 103

TYPE 104

TYPE 105

TYPE 106

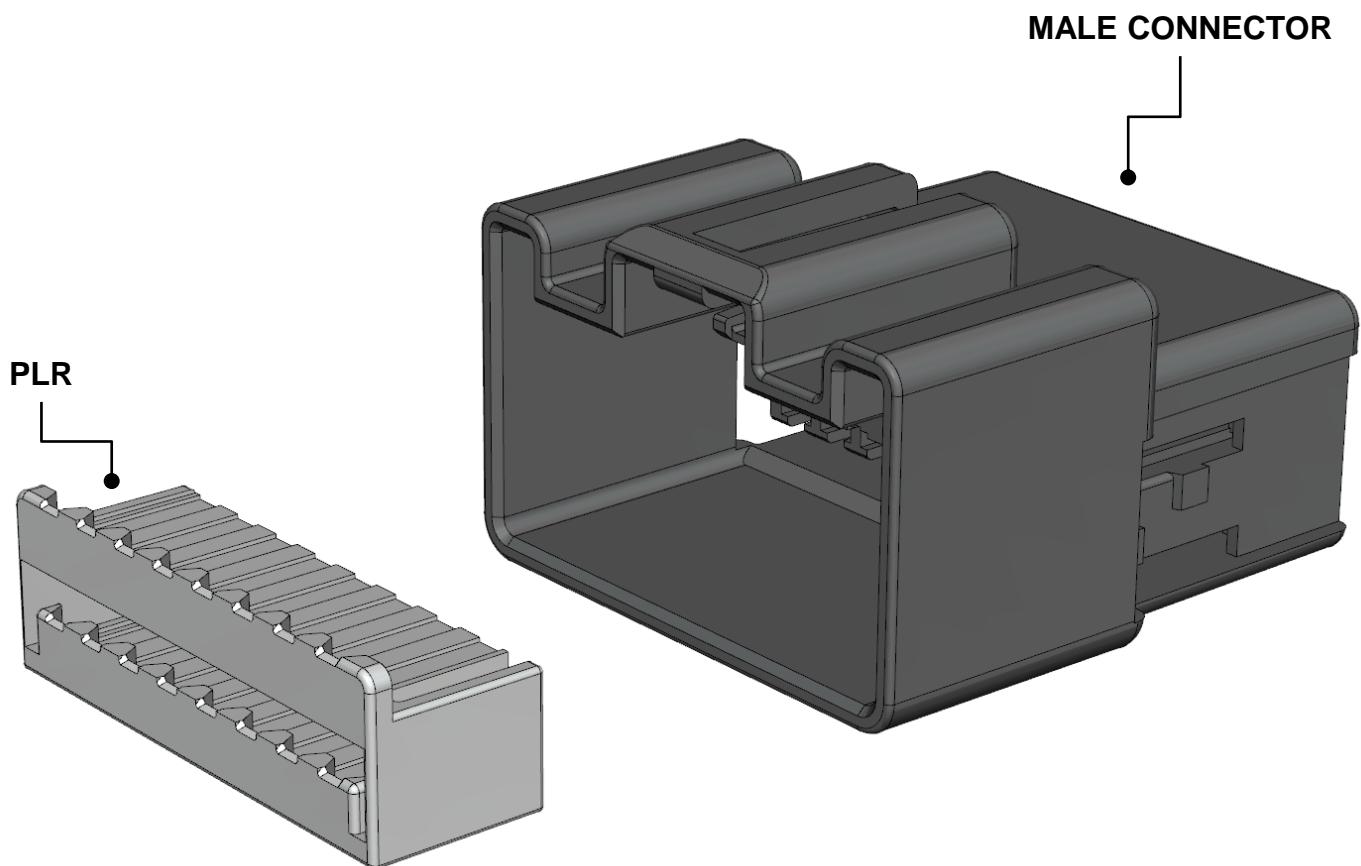


EACH CONNECTION SYSTEM HAVE 6 DIFFERENT TYPES, WHICH DIFFER IN THE INDEXING AND COLOR, REFER TO LATEST DRAWINGS FOR DETAILS

ASSEMBLY

LIST OF COMPONENTS & EXPLODED VIEW

| QUANTITY | COMPONENTS OF 1.5 OCS MALE CONNECTOR |
|----------|--------------------------------------|
| 1 | PLR |
| 1 | MALE CONNECTOR |

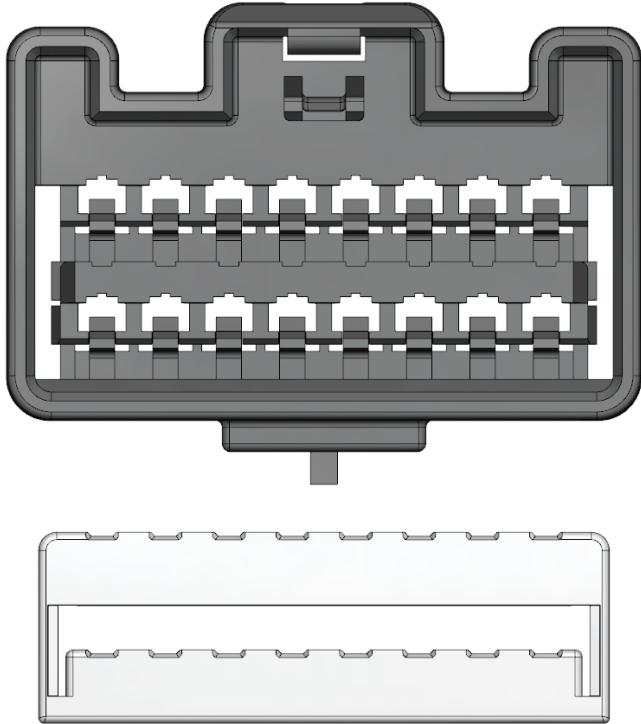


Pictures used in this Assembly Manual and original parts may differ in some details, these differences have no influence on the assembly process.

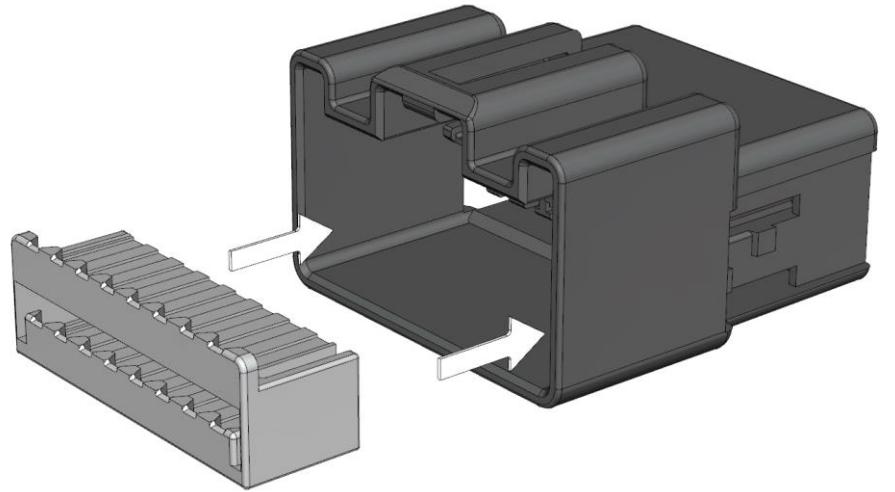
ASSEMBLY

STEP 1a – Align and Insert PLR (to Pre-Stage Position)

VERIFY THE ORIENTATION OF THE PLR

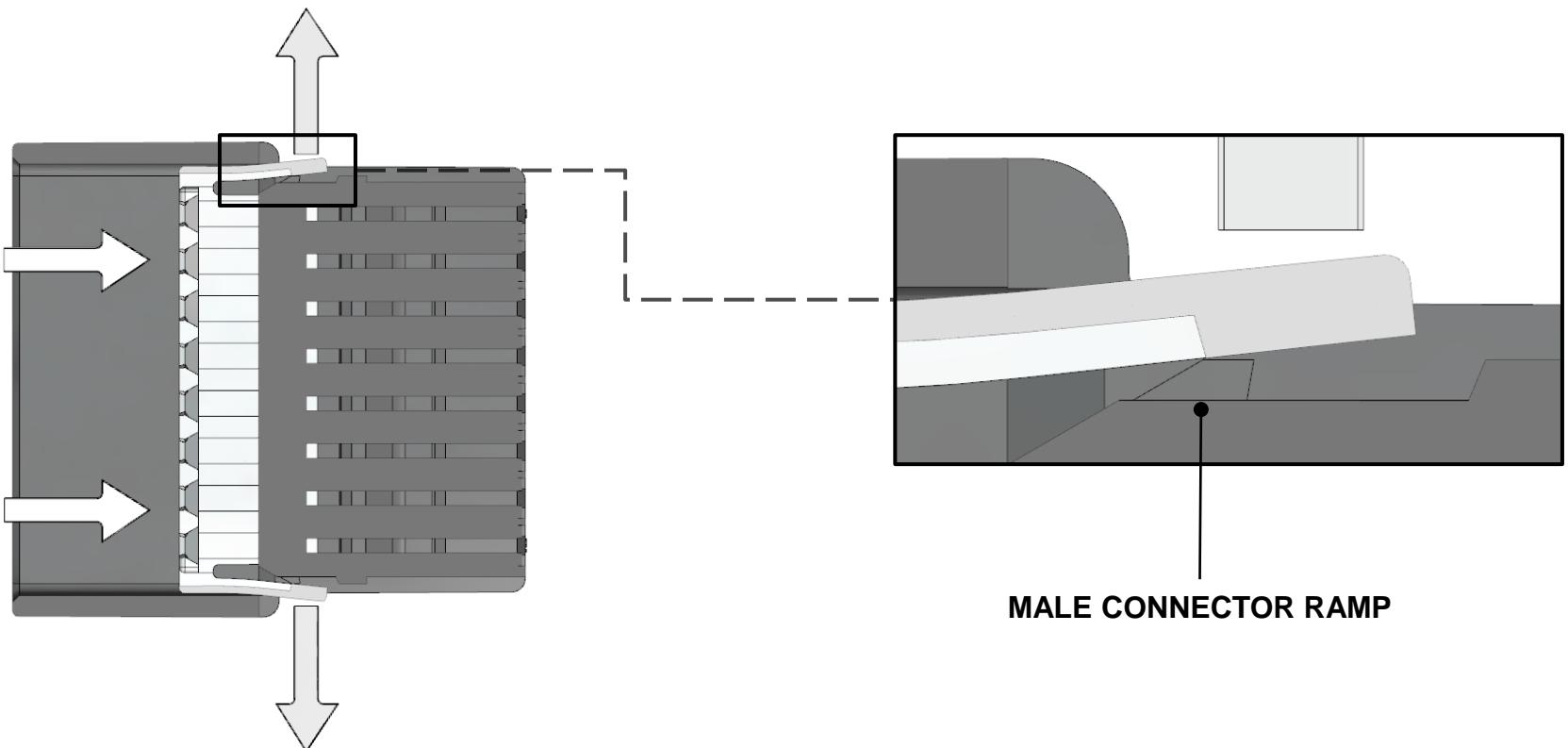


INSERT IT ONTO THE HOUSING



STEP 1b – Align and Insert PLR (to Pre-Stage Position)

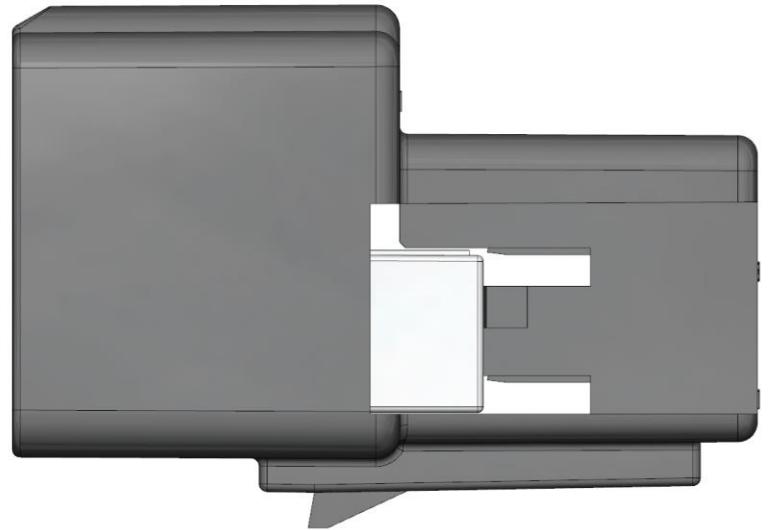
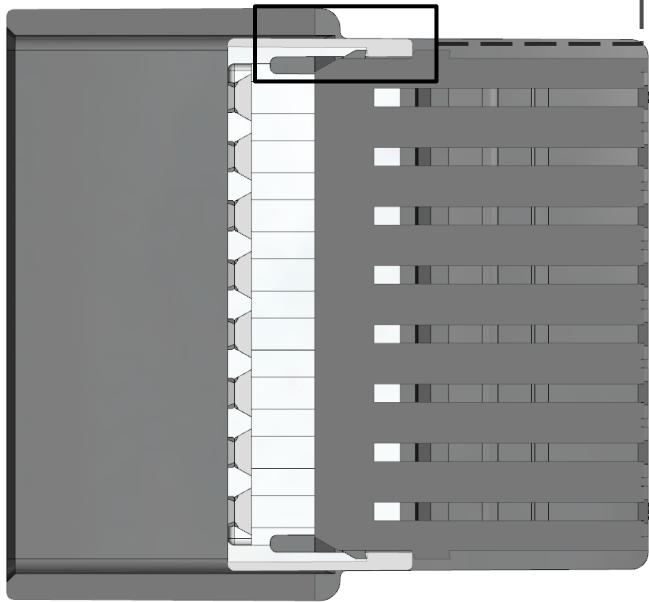
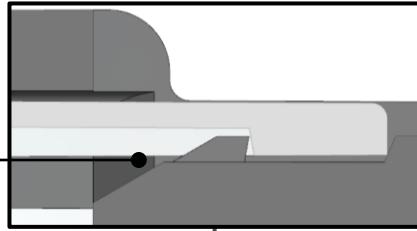
APPLY ENOUGH FORCE ON THE PLR TO CLEAR THE RAMPS OF THE CONNECTOR



ASSEMBLY

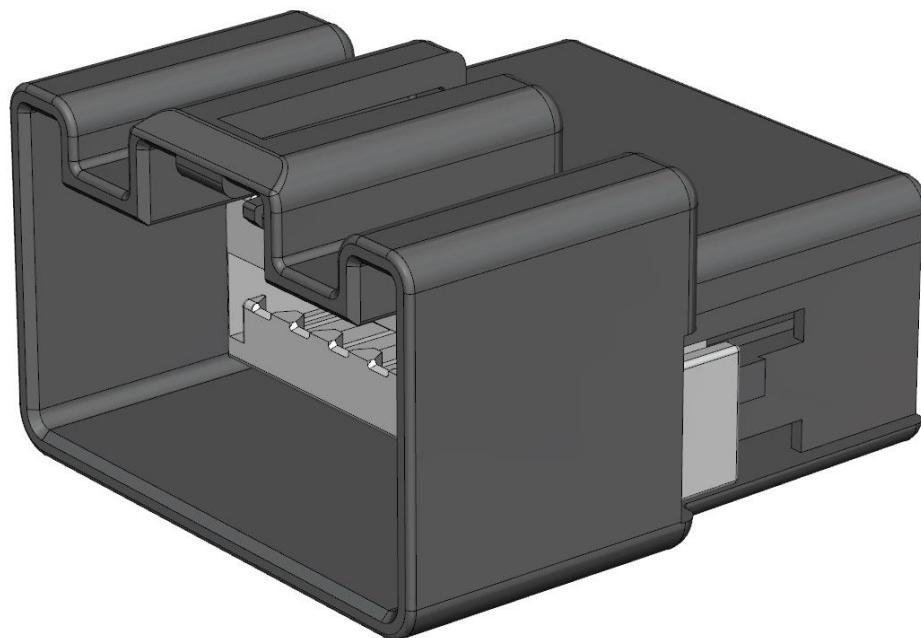
STEP 1c – Align and Insert PLR (to Pre-Stage Position)

VERIFY AUDIBLE CLICK
ON BOTH SIDES



PLR IS NOW IN
PRE-STAGE POSITION

MALE CONNECTOR – COMPLETED ASSEMBLY



ASSEMBLY

**ASSEMBLY OF THE
FEMALE HARNESS ASSEMBLY**

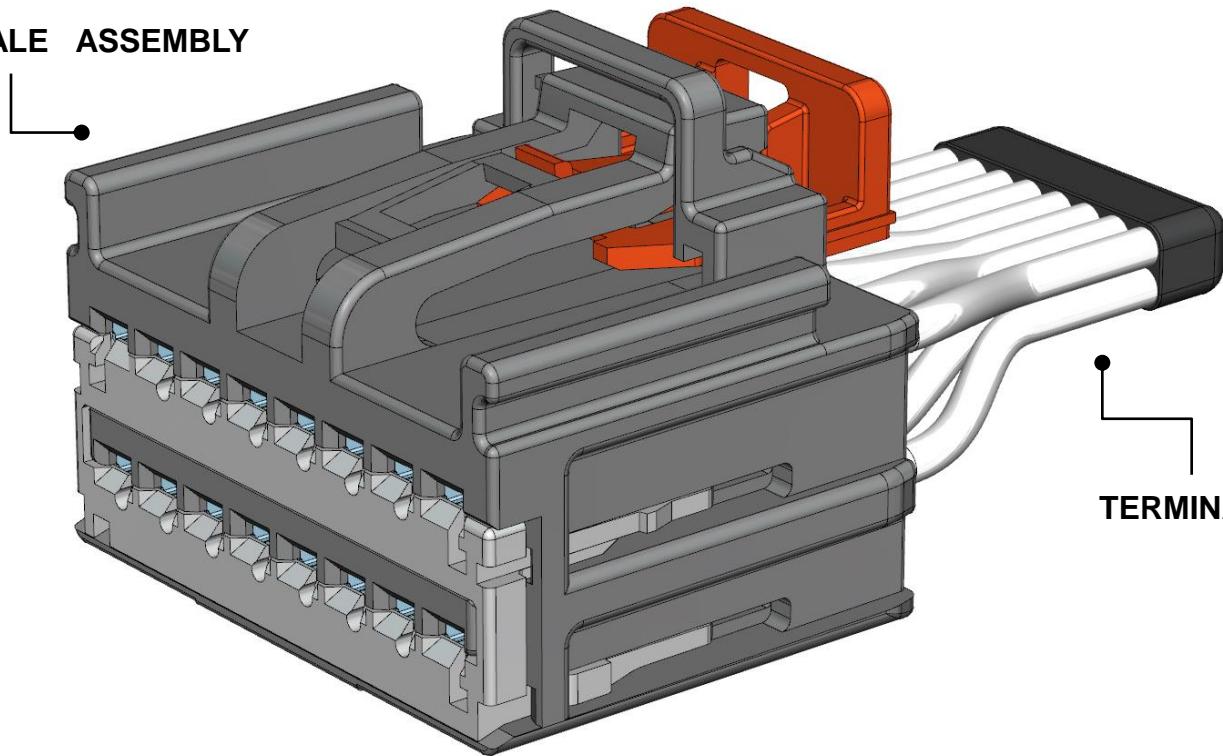
PRE - ASSEMBLY

HARNESS ASSEMBLY

CAR ASSEMBLY

1.5 OCS Unsealed Connection System

FEMALE ASSEMBLY



TERMINALS

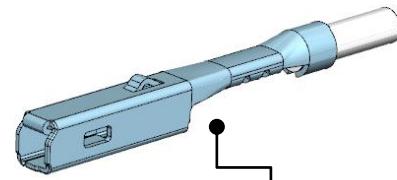
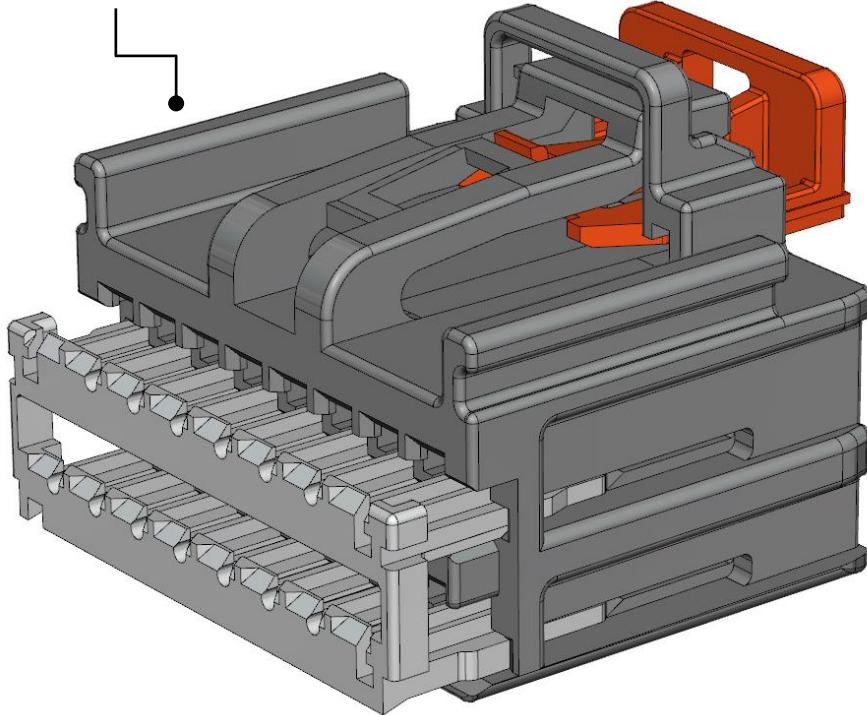
ASSEMBLY

LIST OF COMPONENTS & EXPLODED VIEW

| QUANTITY | COMPONENTS OF 1.5 OCS FEMALE CONNECTION |
|----------|---|
| 1 | FEMALE ASSEMBLY |
| 16* | TERMINALS (FEMALE 1.5) |

* THE QUANTITY OF TERMINALS REQUIRED MIGHT VARY DEPENDING ON THE TYPE OF ASSEMBLY:
2W, 3W, 4W, 6W, 8W, 10W, 12W & 16W.

FEMALE ASSEMBLY



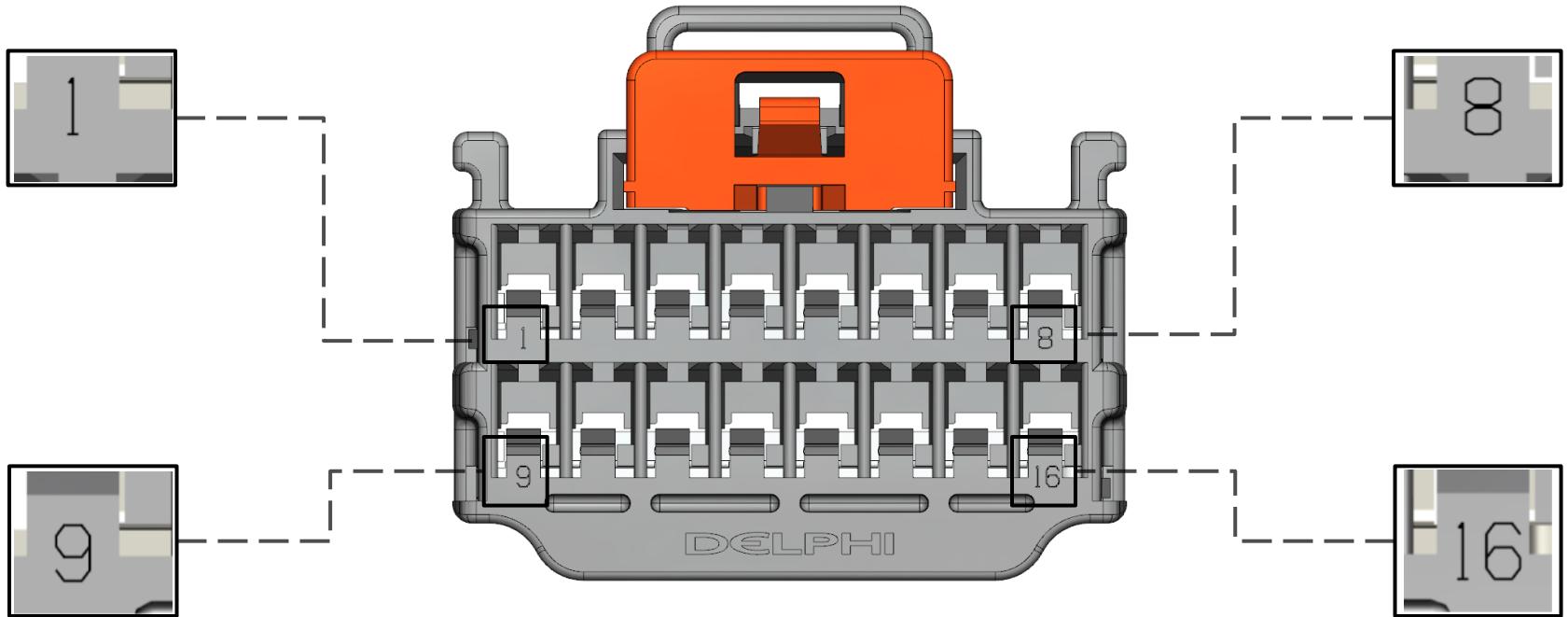
TERMINALS

Pictures used in this Assembly Manual and original parts may differ in some details, these differences have no influence on the assembly process.

ASSEMBLY

STEP 1 – Identify Cavities

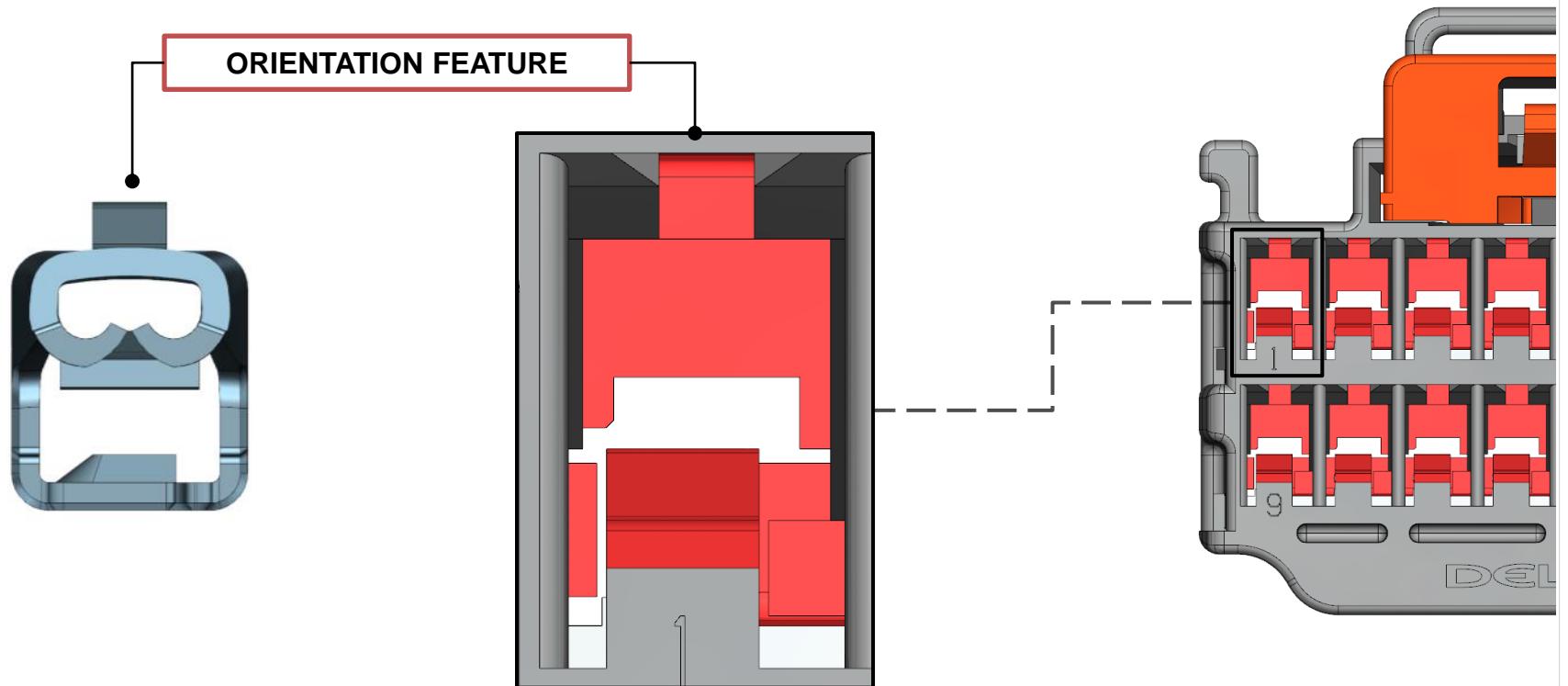
BACK VIEW



CAVITY IDENTIFICATION NUMBERS

STEP 2 – Align Terminals Female 1.5 and Female Assembly

INSERT FEMALE TERMINAL INTO RECEPTACLE HOUSING ACCORDING TO INSERTION PLAN.
- PROPER ORIENTATION OF TERMINAL REQUIRED -



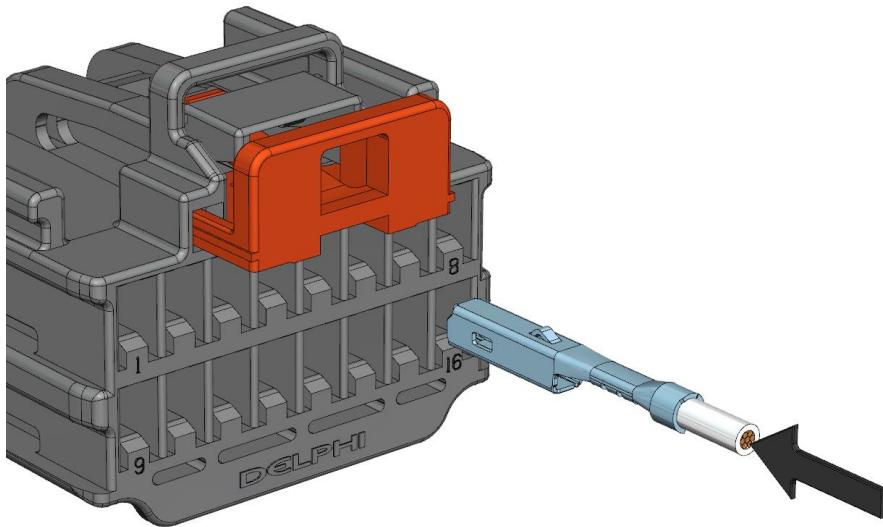
BACK VIEWS

ASSEMBLY

STEP 3a – Insert Terminals OCS Female 1.5

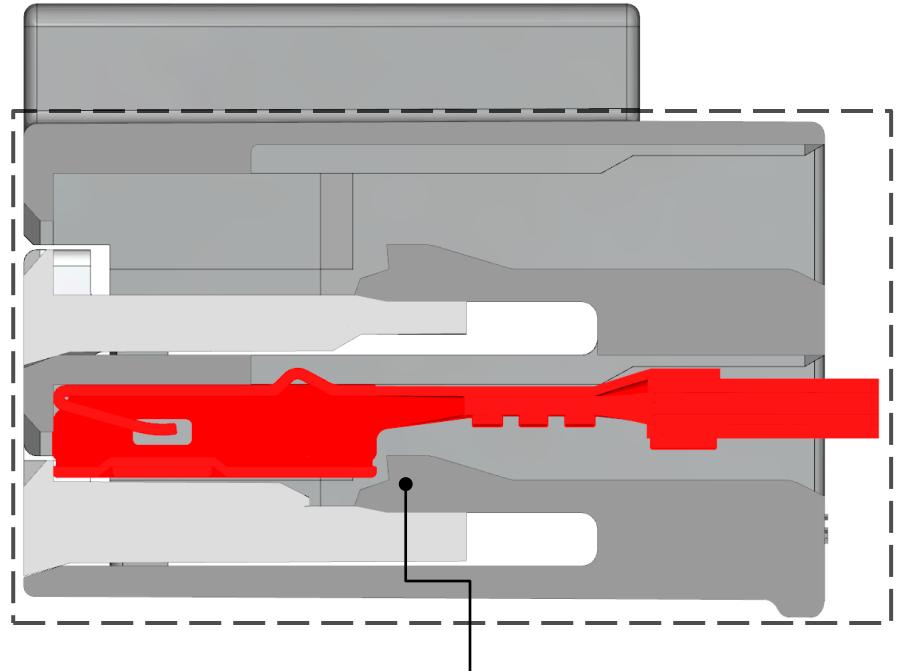
1

PUSH THE TERMINAL STRAIGHT INTO THE CAVITY



2

VERIFY AUDIBLE CLICK

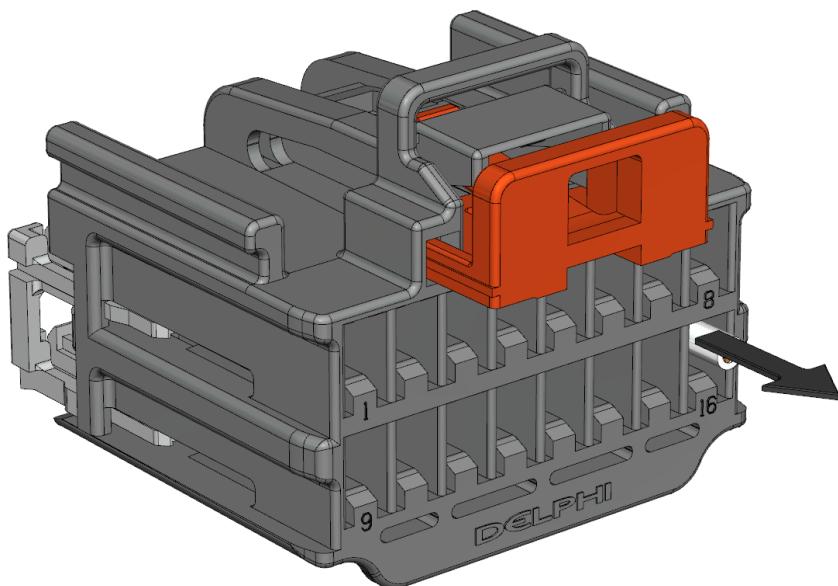


TERMINAL IS FULLY ENGAGED UNDER THE FLEX LOCKING ARM

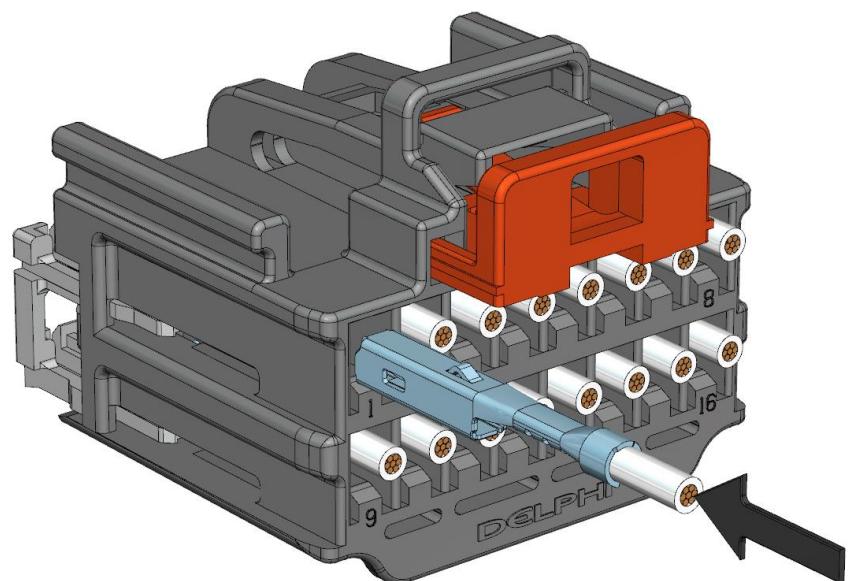
STEP 3b – Insert Terminals OCS Female 1.5

3

GENTLY TUG THE CABLE TO VERIFY THE LOCK SYSTEM



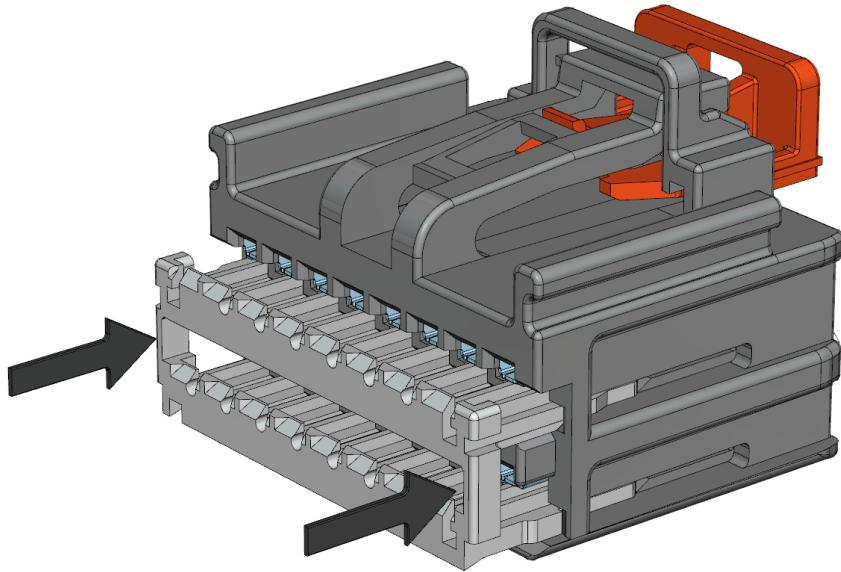
USE THE SAME PROCESS TO INSERT THE REST OF THE TERMINALS



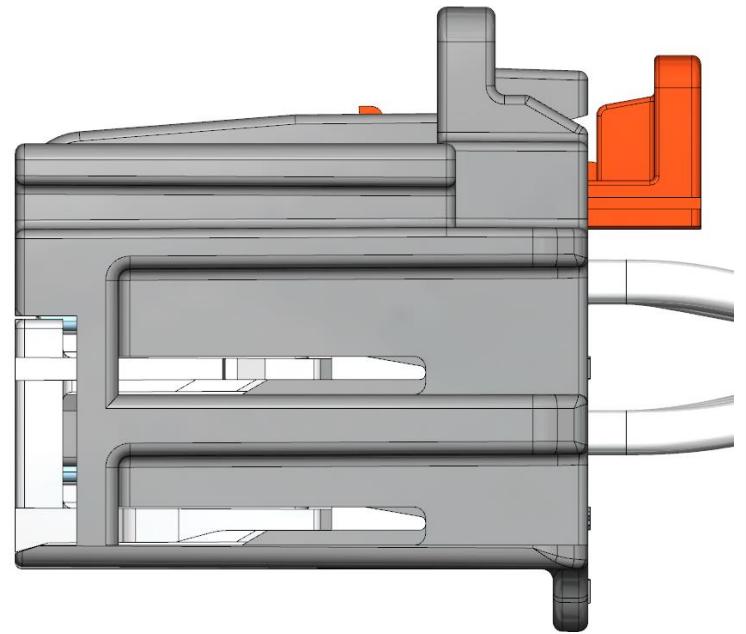
ASSEMBLY

STEP 4 – Close PLR to Full-Stage

PUSH THE PLR TO THE END POSITION TO SECURE THE TERMINAL LOCKING ARMS

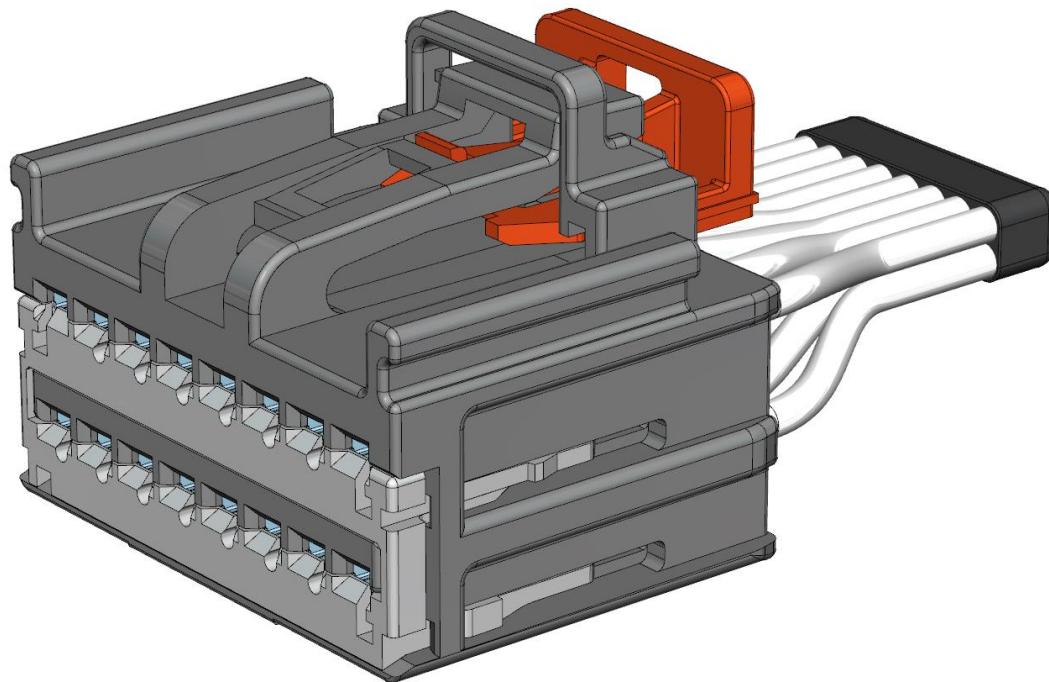


VERIFY AUDIBLE CLICK ON BOTH SIDES



PLR IS NOW IN FULL-STAGE POSITION

FEMALE ASSEMBLY - COMPLETED



ASSEMBLY

**ASSEMBLY OF THE
MALE HARNESS ASSEMBLY**

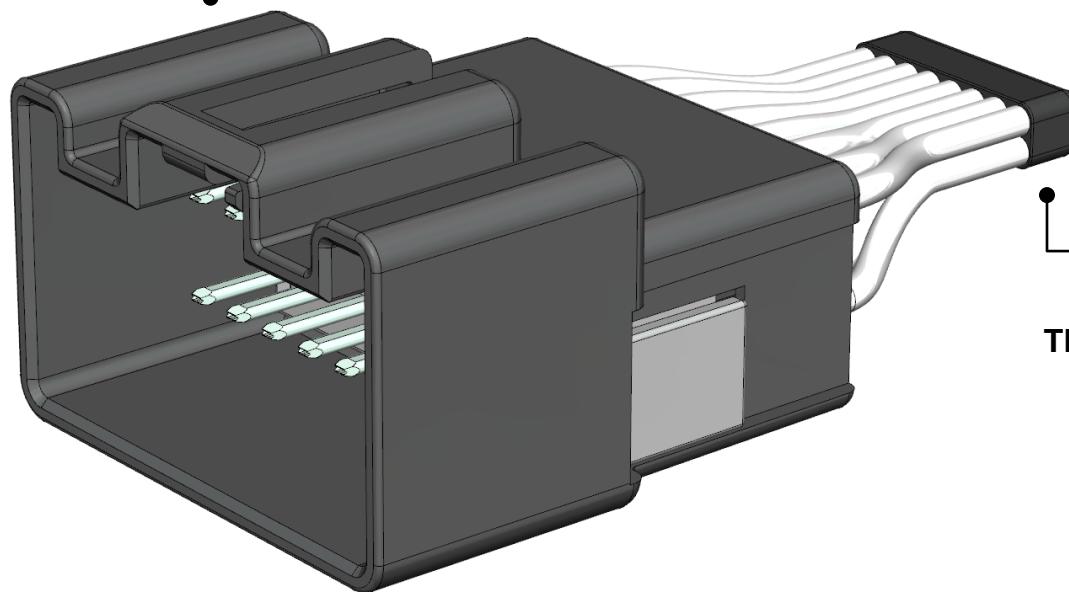
PRE - ASSEMBLY

HARNESS ASSEMBLY

CAR ASSEMBLY

1.5 OCS Unsealed Connection System

MALE ASSEMBLY



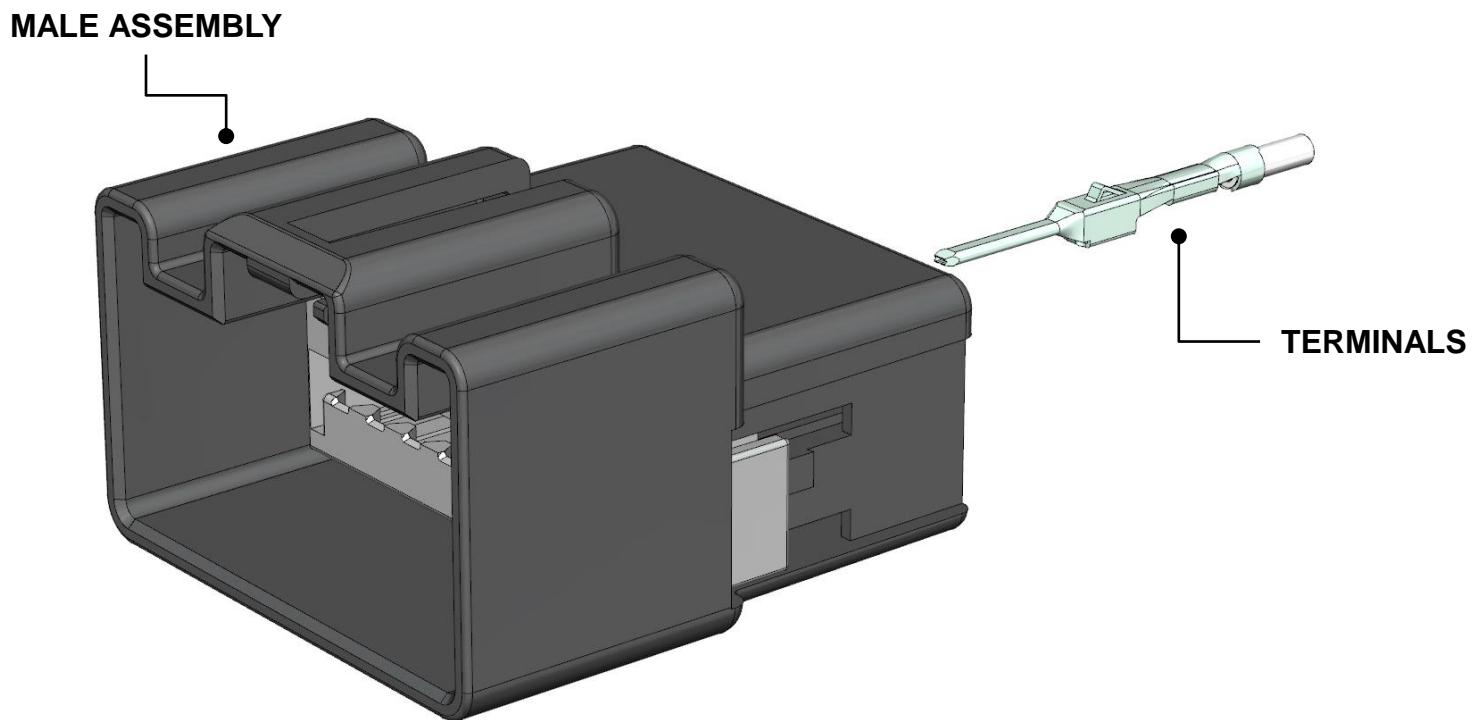
TERMINALS

ASSEMBLY

LIST OF COMPONENTS & EXPLODED VIEW

| QUANTITY | COMPONENTS OF 1.5 OCS MALE CONNECTION |
|----------|---------------------------------------|
| 1 | MALE ASSEMBLY |
| 16* | TERMINALS (MALE 1.5) |

* THE QUANTITY OF TERMINALS REQUIRED MIGHT VARY DEPENDING ON THE TYPE OF ASSEMBLY:
2W, 3W, 4W, 6W, 8W, 10W, 12W & 16W.

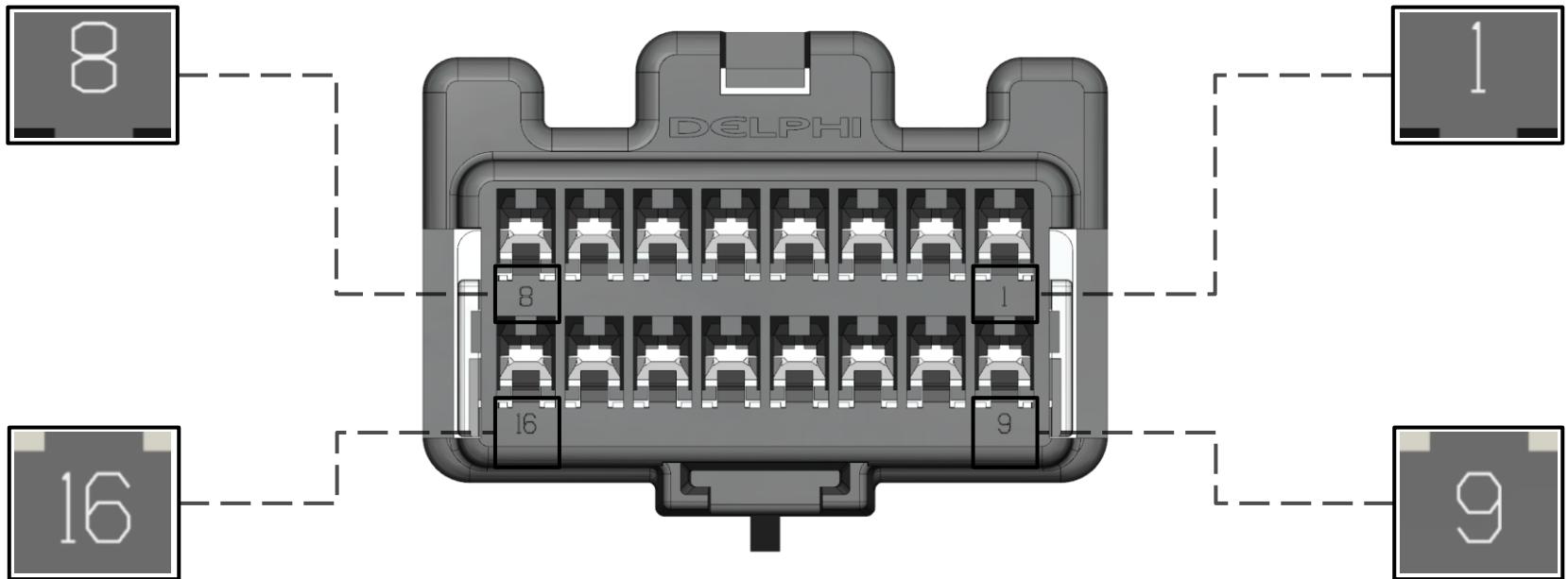


Pictures used in this Assembly Manual and original parts may differ in some details, these differences have no influence on the assembly process.

ASSEMBLY

STEP 1 – Identify Cavities

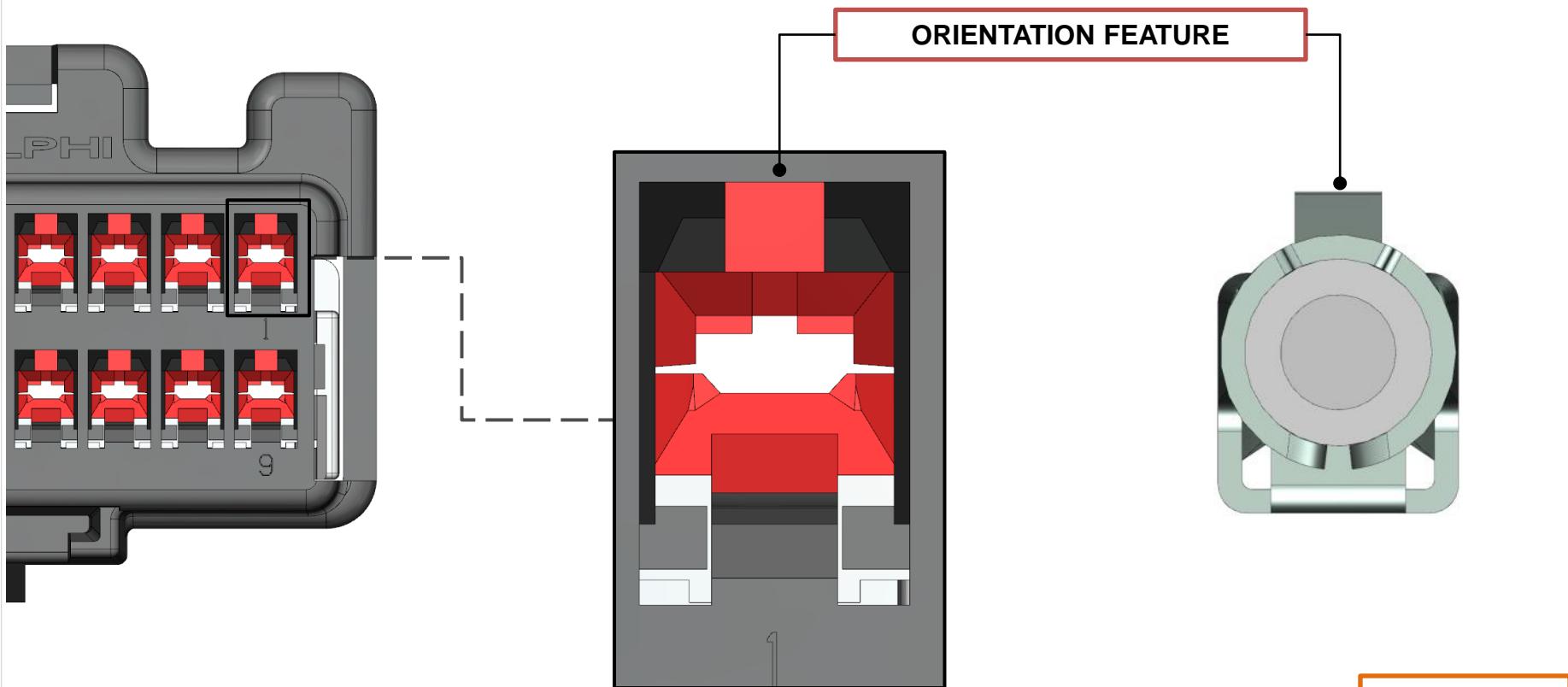
BACK VIEW



CAVITY IDENTIFICATION NUMBERS

STEP 2 – Align Terminals Male 1.5 and Male Assembly

INSERT MALE TERMINAL INTO RECEPTACLE HOUSING ACCORDING TO INSERTION PLAN.
- PROPER ORIENTATION OF TERMINAL REQUIRED -



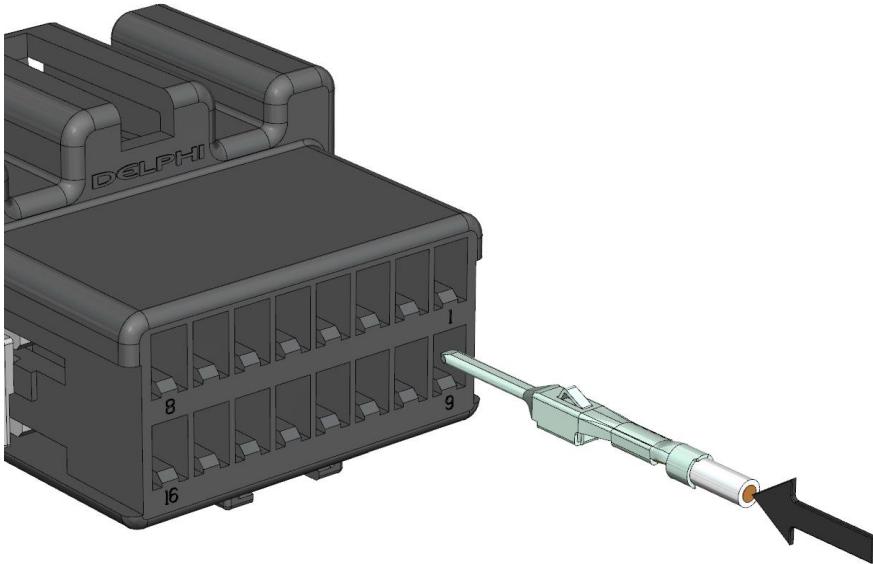
BACK VIEWS

ASSEMBLY

STEP 3a – Insert Terminals OCS Male 1.5

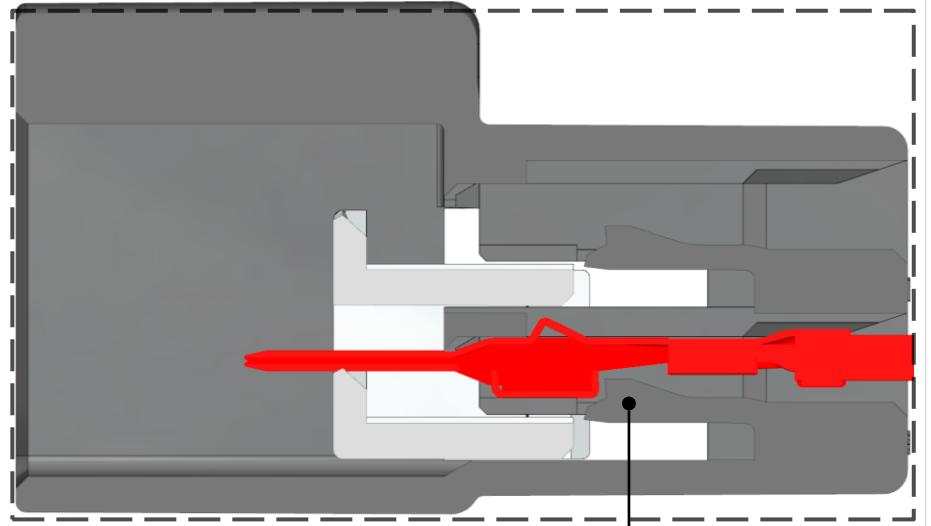
1

PUSH THE TERMINAL STRAIGHT INTO THE CAVITY



2

VERIFY AUDIBLE CLICK

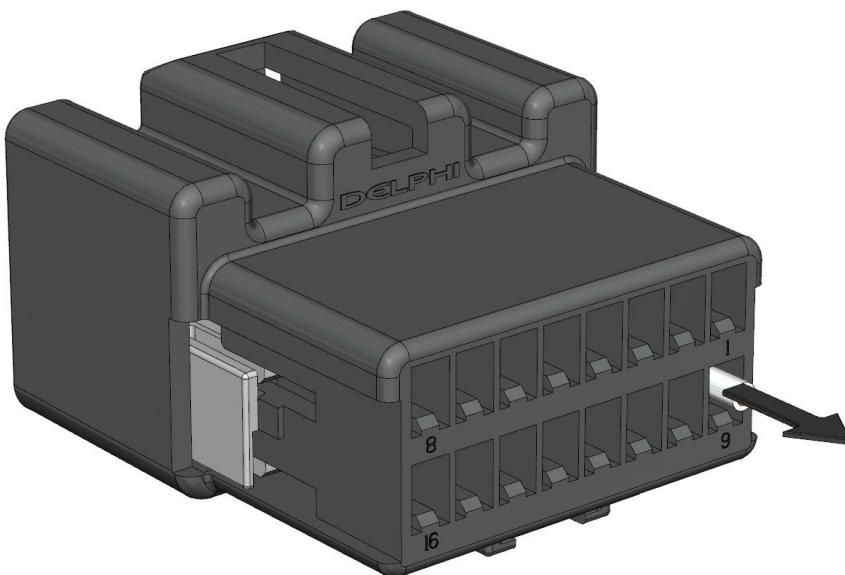


TERMINAL IS FULLY ENGAGED UNDER THE FLEX LOCKING ARM

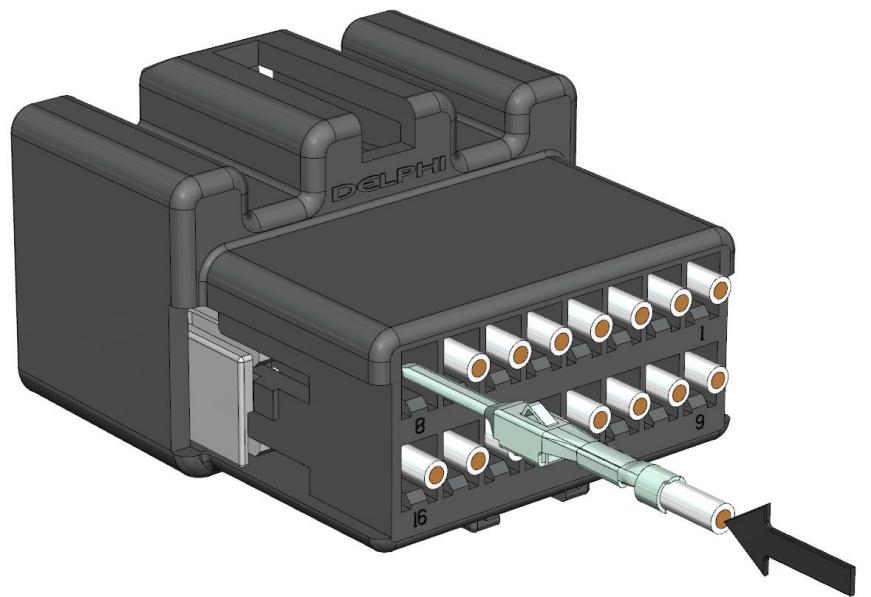
STEP 3b – Insert Terminals OCS Male 1.5

3

GENTLY TUG THE CABLE TO VERIFY THE LOCK SYSTEM



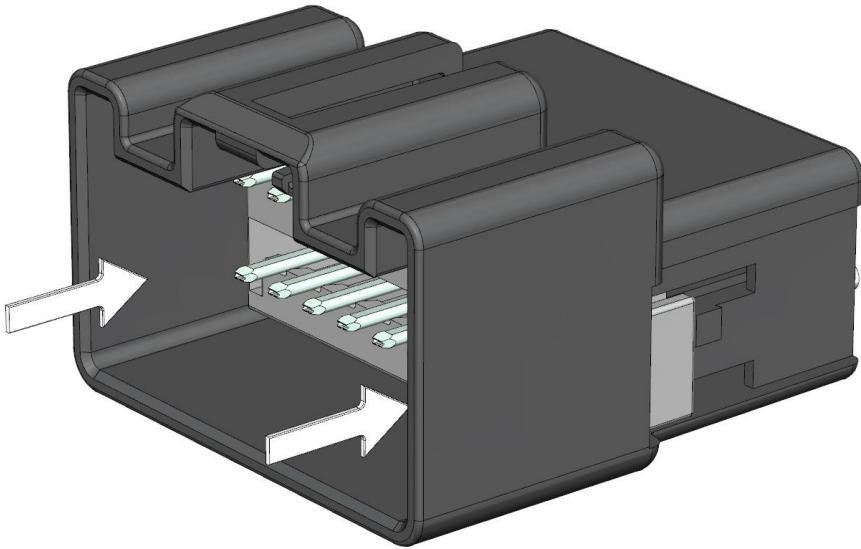
USE THE SAME PROCESS TO INSERT THE REST OF THE TERMINALS



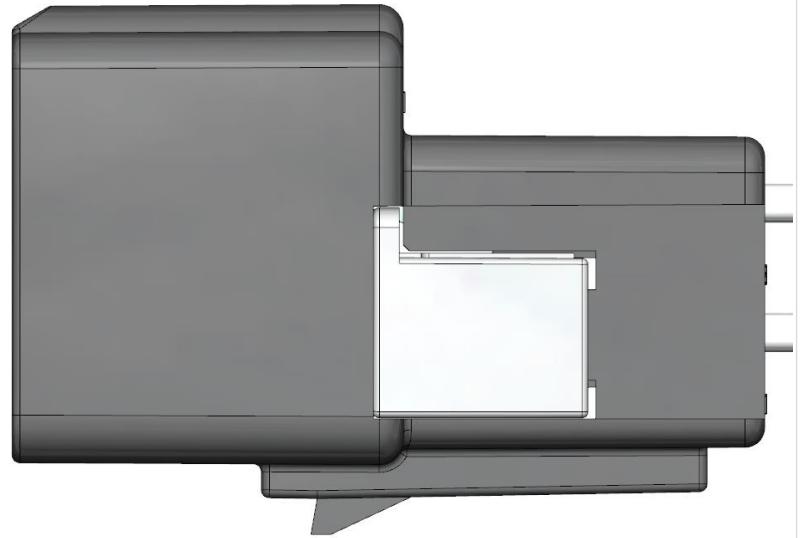
ASSEMBLY

STEP 4 – Close PLR to Full-Stage

PUSH THE PLR TO THE END POSITION TO SECURE THE TERMINAL LOCKING ARMS

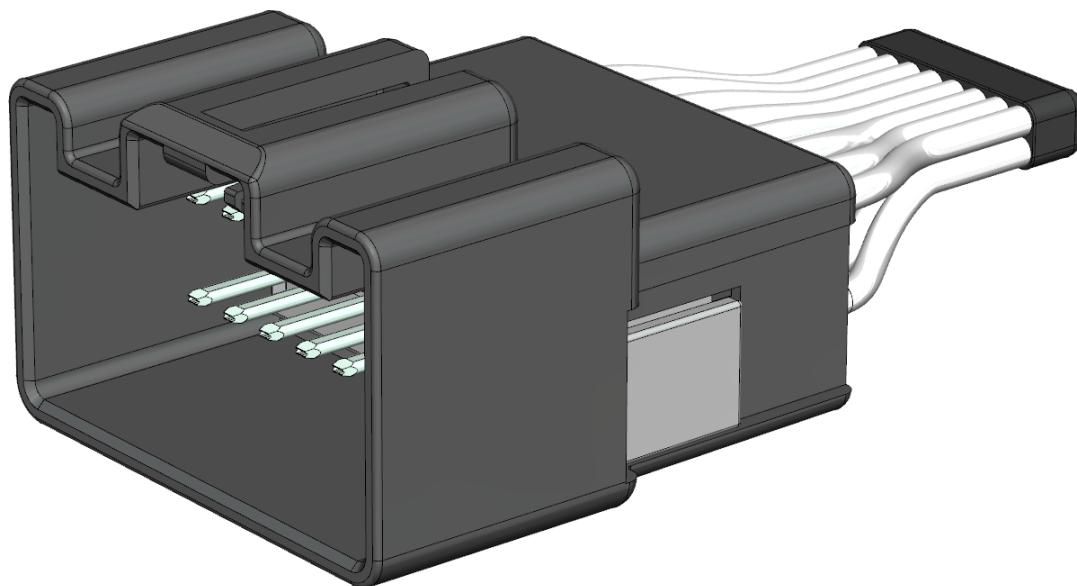


VERIFY AUDIBLE CLICK ON BOTH SIDES



PLR IS NOW IN FULL-STAGE POSITION

MALE ASSEMBLY - COMPLETED



ASSEMBLY

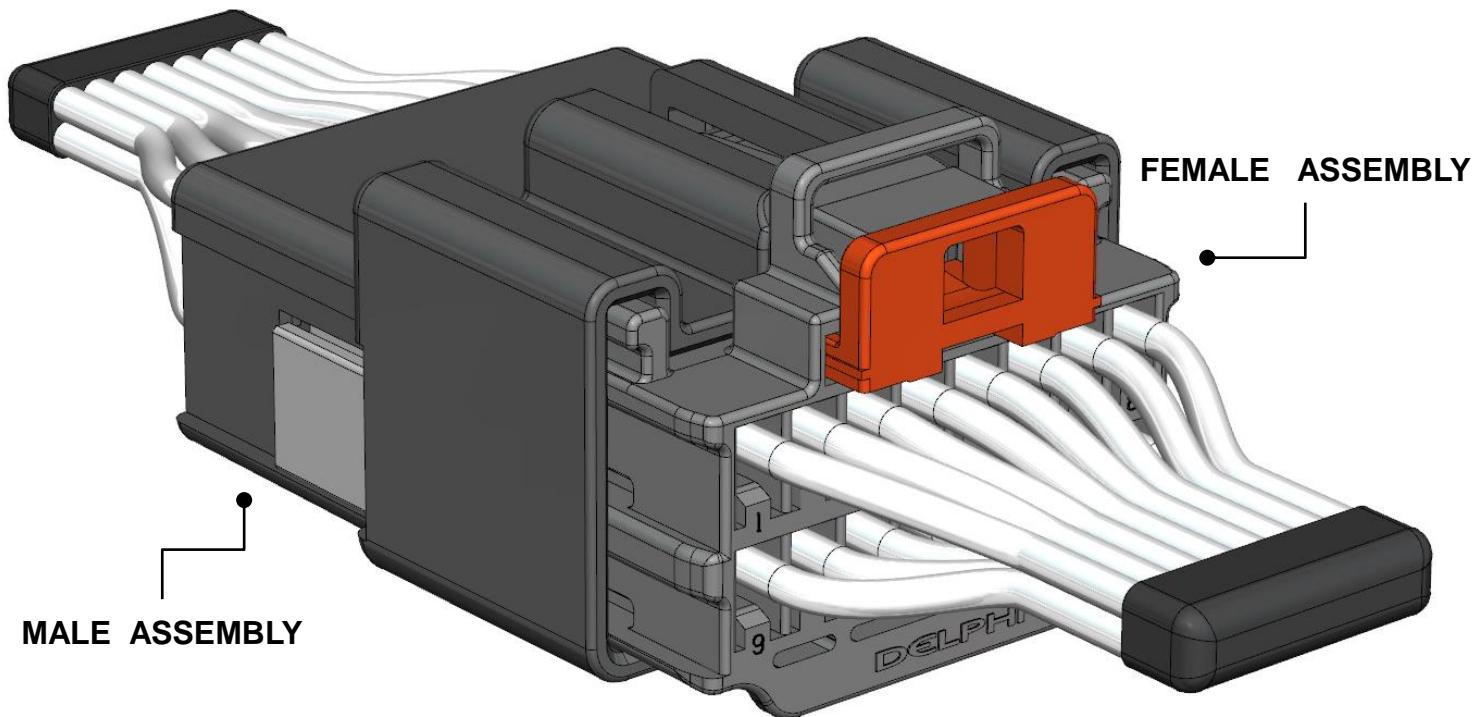
**ASSEMBLY OF THE
CONNECTION SYSTEM**

PRE - ASSEMBLY

HARNESS ASSEMBLY

CAR ASSEMBLY

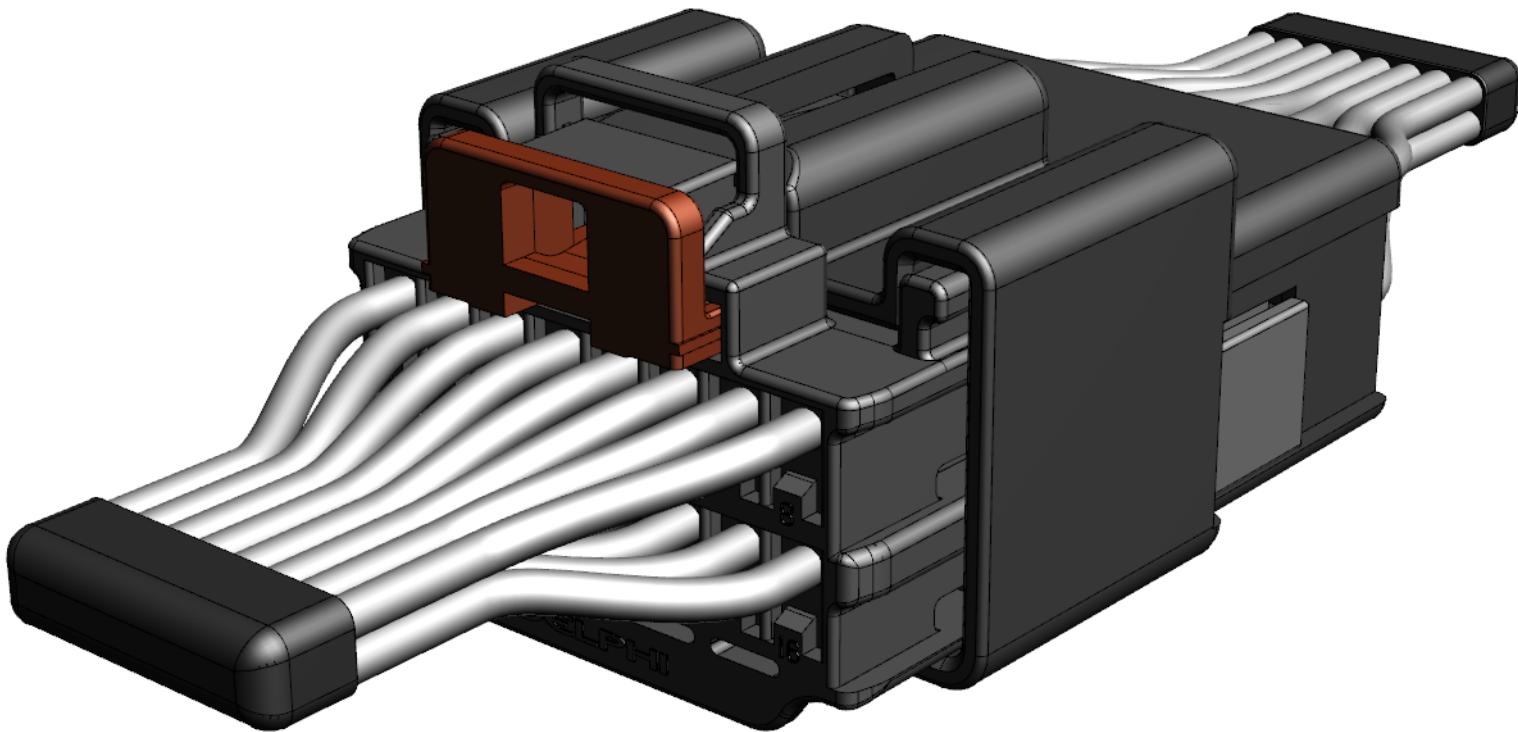
1.5 OCS Unsealed Connection System



ASSEMBLY

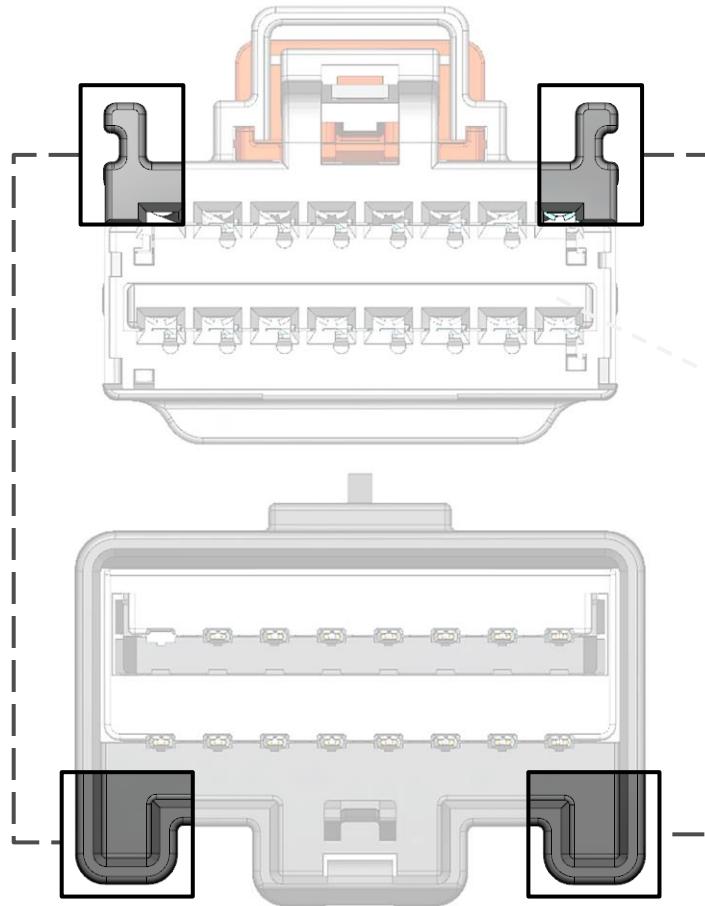
3D MODEL VIEW

**CLICK IMAGE TO START
3D VISUALIZATION**



ASSEMBLY

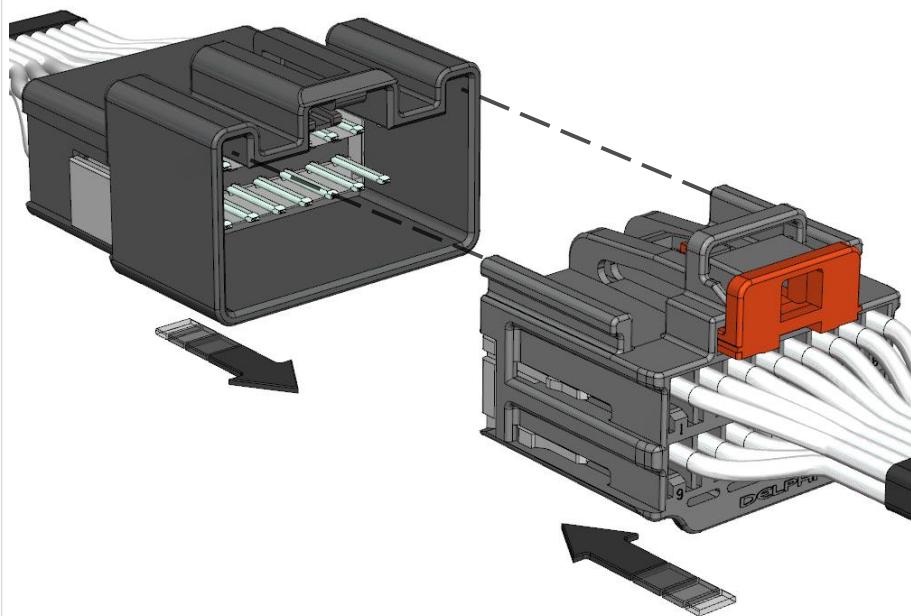
STEP 1 – Identify and Align Index Features



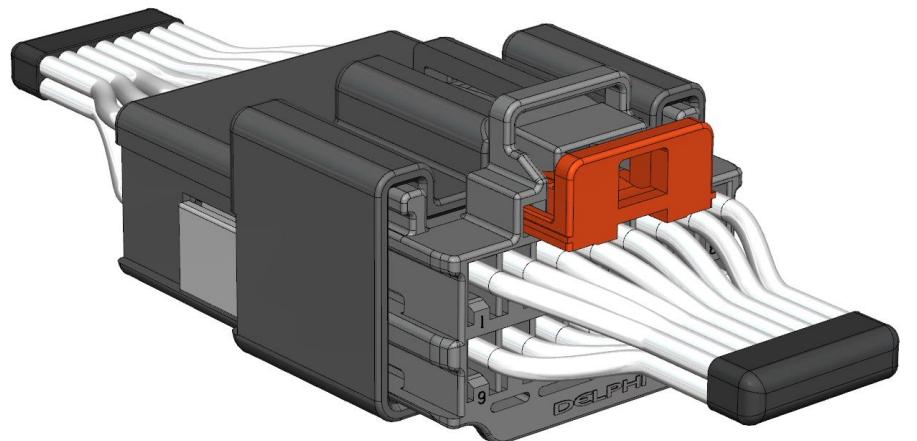
FRONT VIEWS

STEP 2a – Mate Female Assembly and Male Assembly Together Axially

IMPORTANT! IF THE INDEXES DON'T LINE UP, DO NOT CONTINUE.

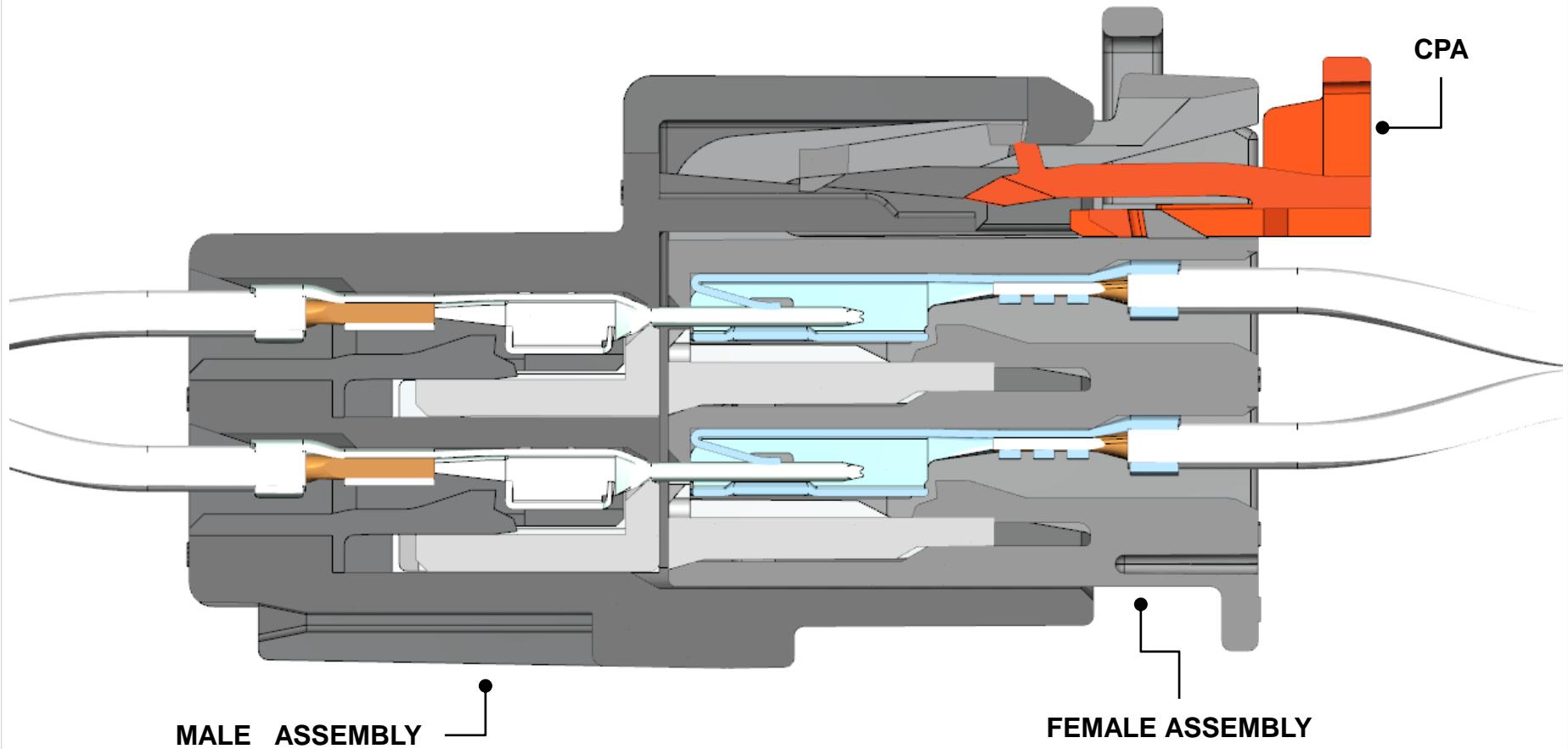


VERIFY AUDIBLE CLICK



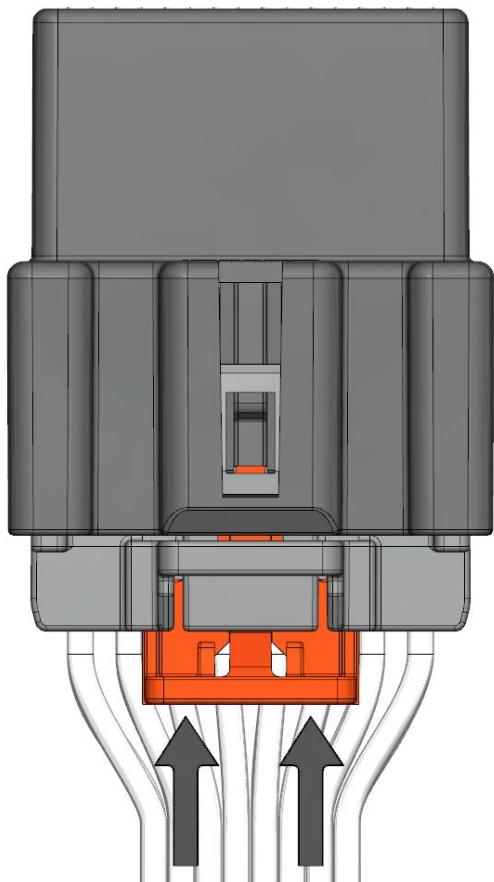
ASSEMBLY

STEP 2b – Mate Female Assembly and Male Assembly Together Axially (COMPLETE)

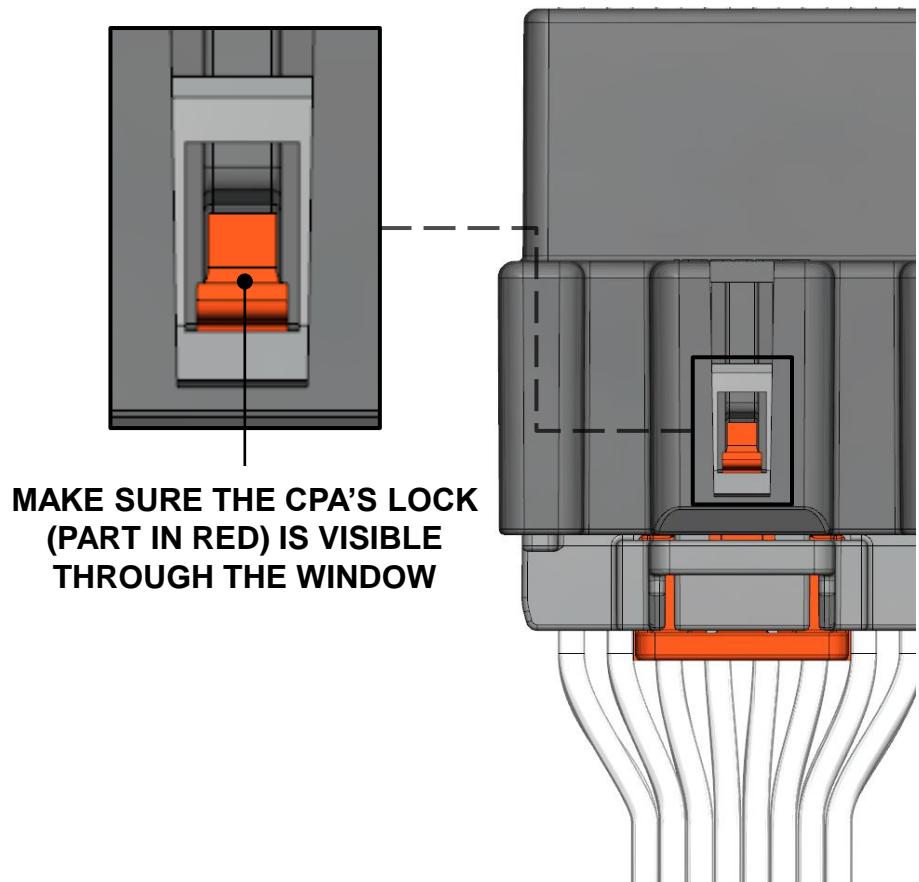


STEP 3a – Close CPA to Full-Stage

SLIDE THE CPA TO THE END POSITION TO SECURE THE ASSEMBLY



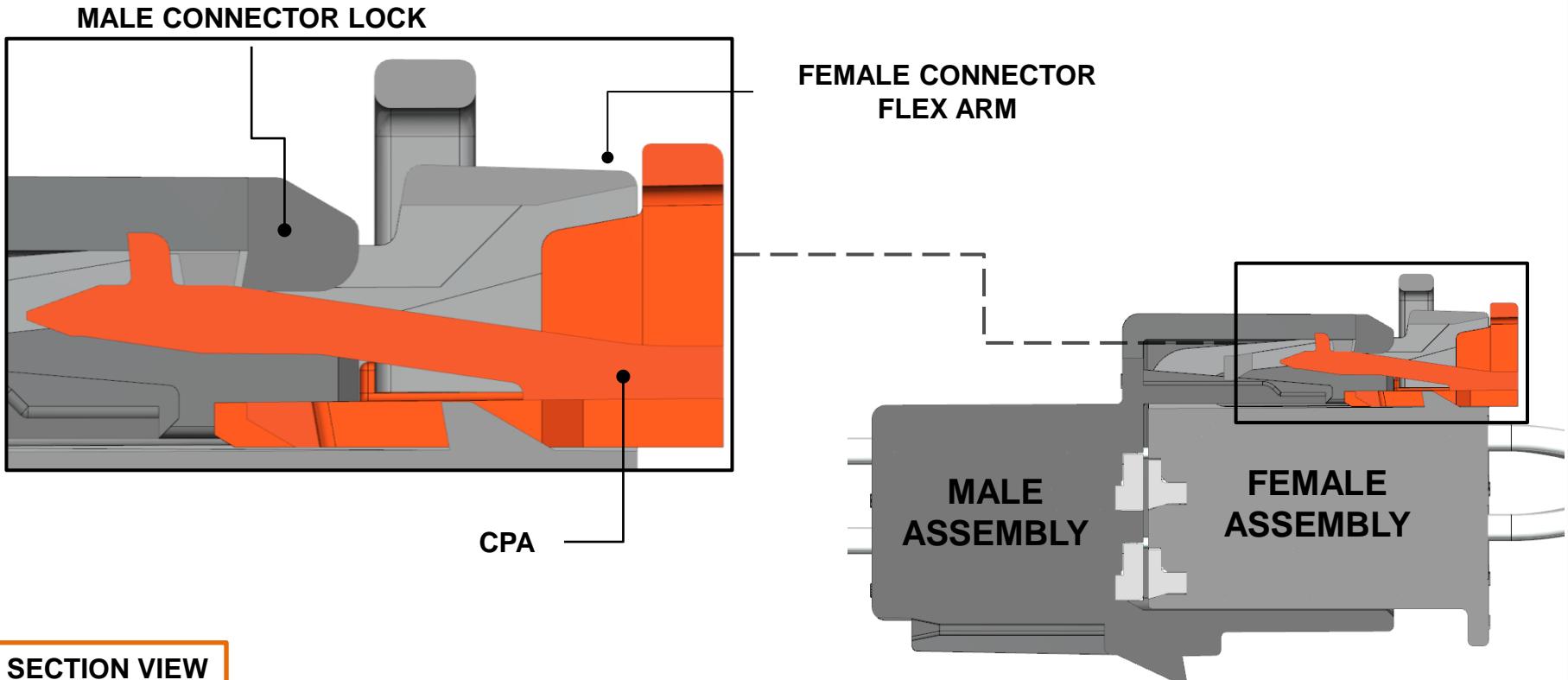
VERIFY AUDIBLE CLICK



ASSEMBLY

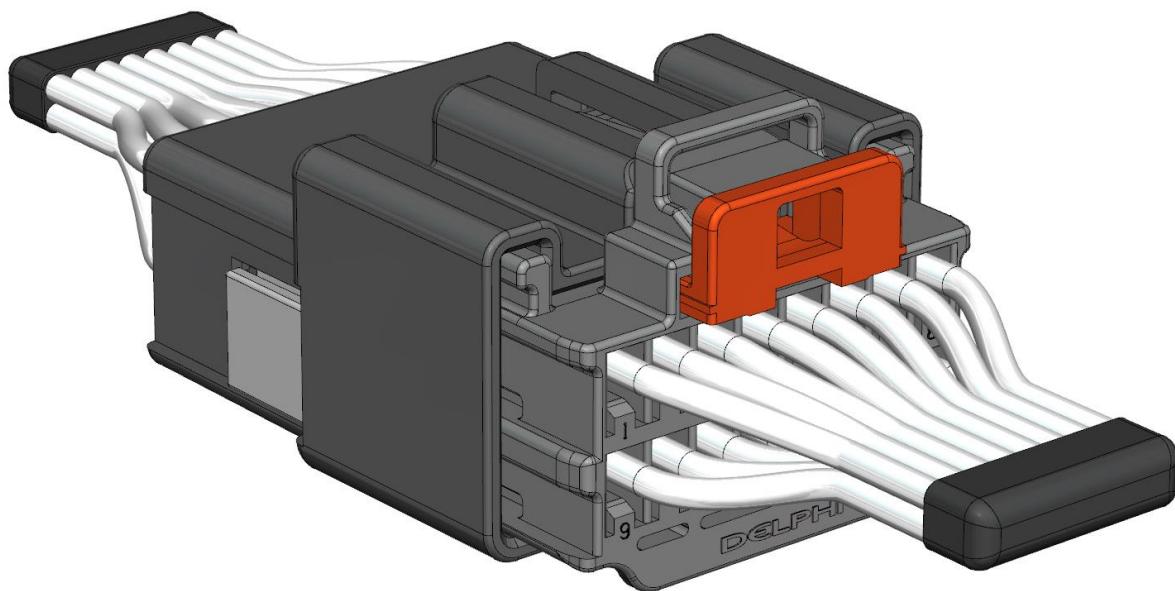
STEP 3b – Close CPA to Full-Stage

THE FLEX ARM CAN NOT BE DEFLECTED BECAUSE THE CPA IS IN FULL-STAGE PREVENTING THE FLEX ARM FROM MOVING DOWNWARD



SECTION VIEW

CONNECTION SYSTEM – COMPLETED ASSEMBLY



DISASSEMBLY

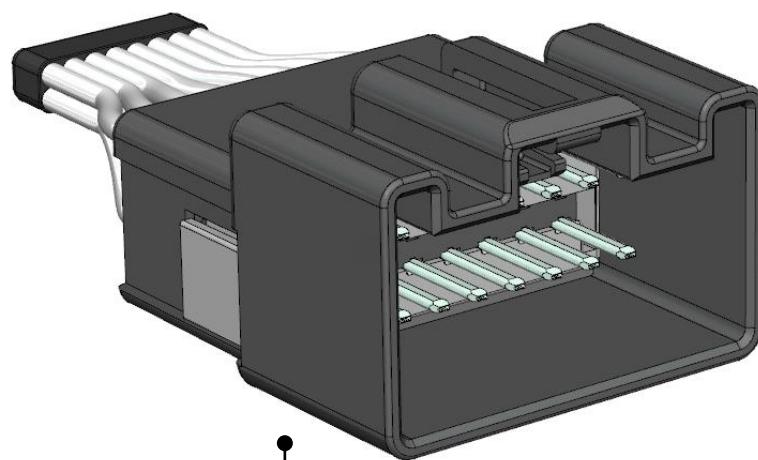
**DISASSEMBLY OF THE
CONNECTION SYSTEM**

PRE - ASSEMBLY

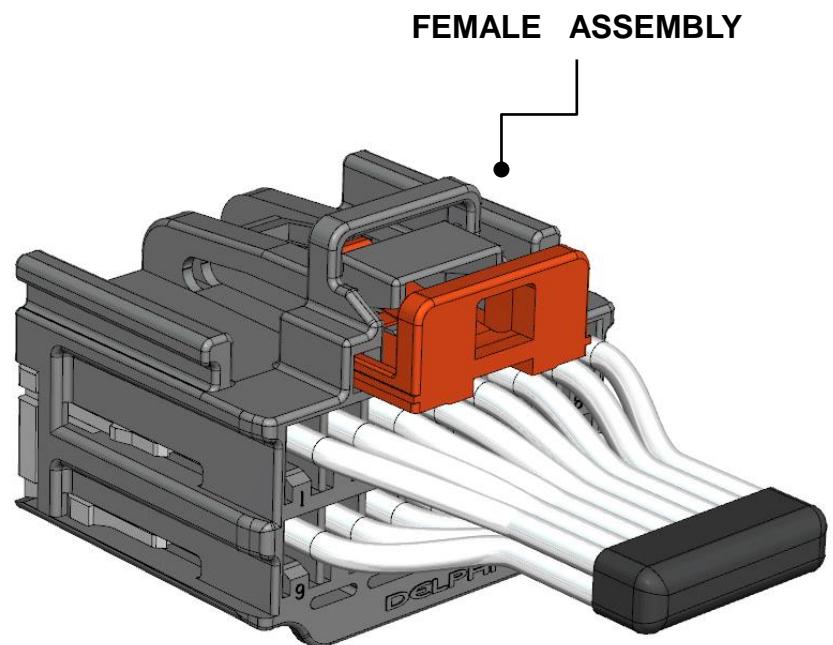
HARNESS ASSEMBLY

CAR ASSEMBLY

1.5 OCS Unsealed Connection System



MALE ASSEMBLY

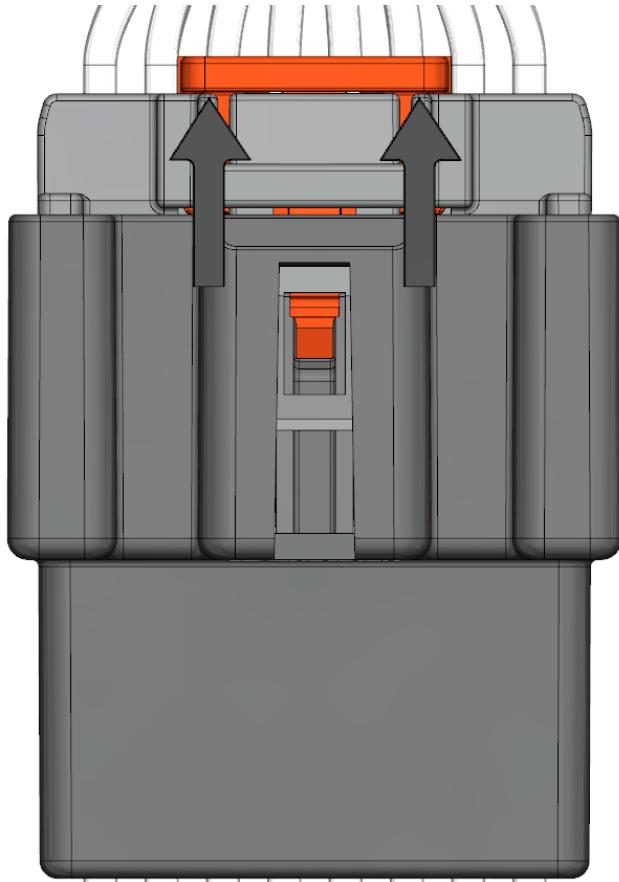


FEMALE ASSEMBLY

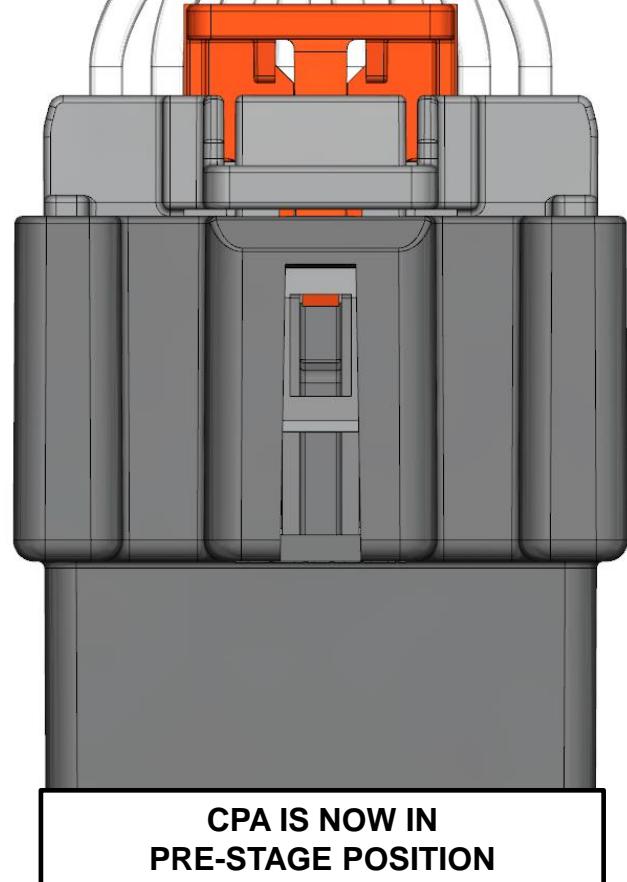
DISASSEMBLY

STEP 1 – Move CPA to Pre-Stage Position

SLIDE BACK THE CPA

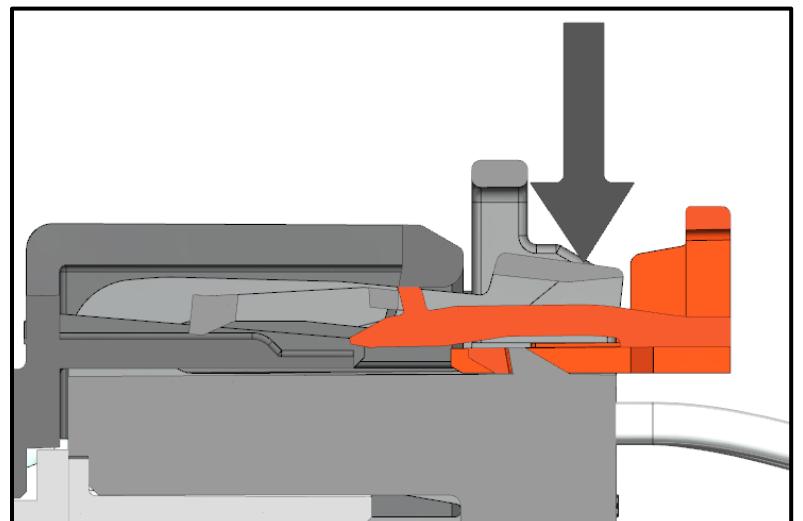
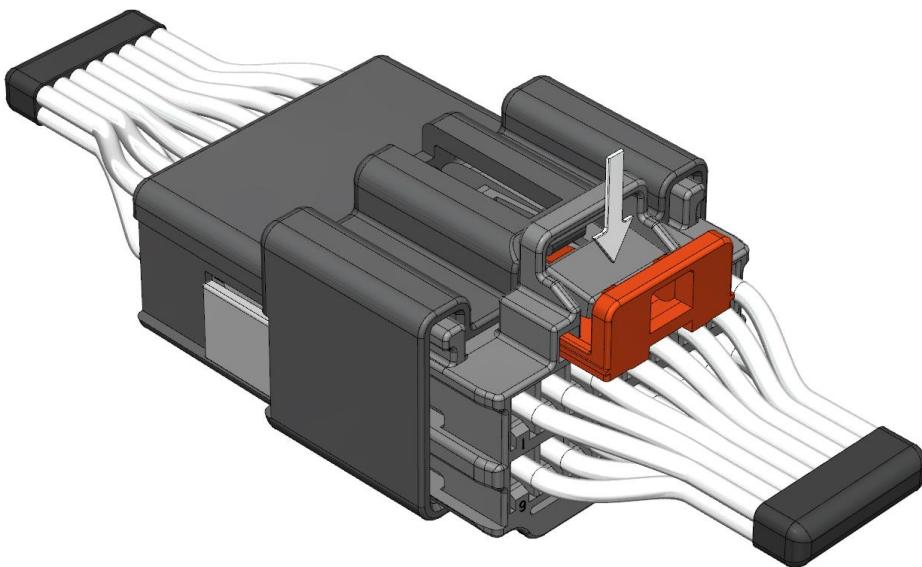


VERIFY AUDIBLE CLICK



STEP 2 – Release the Connector Lock

LOCATE AND PRESS DOWN THE CONNECTOR LOCK

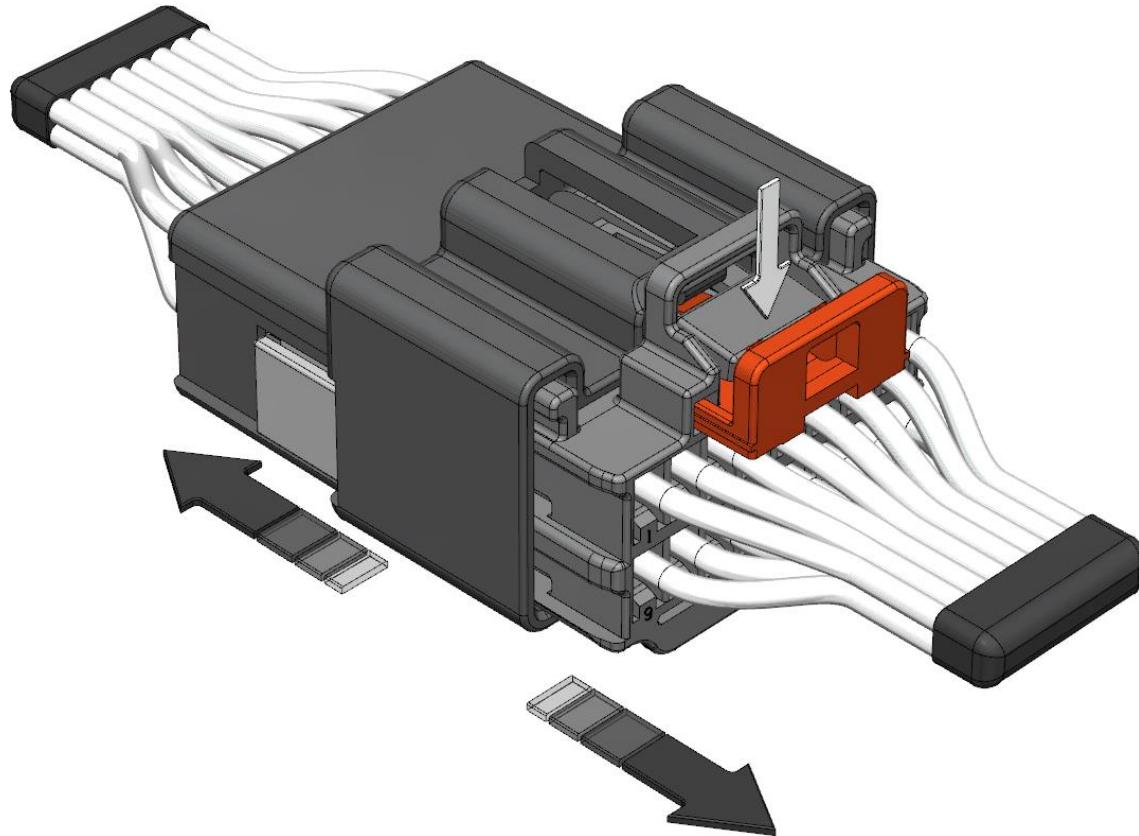


SECTION VIEW

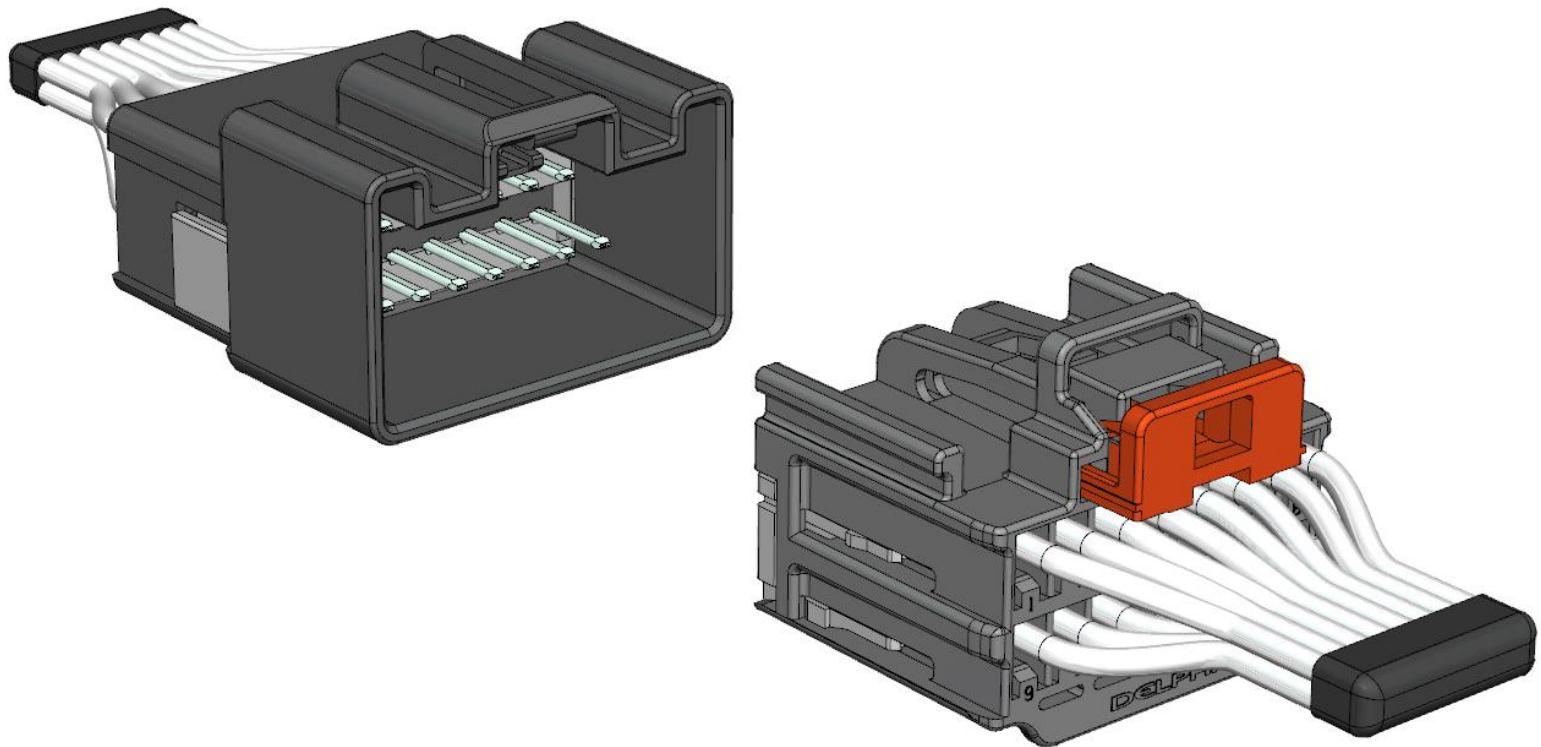
DISASSEMBLY

STEP 3 – Disconnect

WITH THE CONNECTOR LOCK DEFLECTED, PULL BACK BOTH CONNECTORS



CONNECTION SYSTEM – COMPLETED DISASSEMBLY

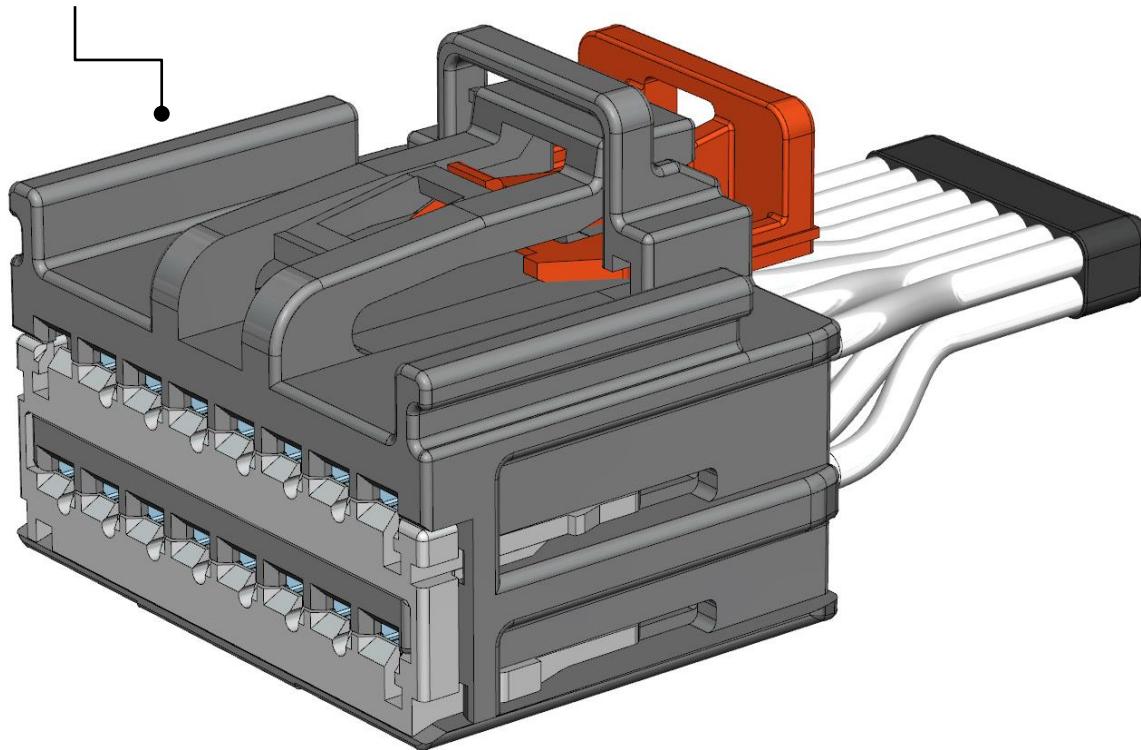


REPAIR / REPLACEMENT

REPAIR / REPLACEMENT OF THE FEMALE ASSEMBLY

1.5 OCS Unsealed Connection System

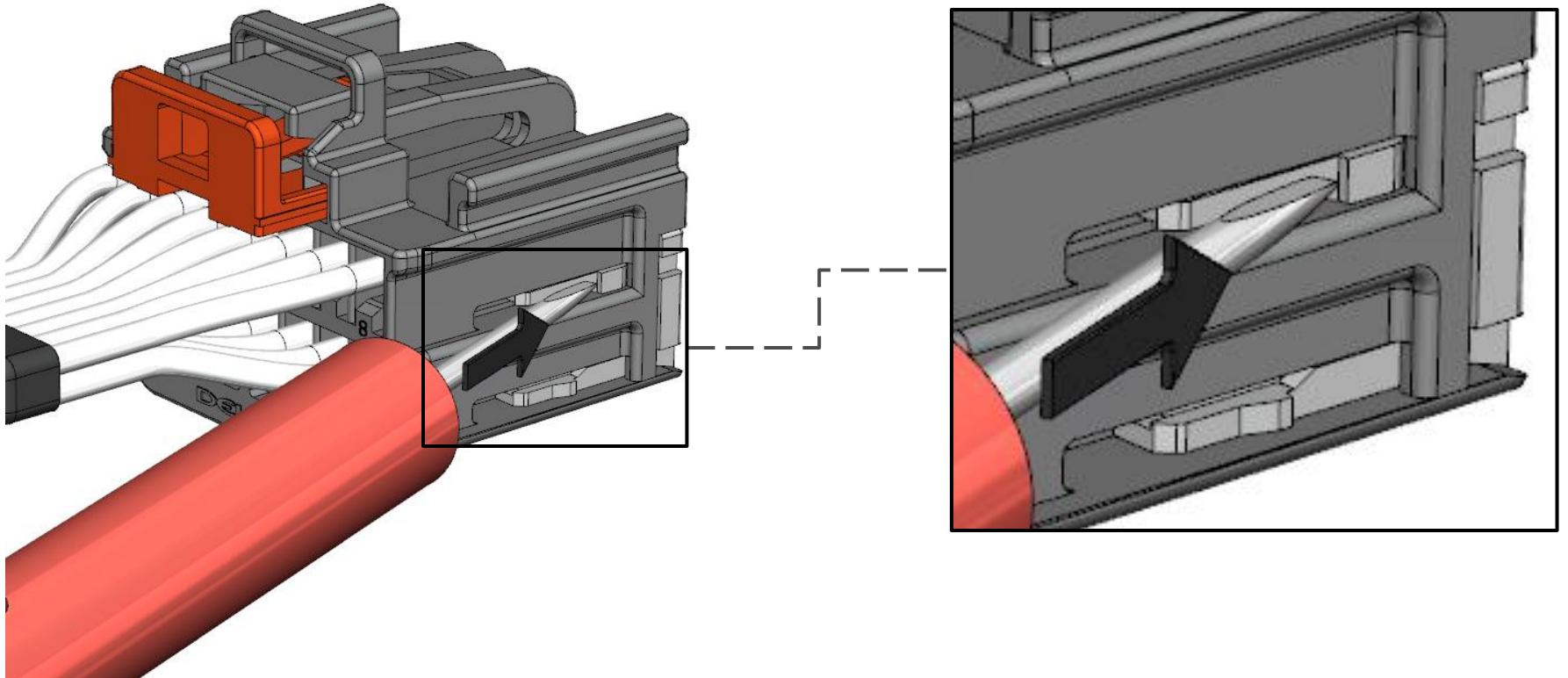
FEMALE ASSEMBLY



REPAIR / REPLACEMENT

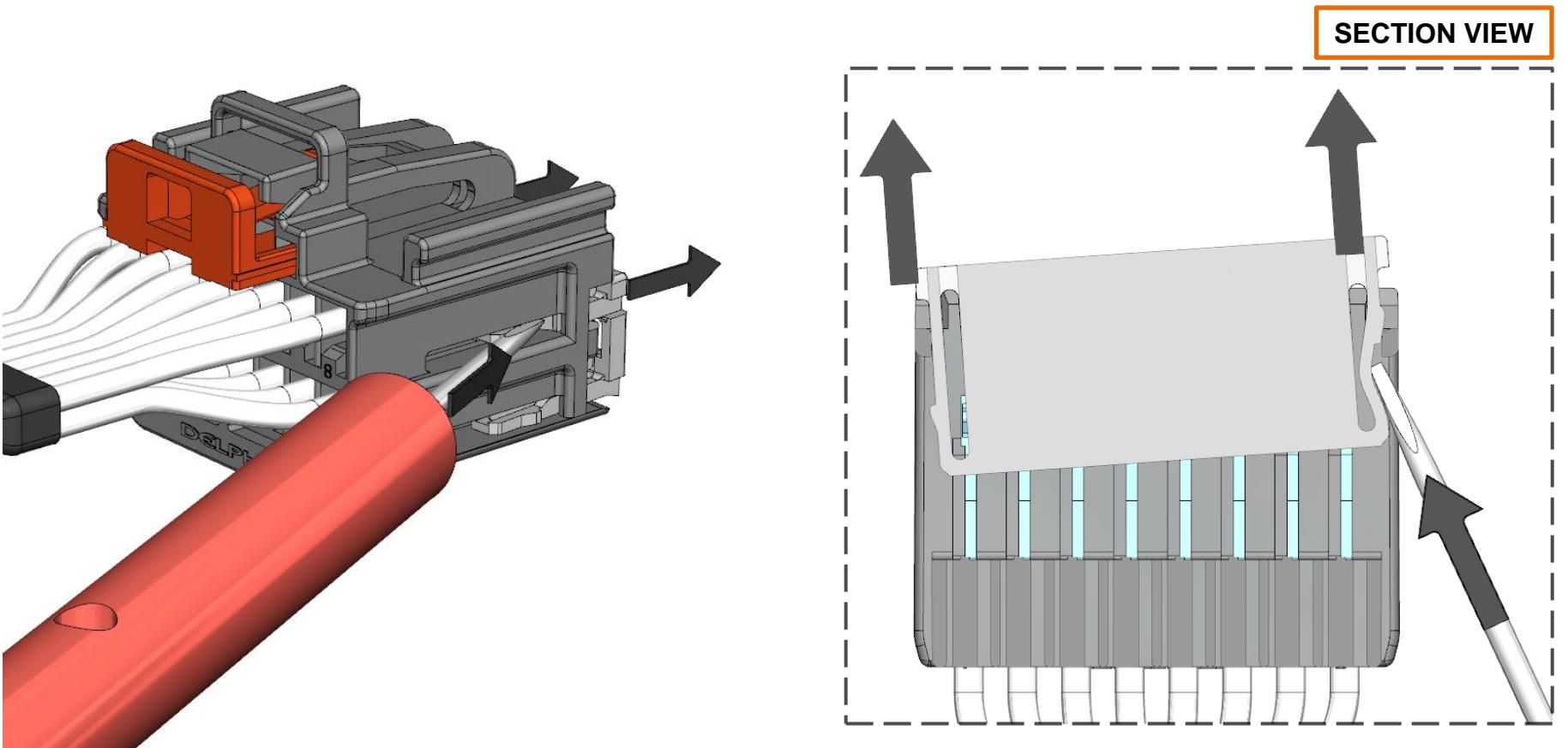
PLR REPLACEMENT (Remove) – STEP 1a

PLACE TOOL 12122647 BEHIND THE LOCK OF THE PLR



PLR REPLACEMENT (Remove) – STEP 1b

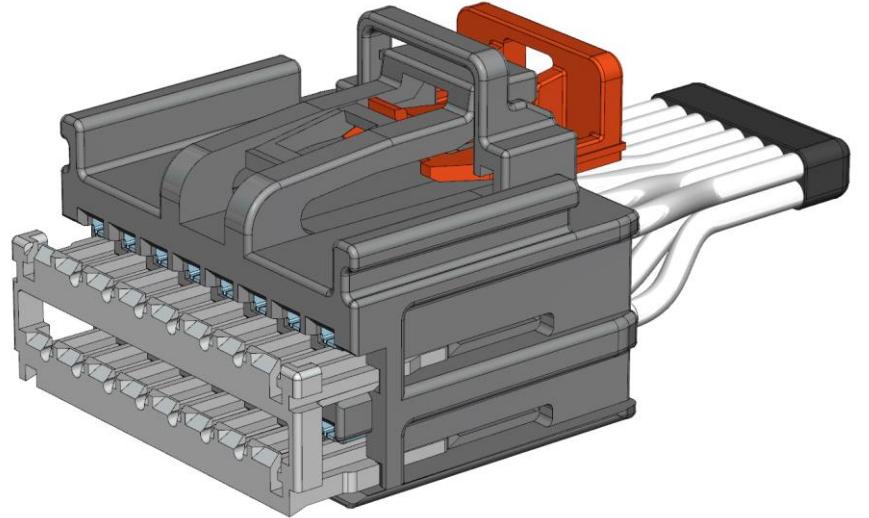
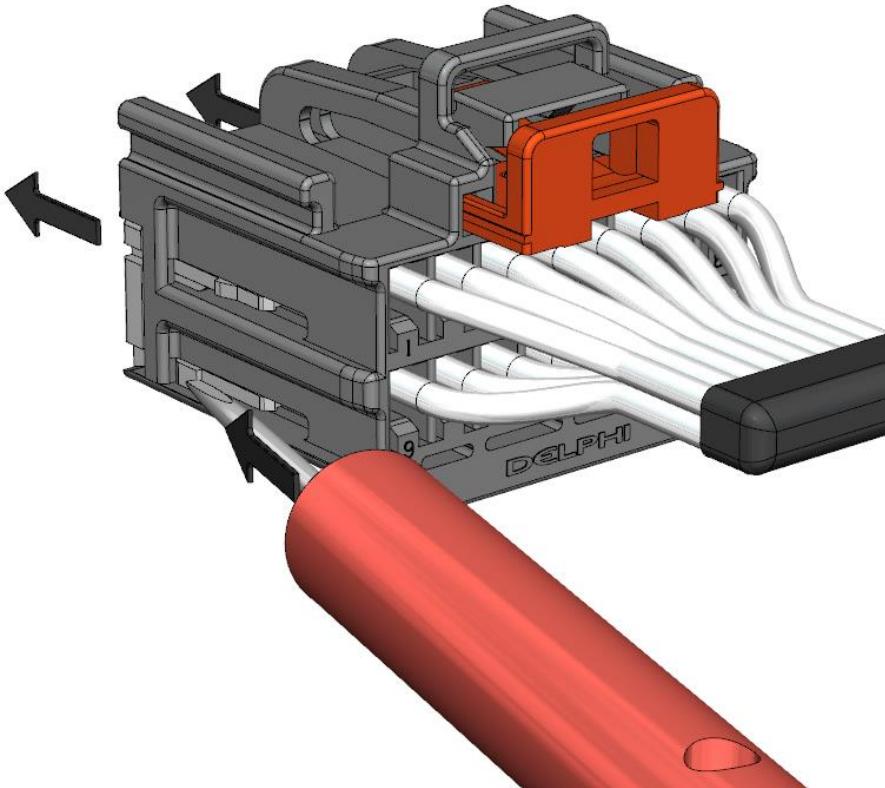
PRESS THE TOOL ENOUGH TO BEND THE LOCK AND RELEASE THAT SIDE OF THE PLR



REPAIR / REPLACEMENT

PLR REPLACEMENT (Remove) – STEP 1c

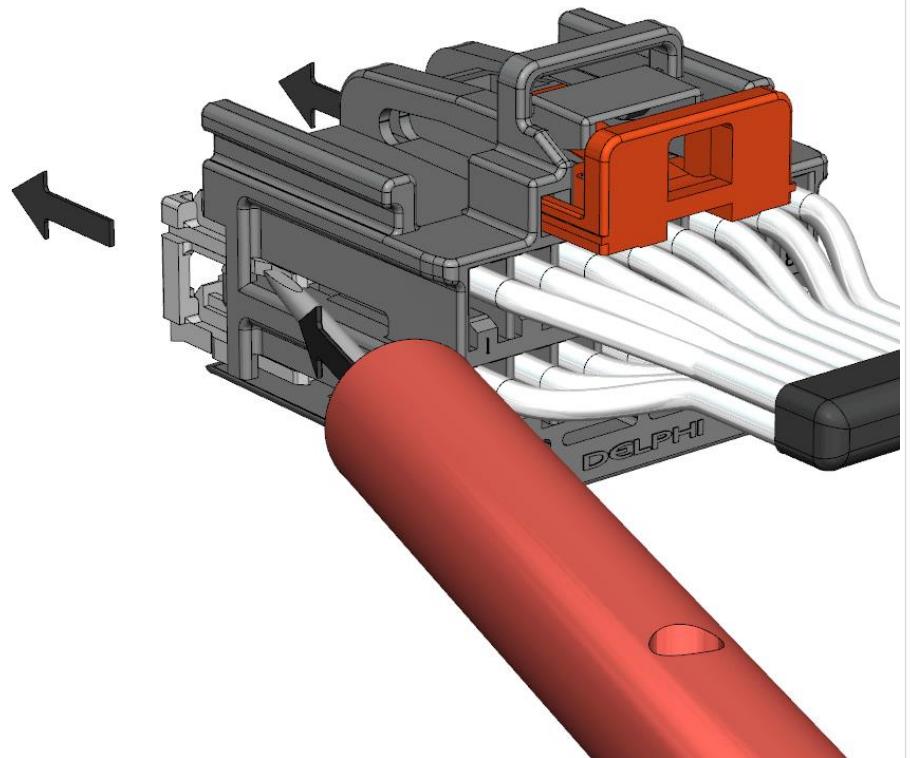
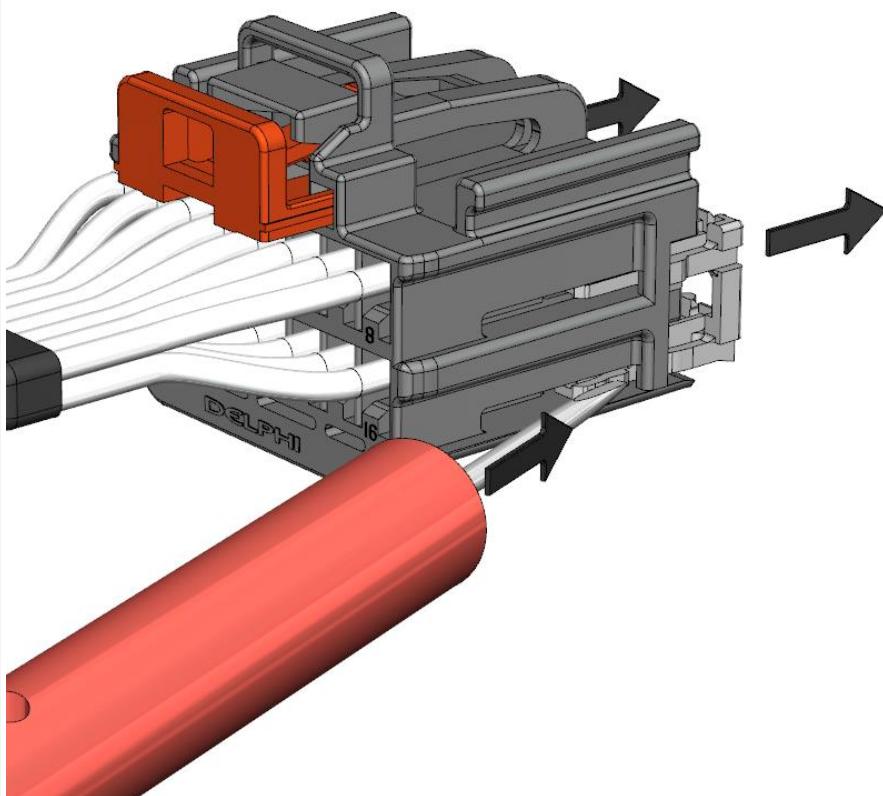
FOLLOW THE SAME PROCESS TO RELEASE THE OTHER SIDE OF THE PLR



PLR IS NOW IN PRE-STAGE POSITION

PLR REPLACEMENT (Remove) – STEP 1d

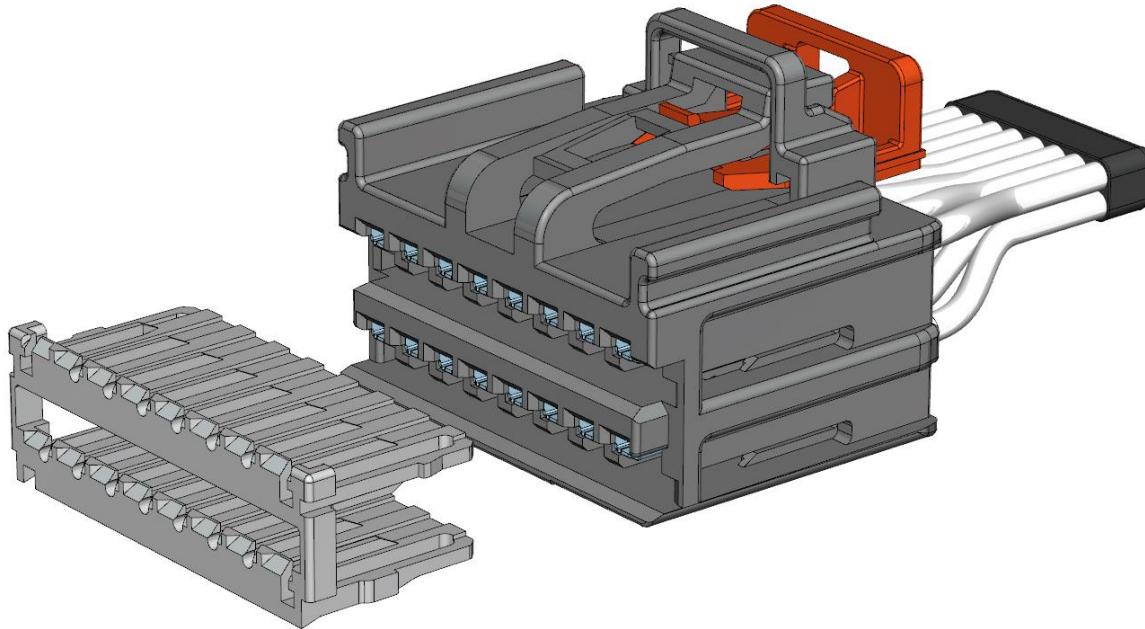
TO COMPLETELY REMOVE THE PLR, REPEAT STEPS 1a TO 1c



REPAIR / REPLACEMENT

PLR REPLACEMENT (Remove) – STEP 1e

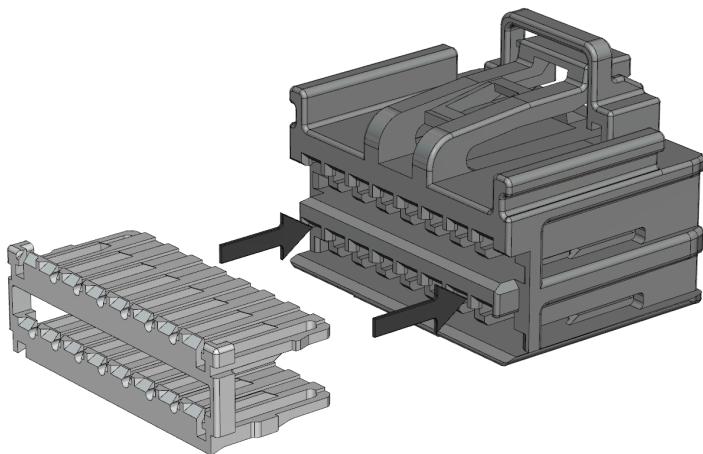
RELEASE PLR FROM THE FEMALE ASSEMBLY



PLR REMOVED

PLR REPLACEMENT (Install) – STEP 2

REFER TO PRE-ASSEMBLY
MANUAL SECTION



DELPHI Assembly Manual
1.5 OCS Unsealed Connection System
1.5 Terminal System

ASSEMBLY

STEP 1a – Align and Insert PLR (to Pre-Stage Position)

VERIFY THE ORIENTATION OF THE PLR

INSERT IT ONTO THE HOUSING

STEP 1b – Align and Insert PLR (to Pre-Stage Position)

VERIFY AUDIBLE CLICK ON BOTH SIDES

LATERAL VIEW

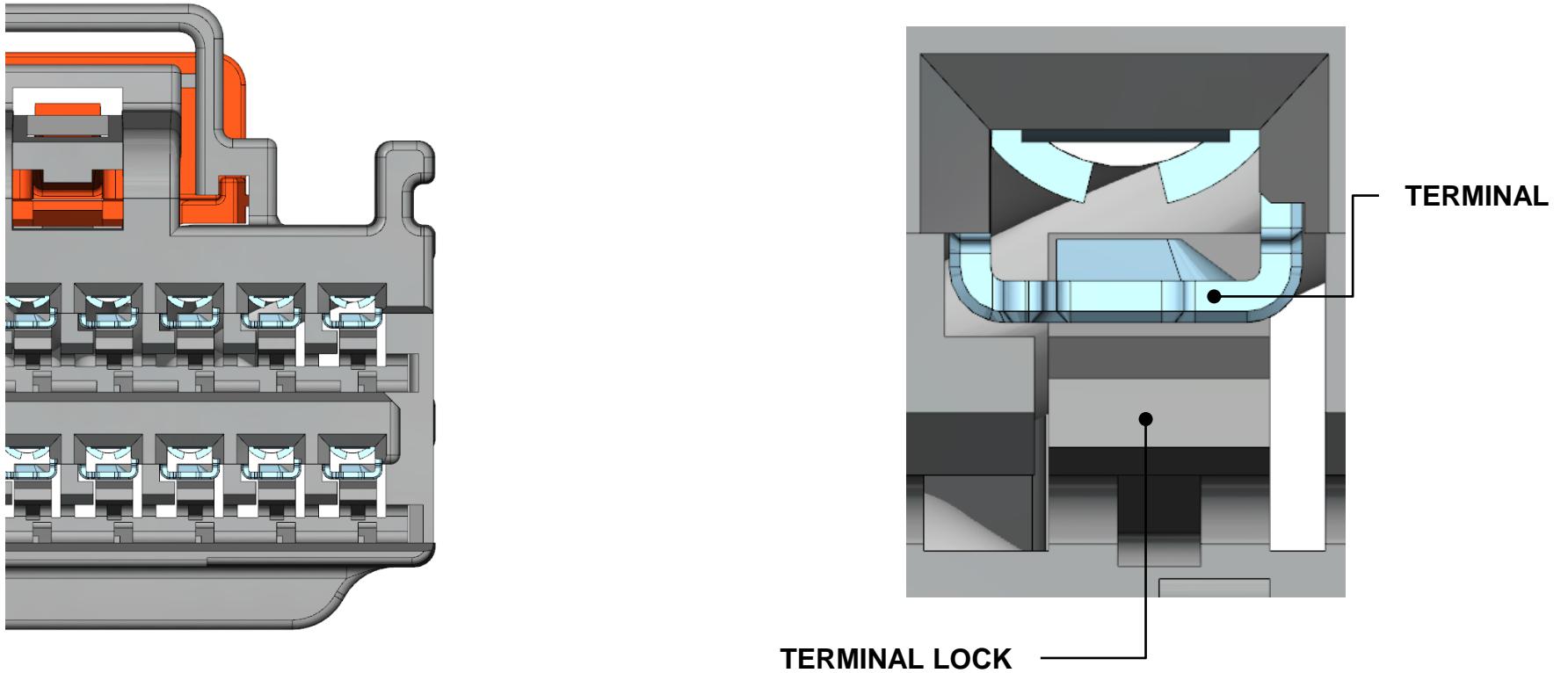
PLR IS NOW IN PRE-STAGE POSITION

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Assembly Manual - 13984858

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REPAIR / REPLACEMENT

FEMALE TERMINAL OCS 1.5 REPLACEMENT (Remove) – STEP 1a



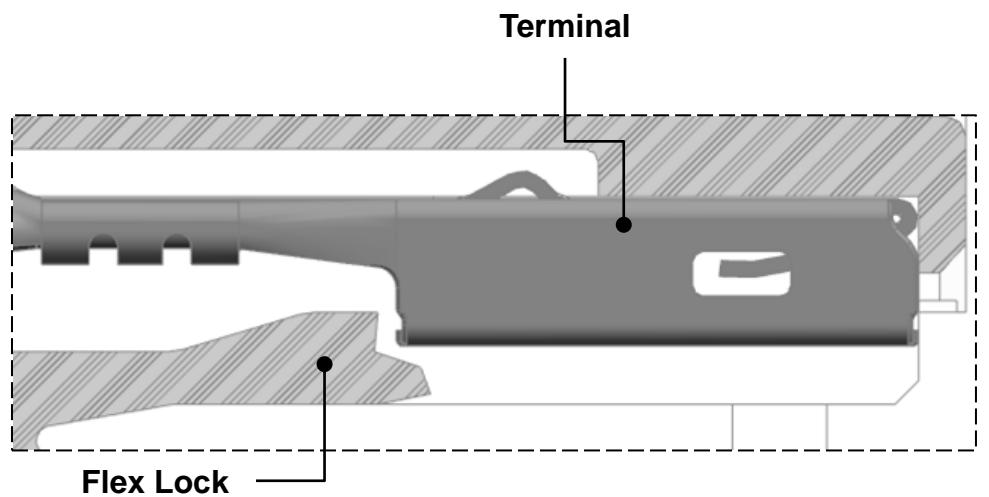
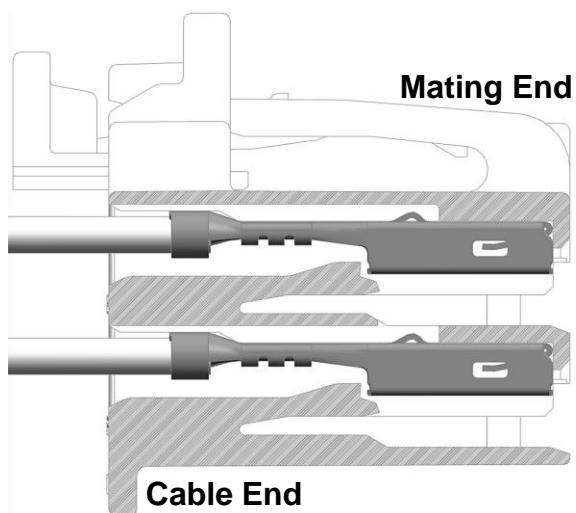
FRONT VIEWS

FEMALE TERMINAL OCS 1.5 REPLACEMENT (Remove) – STEP 1b

REMOVE TERMINALS

IDENTIFY

Flex Lock



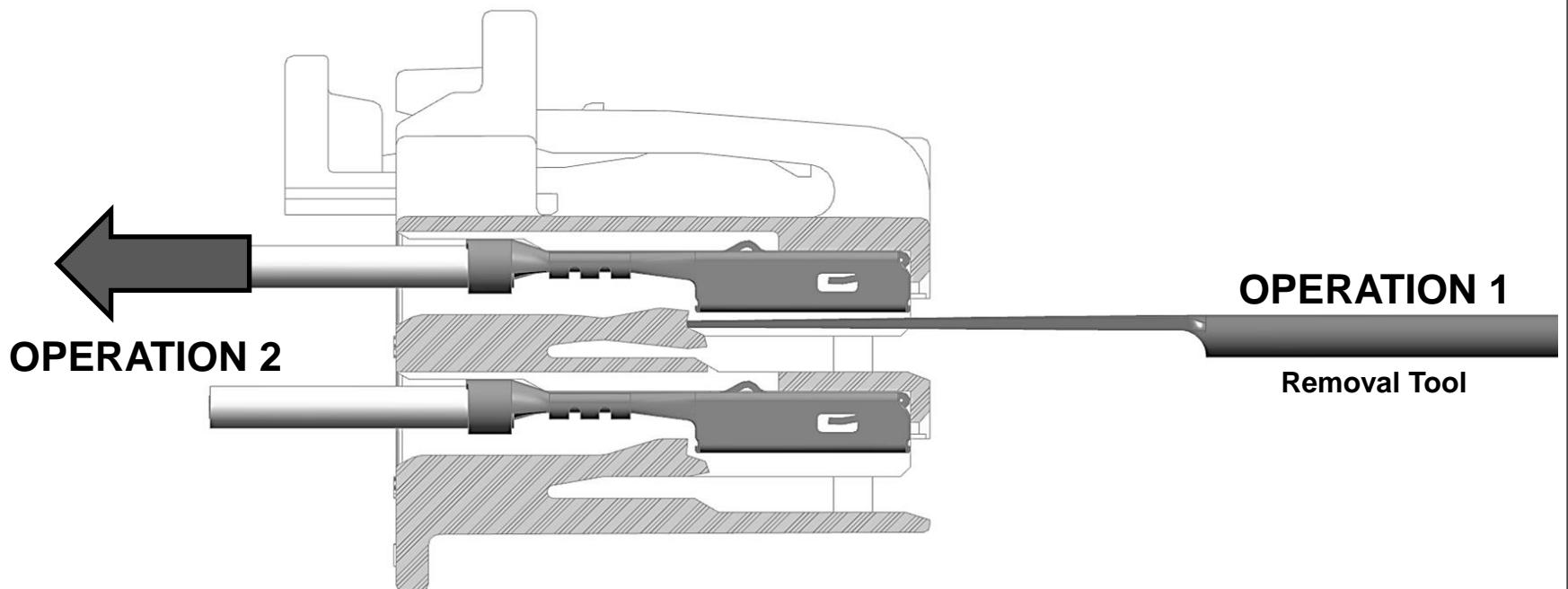
* This graph just represents how this kind of terminals are removed.

REPAIR / REPLACEMENT

FEMALE TERMINAL OCS 1.5 REPLACEMENT (Remove) – STEP 1c

REMOVE TERMINALS

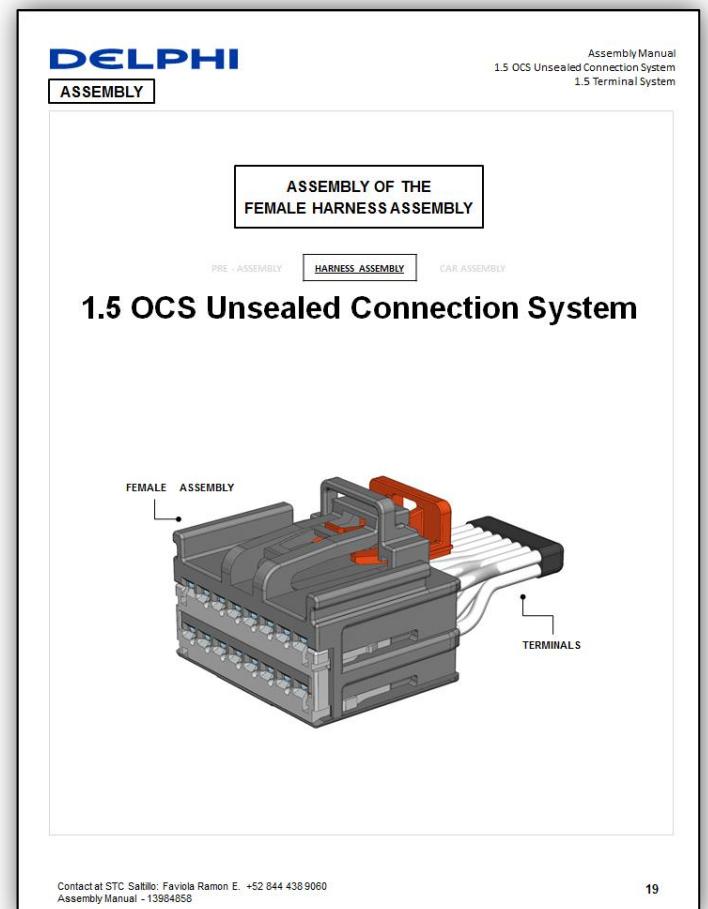
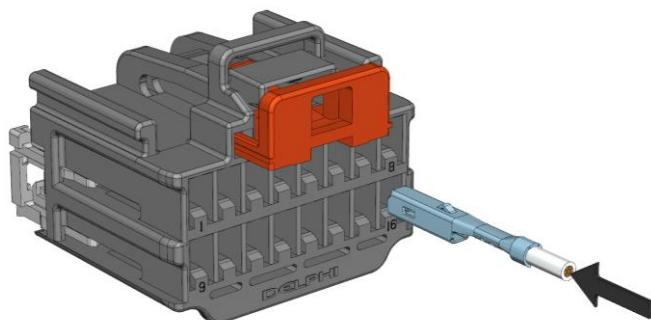
Locate Flex Lock at the front of the Connector. Insert (Operation 1) tool 12094429 straight into the window, deflect the Flex Lock to unseat the Terminal and gently pull on the cable to remove (Operation 2) the Female Terminal from the Connector.



* This graph just represents how this kind of terminals are removed.

FEMALE TERMINAL OCS 1.5 REPLACEMENT (Insert) – STEP 2

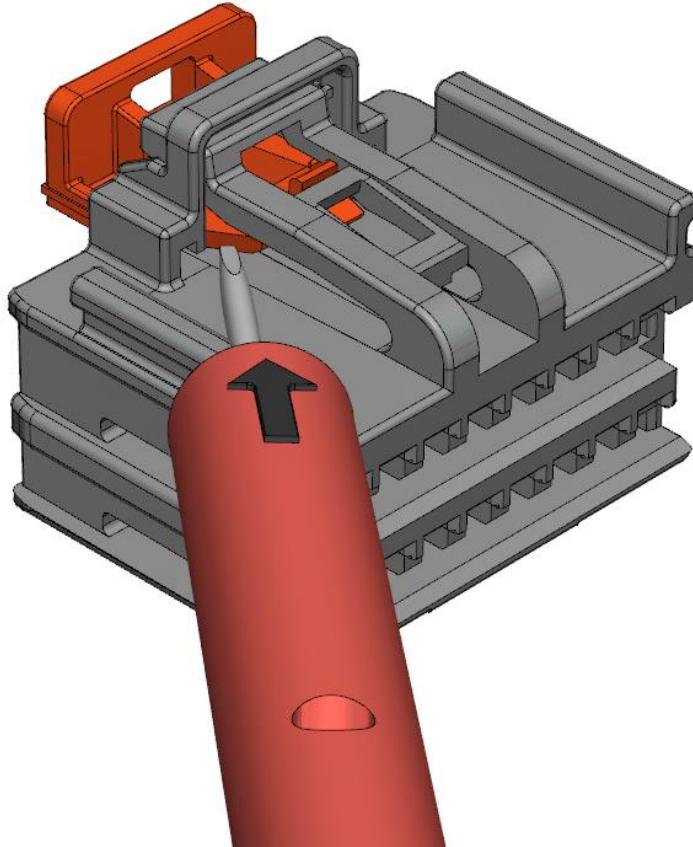
REFER TO HARNESS
MANUAL SECTION



REPAIR / REPLACEMENT

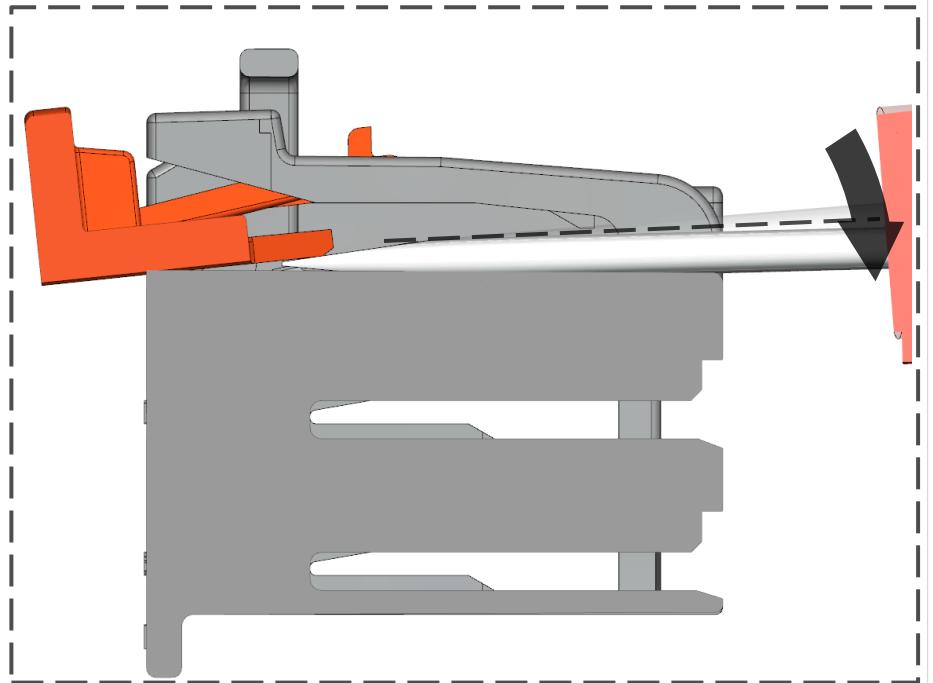
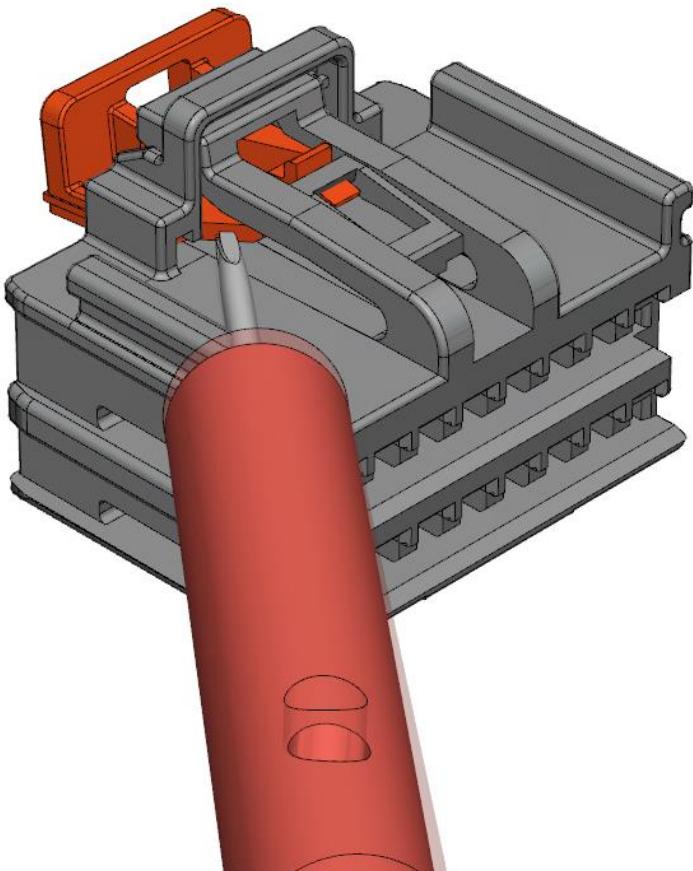
CPA REPLACEMENT (Remove) – STEP 1a

PLACE TOOL 12122647 OR 12094441 BETWEEN THE CONNECTOR AND CPA AS SHOWN



CPA REPLACEMENT (Remove) – STEP 1b

ROTATE THE TOOL TO LIFT THE BOTTOM OF THE CPA

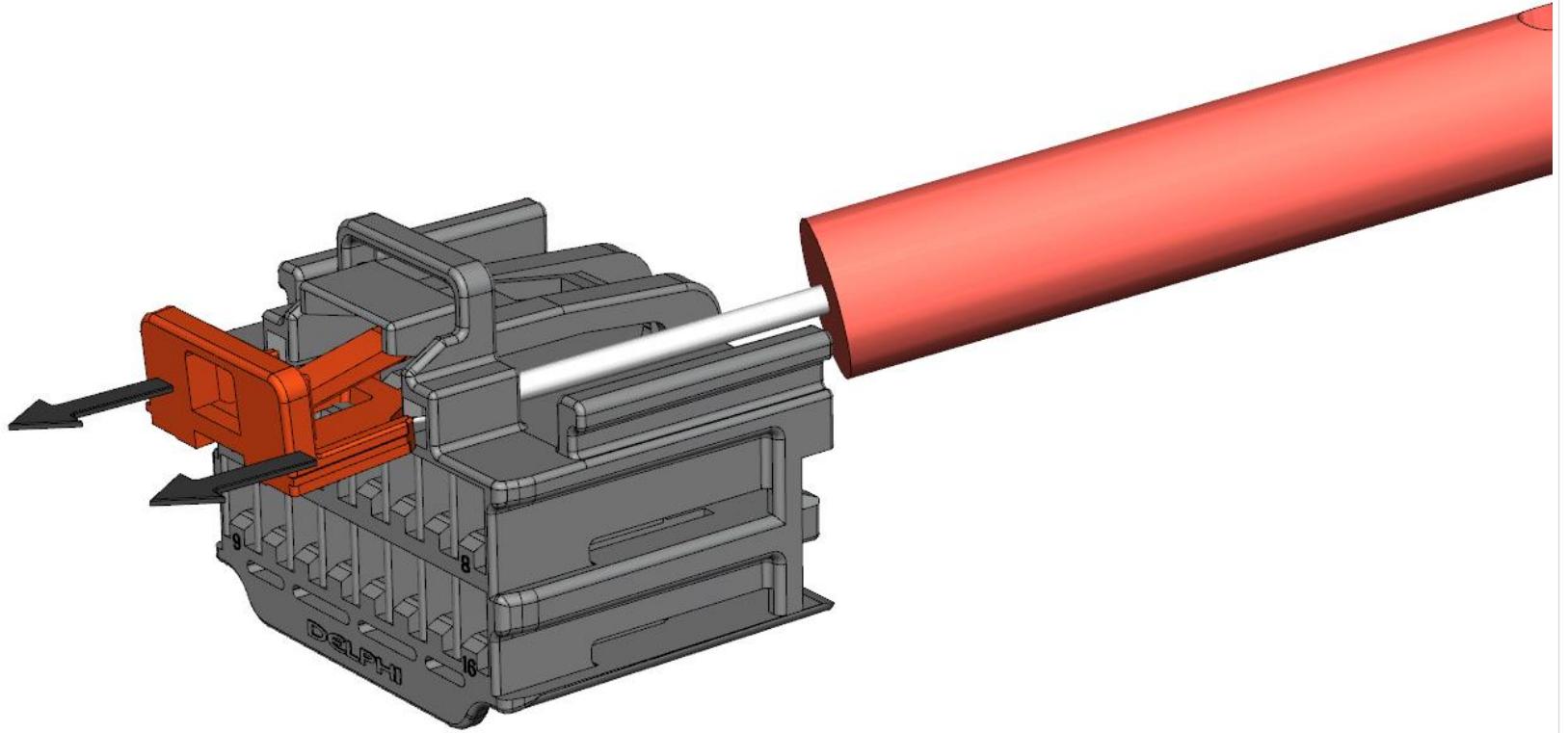


SECTION VIEW

REPAIR / REPLACEMENT

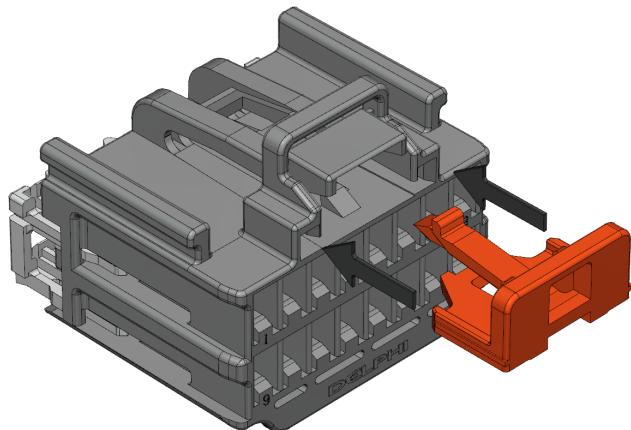
CPA REPLACEMENT (Remove) – STEP 1c

RELEASE THE CPA FROM THE FEMALE ASSEMBLY



CPA REPLACEMENT (Install) – STEP 2

REFER TO PRE-ASSEMBLY
MANUAL SECTION



CPA is not a reusable sub-component.
REPLACE ENTIRE CPA

Assembly Manual
1.5 OCS Unsealed Connection System
1.5 Terminal System

DELPHI

ASSEMBLY

STEP 2 – Identify the Required CPA

| | |
|--|---|
| <p style="font-size: x-small; text-align: center;">CPA FOR SMALL SYSTEMS: 2W, 3W, 4W, 6W & 8W Connectors</p> | <p style="font-size: x-small; text-align: center;">CPA FOR LARGE SYSTEMS: 10W, 12W & 16W Connectors</p> |
|--|---|

THE CPAs SHARE THE SAME METHOD OF ASSEMBLY REGARDLESS THEIR DIFFERENCES

STEP 3a – Align and Lock CPA (to Pre-Stage Position)

BACK VIEW

FEMALE CONNECTOR

CPA

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Assembly Manual - 13984858

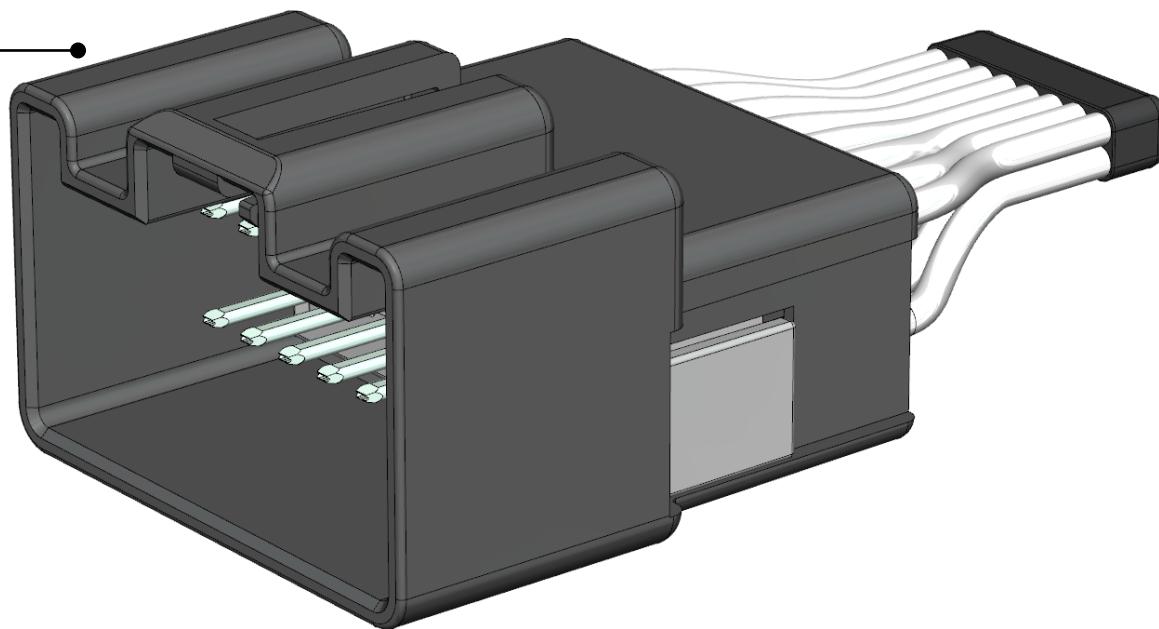
11

REPAIR / REPLACEMENT

REPAIR / REPLACEMENT OF THE MALE ASSEMBLY

1.5 OCS Unsealed Connection System

MALE ASSEMBLY

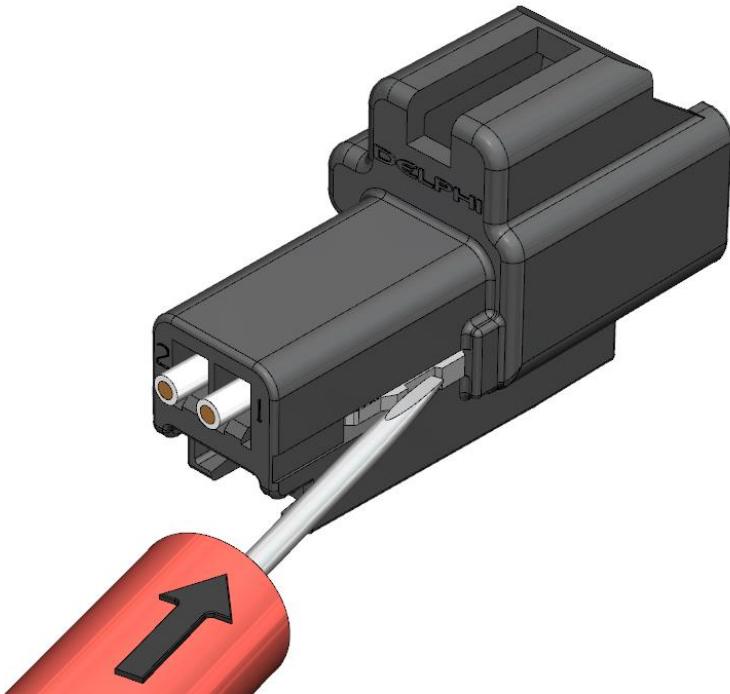


REPAIR / REPLACEMENT

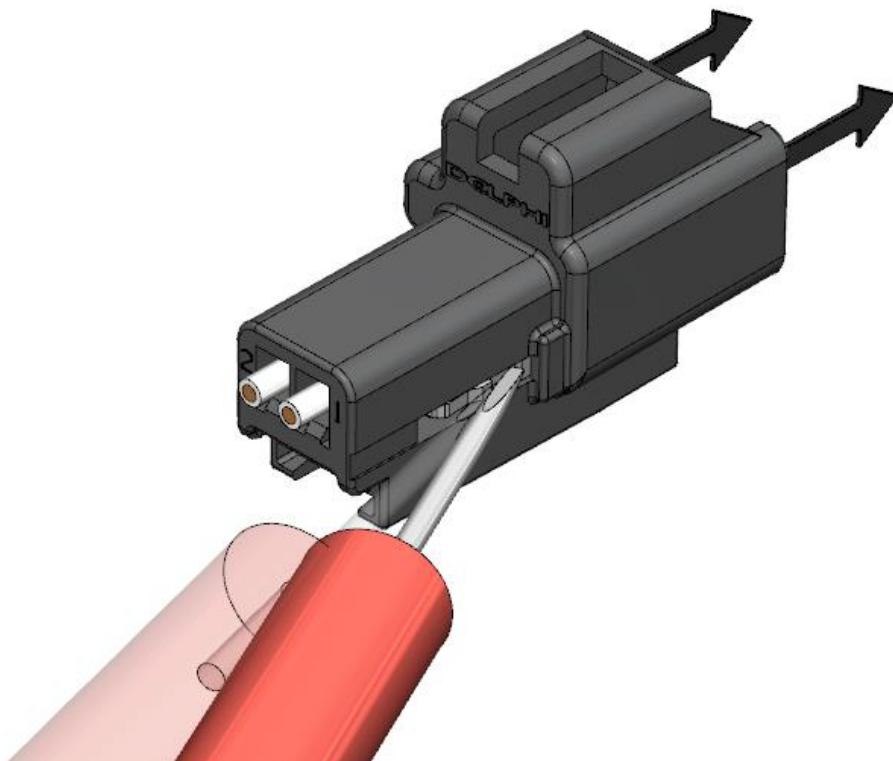
PLR REPLACEMENT (Remove) – STEP 1a

PROCESS FOR SINGLE ROW CONNECTORS:

- 1 PLACE TOOL 12122647 BEHIND THE LOCK OF THE PLR

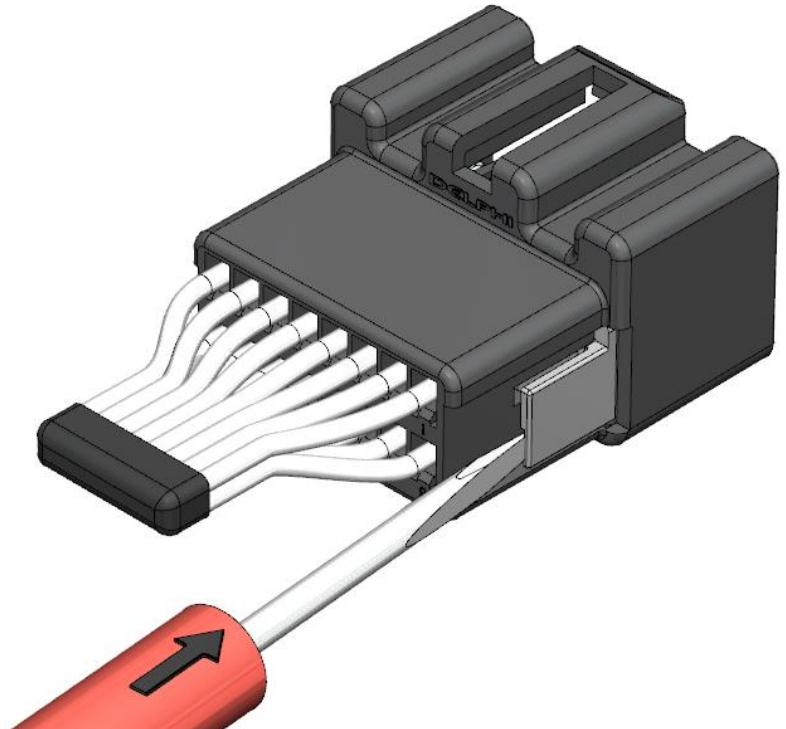


- 2 PRESS THE TOOL ENOUGH TO BEND THE LOCK AND RELEASE THAT SIDE TO PRE-STAGE

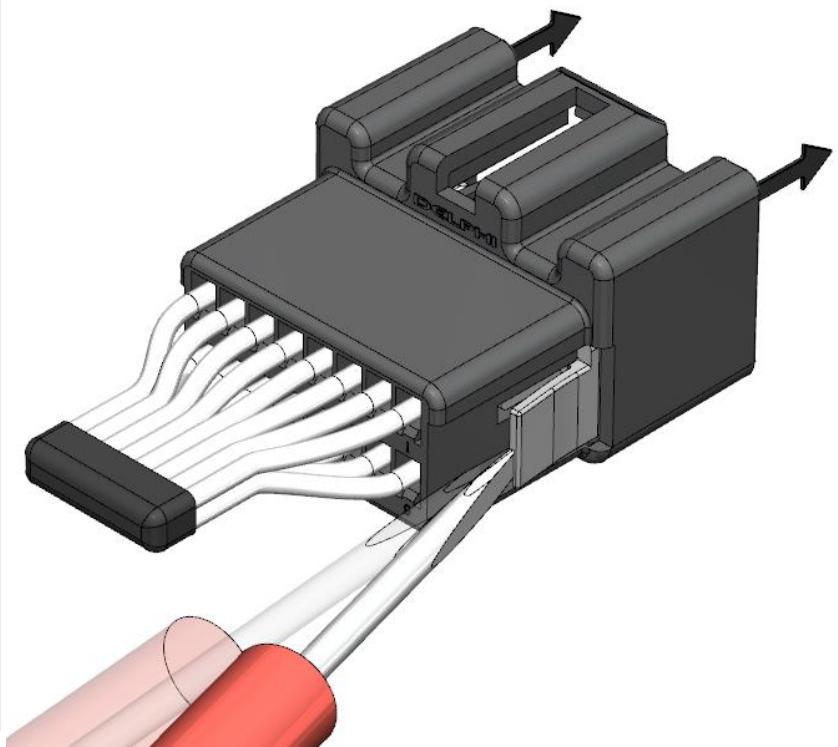


PROCESS FOR DOUBLE ROW CONNECTORS:

- 1 PLACE TOOL 12094441 BEHIND THE TAB OF THE PLR



- 2 DEFLECT THE LOCK AND MOVE THAT SIDE TO PRE-STAGE POSITION

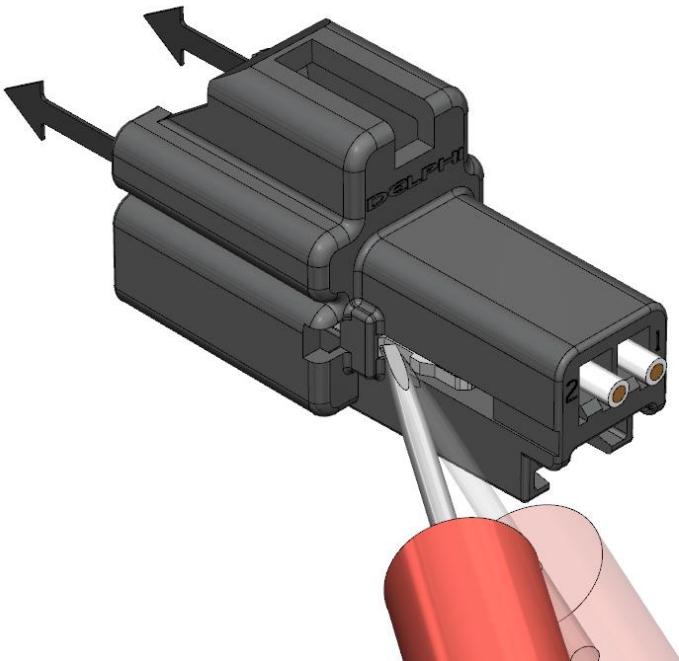


REPAIR / REPLACEMENT

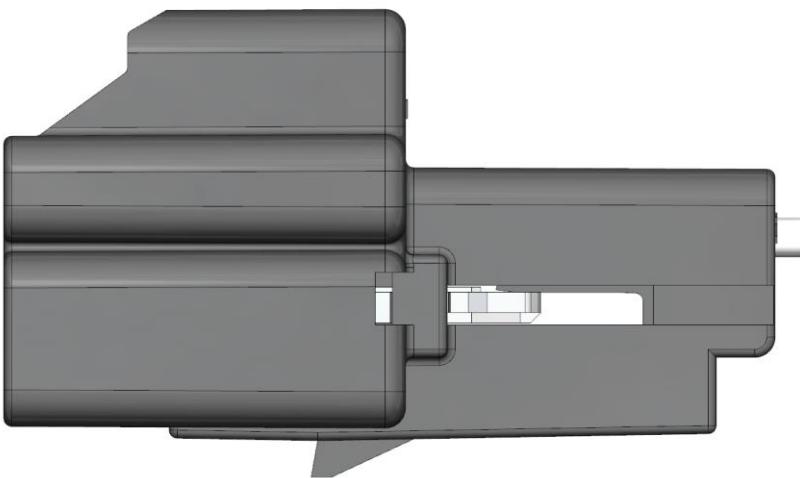
PLR REPLACEMENT (Remove) – STEP 1b

PROCESS FOR SINGLE ROW CONNECTORS:

3 FOLLOW THE SAME PROCESS TO RELEASE THE OTHER SIDE

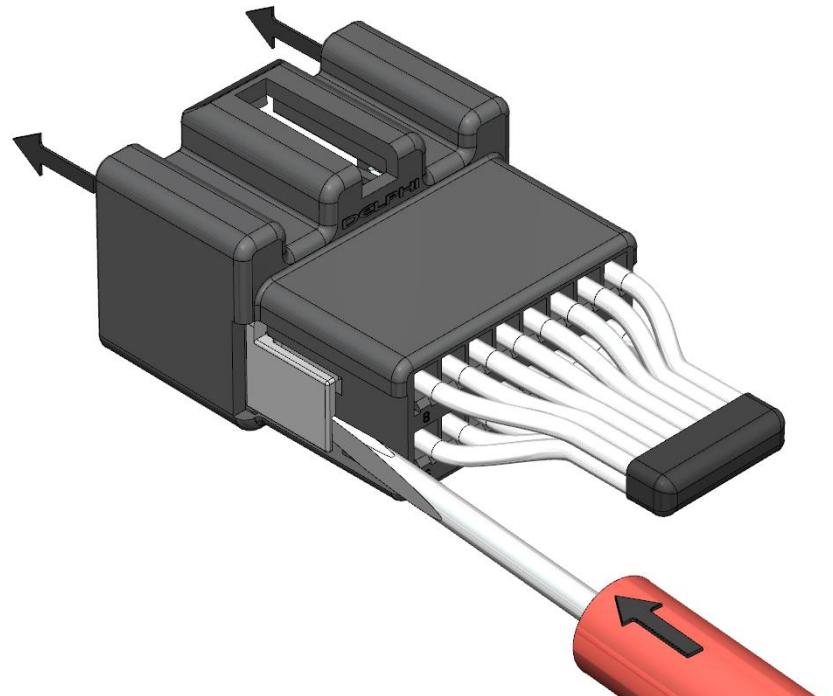


4 PLR IS NOW IN PRE-STAGE POSITION

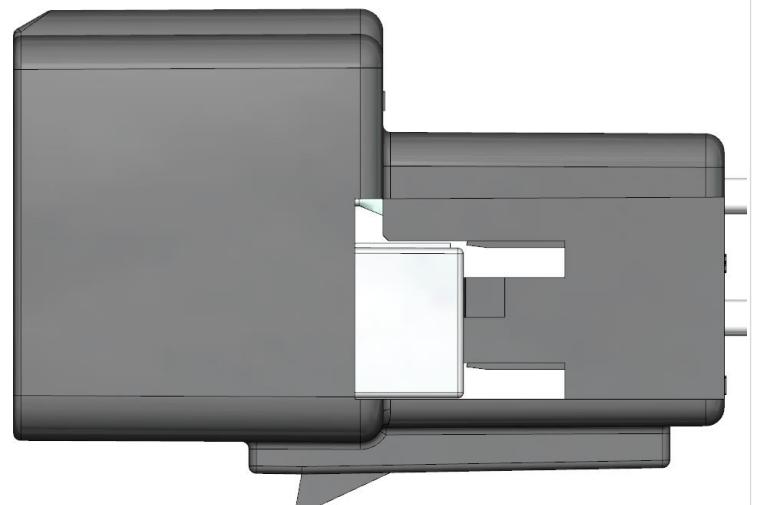


PROCESS FOR DOUBLE ROW CONNECTORS:

3 FOLLOW THE SAME PROCESS TO RELEASE THE OTHER SIDE



4 PLR IS NOW IN PRE-STAGE POSITION

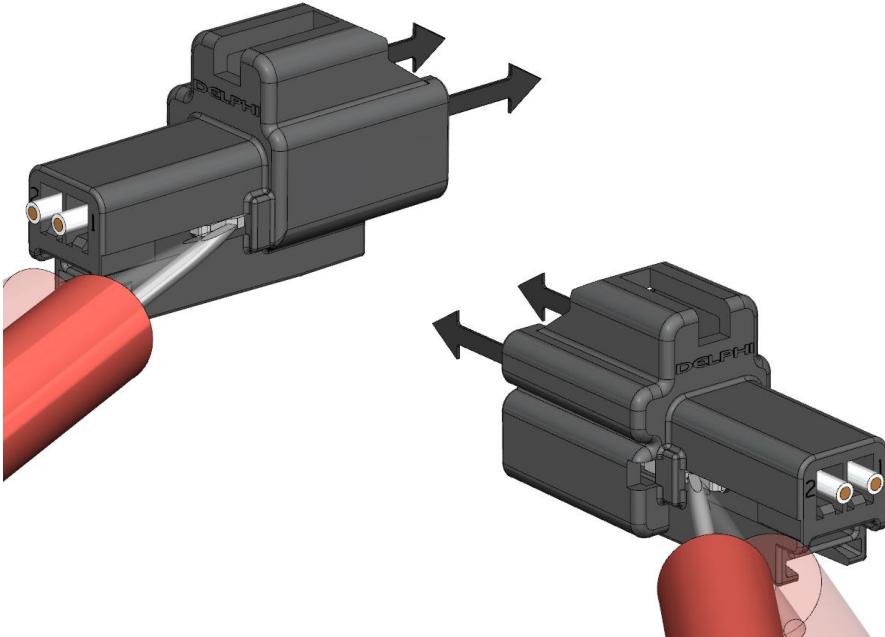


REPAIR / REPLACEMENT

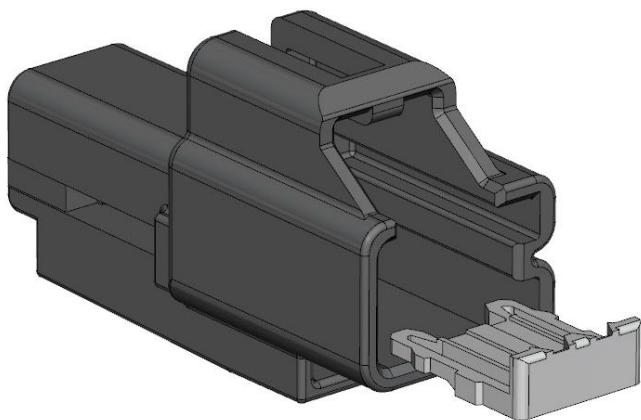
PLR REPLACEMENT (Remove) – STEP 1c

PROCESS FOR SINGLE ROW CONNECTORS:

5 TO COMPLETELY REMOVE THE PLR, REPEAT STEPS **1** **2** **3**

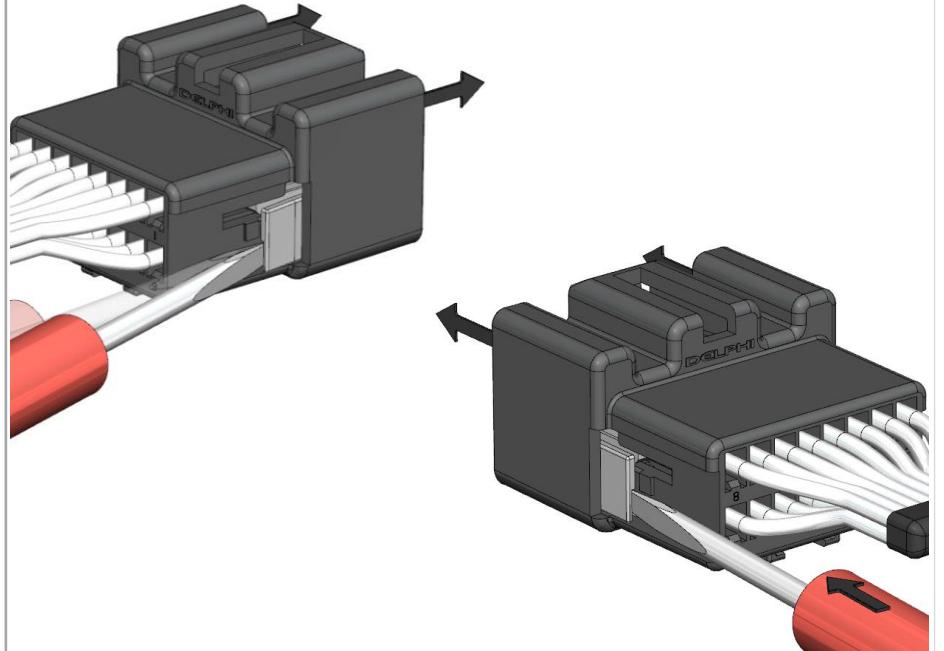


4 RELEASE THE PLR FROM THE MALE CONNECTOR

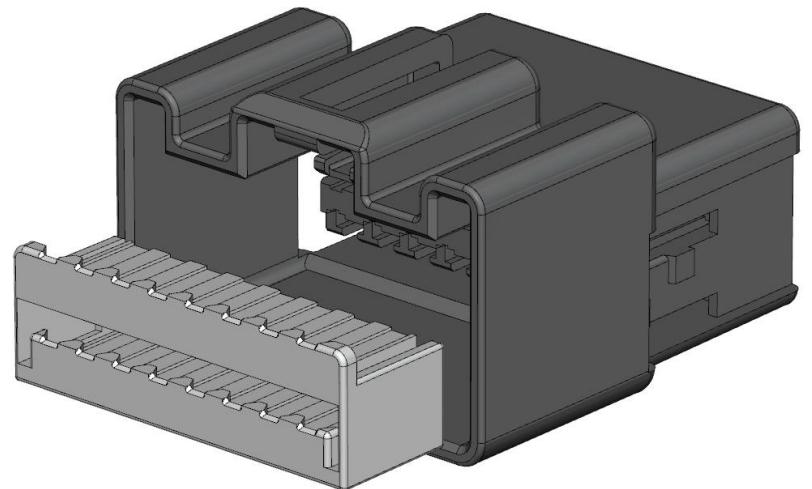


PROCESS FOR DOUBLE ROW CONNECTORS:

5 TO COMPLETELY REMOVE THE PLR, REPEAT STEPS **1** **2** **3**



4 RELEASE THE PLR FROM THE MALE CONNECTOR

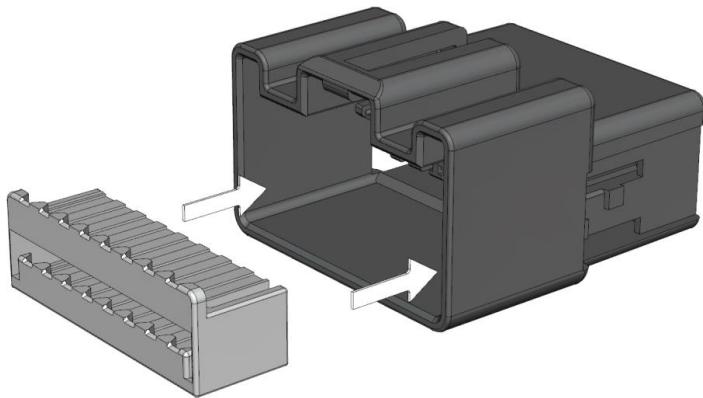


PLR REMOVED

REPAIR / REPLACEMENT

PLR REPLACEMENT (Install) – STEP 2

REFER TO PRE-ASSEMBLY
MANUAL SECTION



DELPHI Assembly Manual
1.5 OCS Unsealed Connection System
1.5 Terminal System

ASSEMBLY

STEP 1a – Align and Insert PLR (to Pre-Stage Position)

VERIFY THE ORIENTATION OF THE PLR

INSERT IT ONTO THE HOUSING

STEP 1b – Align and Insert PLR (to Pre-Stage Position)

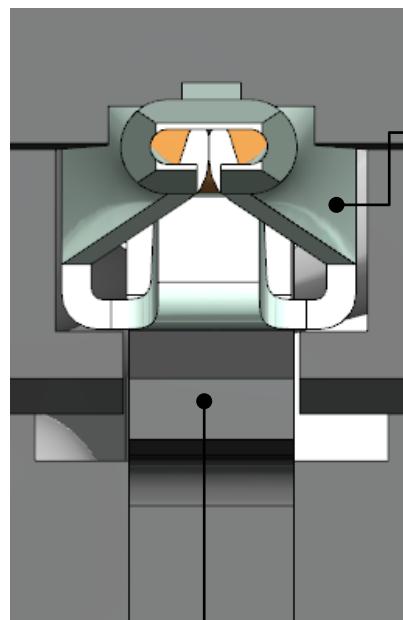
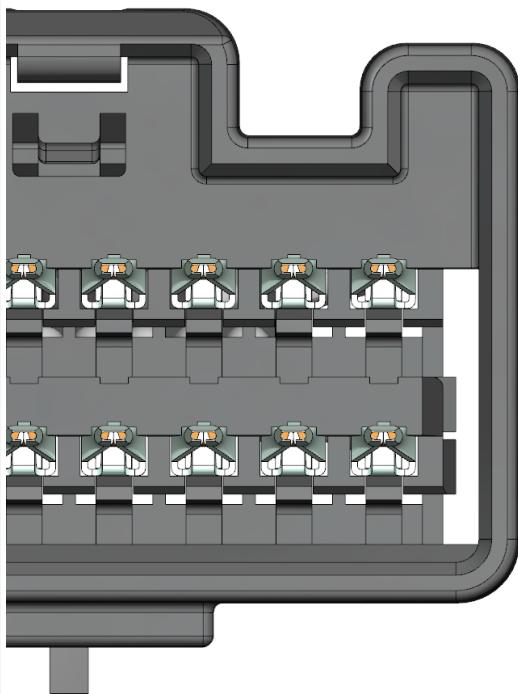
APPLY ENOUGH FORCE ON THE PLR TO CLEAR THE RAMPS OF THE CONNECTOR

MALE CONNECTOR RAMP

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Assembly Manual - 13984858

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MALE TERMINAL OCS 1.5 REPLACEMENT (Remove) – STEP 1a



TERMINAL

TERMINAL LOCK

FRONT VIEWS

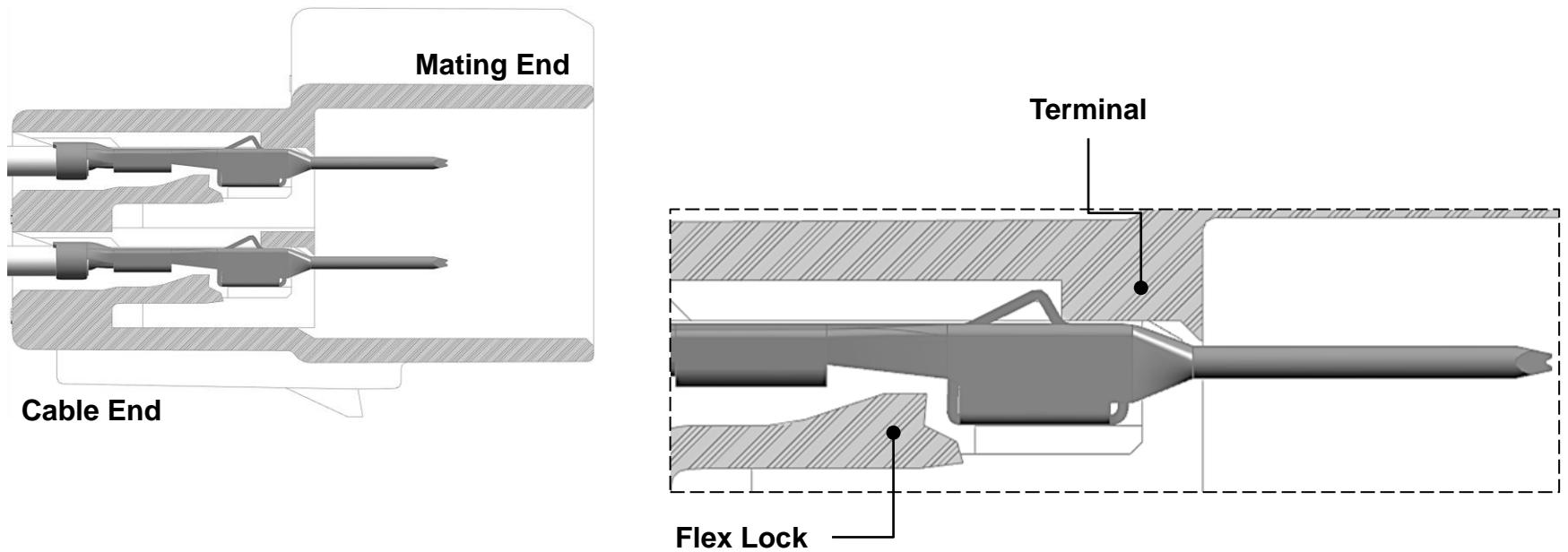
REPAIR / REPLACEMENT

MALE TERMINAL OCS 1.5 REPLACEMENT (Remove) – STEP 1b

REMOVE TERMINALS

IDENTIFY

Flex Lock

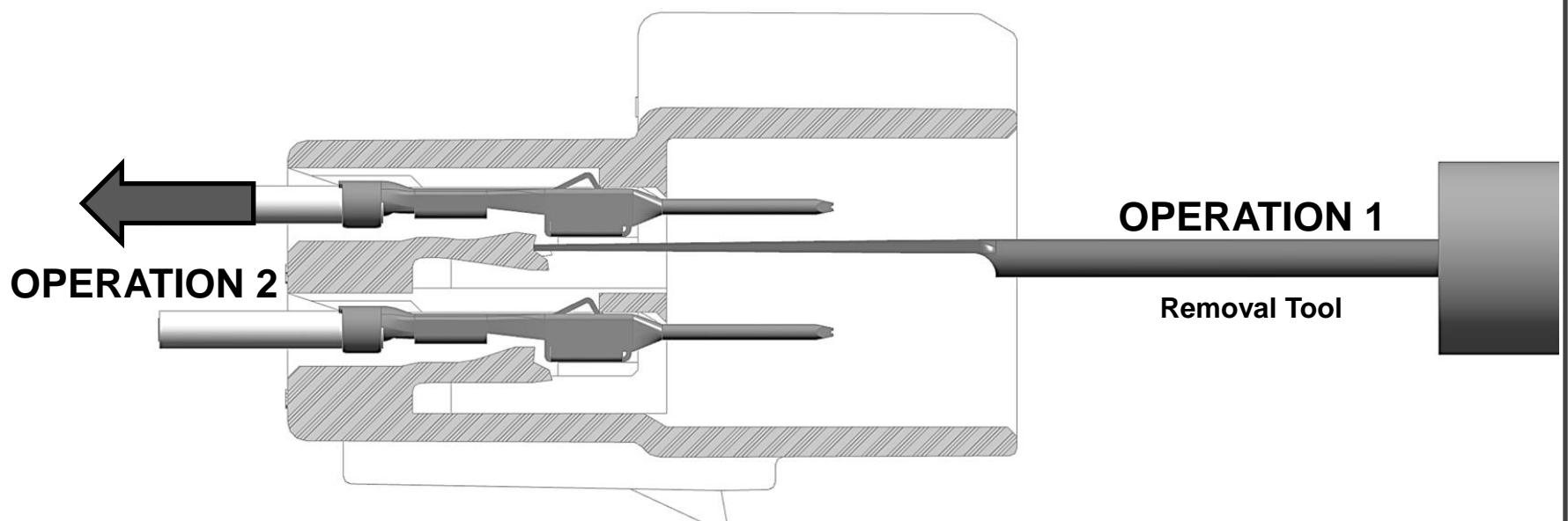


* This graph just represents how this kind of terminals are removed.

MALE TERMINAL OCS 1.5 REPLACEMENT (Remove) – STEP 1c

REMOVE TERMINALS

Locate Flex Lock at the front of the Connector. Insert (Operation 1) tool 12094429 straight into the window, deflect the Flex Lock to unseat the Terminal and gently pull on the cable to remove (Operation 2) the Male Terminal from the Connector.

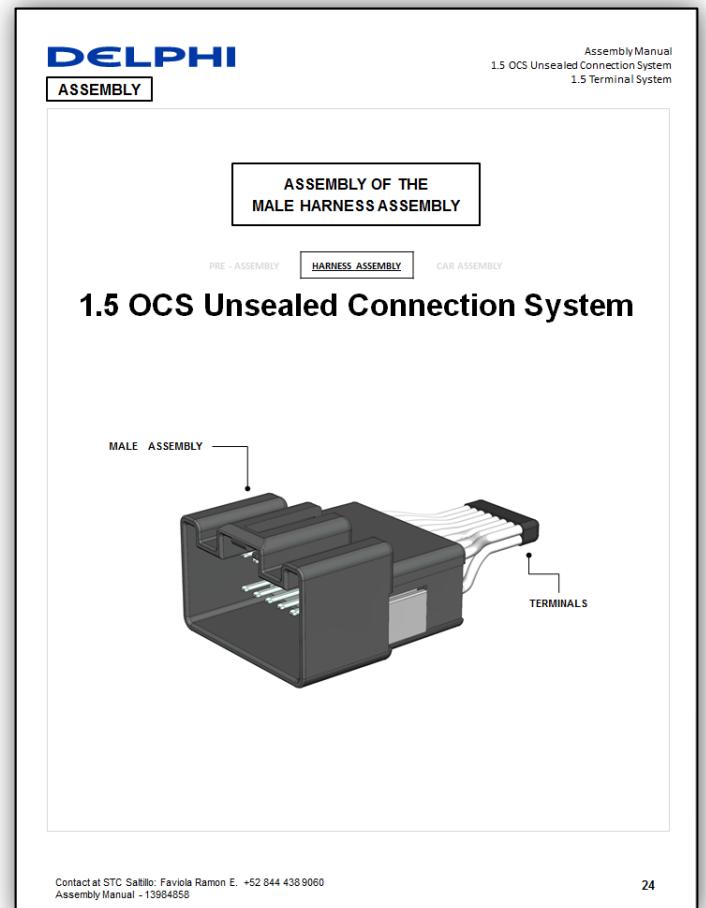
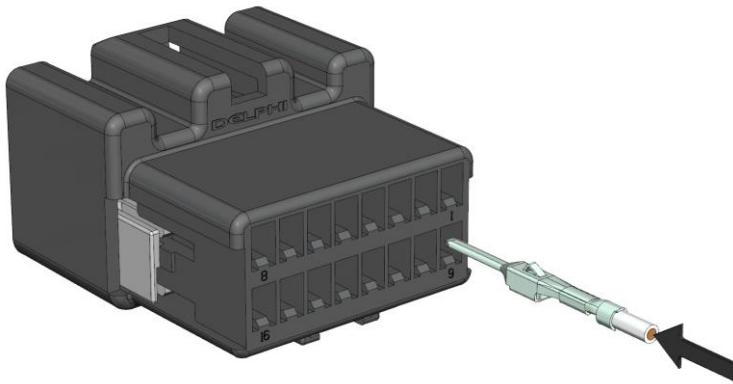


* This graph just represents how this kind of terminals are removed.

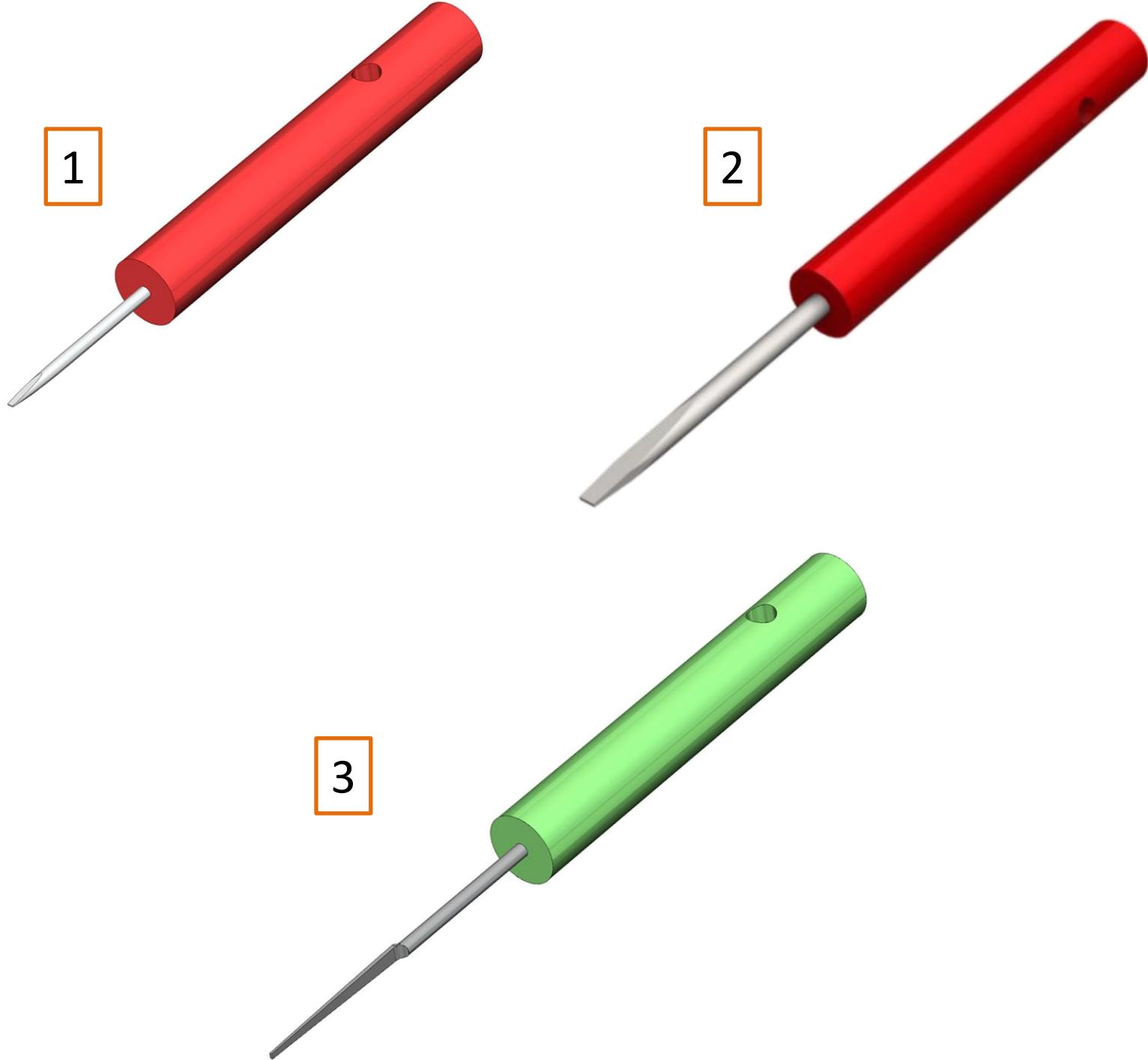
REPAIR / REPLACEMENT

MALE TERMINAL OCS 1.5 REPLACEMENT (Insert) – STEP 2

REFER TO HARNESS
MANUAL SECTION



RECOMMENDED REPAIR TOOLS



| ITEM | DELPHI PART NUMBER |
|------|--------------------|
| 1 | 12122647 |
| 2 | 12094441 |
| 3 | 12094429 |

REVISIONS

| DATE | REV | REVISION HISTORY | AUTH |
|--------|-----|--|--------|
| 09OC12 | 01 | RELEASED | 419659 |
| 18JN13 | 02 | UPDATED GRAPHICS WITH LATEST DESIGNS, CHANGED – CPA & NAME OF THE MANUAL AND ADDED VIEW OF VERSIONS SHEETS | 422488 |
| 19JL13 | 03 | CHANGED TERMINAL INSERTION SEQUENCE AND ADDED LABEL TO REVISE THE CPA LOCK WHEN CLOSED TO FULL-STAGE | 423304 |
| 24FE16 | 04 | UPDATED GRAPHICS WITH LATEST DESIGNS & REPAIR SECTION AND ADDED REPAIR TOOL PART NUMBERS | 431953 |