ASSEMBLY INSTRUCTIONS for
16 WAY GT MIXED 150/280
SEALED CONNECTION SYSTEM

NOTE:
PLEASE CONTACT YOUR DELPHI SALES REPRESENTATIVE
WITH ANY QUESTIONS OR COMMENTS CONCERNING THESE
ASSEMBLY INSTRUCTIONS.

COMPONENT PART NUMBERS AND REPAIR TOOL PART
NUMBERS ARE AVAILABLE FROM YOUR DELPHI SALES ENGINEER.
16-WAY FEMALE GT MIXED 150/280 SEALED CONNECTOR ASSEMBLY
CONSISTS OF THE FOLLOWING COMPONENTS:

**NOTE 1:** COMPONENTS ABOVE SHOULD COME AS AN ASSEMBLY

**NOTE 2:**
THE USE OF THE TERMINAL POSITION ASSURANCE (TPA) IS OPTIONAL, BUT RECOMMENDED
ASSEMBLY INSTRUCTIONS
16-WAY FEMALE GT MIXED 150/280
SEALED CONNECTOR ASSEMBLY

NOTE 3: PLR MUST BE IN THE PRE-STAGE POSITION (NOT THE FINAL LOCKED POSITION) PRIOR TO PLUGGING LEADS (Refer to STEP 4)

STEP 1: PLUG LEADS TO CONNECTOR ASSEMBLY PER PRINT.

STEP 2: BUILD (1) ONE TERMINAL POSITION ASSURANCE (TPA) TO CONNECTOR ASSEMBLY.

A. POSITION TPA BETWEEN TOP AND BOTTOM ROWS OF LEADS, WITH THE LOCK TABS TOWARD THE CONNECTOR.

B. SLIDE TPA ONTO CONNECTOR AND SNAP BOTH LOCK TABS INTO PLACE USING FINGERS.

STEP 3: BUILD (1) ONE CONNECTOR POSITION ASSURANCE (CPA) TO CONNECTOR ASSEMBLY.

A. HOLD CONNECTOR ASSEMBLY PLUGGING SIDE AWAY FROM HAND. HOLD CPA WITH EXTENSIONS TOWARD CONNECTOR.

B. SLIDE EXTENSIONS INTO SLOTS AND SNAP INTO PLACE USING FINGERS.

STEP 4: SEAT PRIMARY LOCK REINFORCEMENT (PLR) FROM PRE-STAGE POSITION TO FINAL LOCK POSITION.
ASSEMBLY INSTRUCTIONS
16-WAY FEMALE GT MIXED 150/280
SEALED CONNECTOR ASSEMBLY

NOTE 4: PLR MUST BE IN THE PRE-STAGE POSITION (NOT THE FINAL LOCKED POSITION) PRIOR TO PLUGGING LEADS (Refer to STEP 4)

STEP 1:
PLUG LEADS TO CONNECTOR ASSEMBLY PER PRINT.

STEP 2: (OPTIONAL)
BUILD (1) ONE TERMINAL POSITION ASSURANCE (TPA) TO CONNECTOR ASSEMBLY.

A. POSITION TPA BETWEEN TOP AND BOTTOM ROWS OF LEADS, WITH THE LOCK TABS TOWARD THE CONNECTOR.

B. SLIDE TPA ONTO CONNECTOR AND SNAP BOTH LOCK TABS INTO PLACE USING FINGERS.

COMPLETED STEP 2
STEP 3:  (OPTIONAL)

BUILD (1) ONE CONNECTOR POSITION ASSURANCE (CPA) TO CONNECTOR ASSEMBLY.

A. HOLD CONNECTOR ASSEMBLY PLUGGING SIDE AWAY FROM HAND. HOLD CPA WITH EXTENSIONS TOWARD CONNECTOR.

B. SLIDE EXTENSIONS INTO SLOTS AND SNAP INTO PLACE USING FINGERS.
ASSEMBLY INSTRUCTIONS
16-WAY FEMALE GT MIXED 150/280
SEALED CONNECTOR ASSEMBLY

STEP 4:
SEAT PRIMARY LOCK REINFORCEMENT (PLR) FROM THE PRE-STAGE POSITION TO THE FINAL LOCK POSITION.

PLR PRE-STAGED POSITION

PLR FINAL LOCK POSITION

PUSH

COMPLETED STEP 4
16-WAY MALE GT MIXED 150/280 CONNECTOR ASSEMBLY CONSISTS OF THE FOLLOWING COMPONENTS:

**CONNECTOR BODY**

**PLR**

**COMPLETE ASSEMBLY**

**TERMINAL POSITION ASSURANCE (TPA)**

**NOTE 1:**
COMPONENTS SHOULD COME AS AN ASSEMBLY

**NOTE 2:**
THE USE OF THE TERMINAL POSITION ASSURANCE (TPA) IS OPTIONAL, BUT RECOMMENDED
ASSEMBLY INSTRUCTIONS
16-WAY MALE GT MIXED 150/280
SEALED CONNECTOR ASSEMBLY

NOTE 3: PLR MUST BE IN THE PRE-STAGE POSITION (NOT THE FINAL LOCKED POSITION) PRIOR TO PLUGGING LEADS (Refer to STEP 3)

STEP 1: PLUG LEADS TO CONNECTOR ASSEMBLY PER PRINT.

STEP 2: BUILD (1) ONE TERMINAL POSITION ASSURANCE (TPA) TO CONNECTOR ASSEMBLY.
A. POSITION TPA BETWEEN TOP AND BOTTOM ROWS OF LEADS, WITH THE LOCK TABS TOWARD THE CONNECTOR.
B. SLIDE TPA ONTO CONNECTOR AND SNAP BOTH LOCK TABS INTO PLACE USING FINGERS.

STEP 3: SEAT PRIMARY LOCK REINFORCEMENT (PLR) FROM THE PRE-STAGE POSITION TO THE FINAL LOCK POSITION.
ASSEMBLY INSTRUCTIONS
16-WAY MALE GT MIXED 150/280
SEALED CONNECTOR ASSEMBLY

NOTE 4: PLR MUST BE IN THE PRE-STAGE POSITION (NOT THE FINAL LOCKED POSITION) PRIOR TO PLUGGING LEADS (Refer to STEP 3)

STEP 1: PLUG LEADS TO CONNECTOR ASSEMBLY PER PRINT.

STEP 2: (OPTIONAL)
BUILD (1) ONE TERMINAL POSITION ASSURANCE (TPA) TO CONNECTOR ASSEMBLY.

A. POSITION TPA BETWEEN TOP AND BOTTOM ROWS OF LEADS, WITH THE LOCK TABS TOWARD THE CONNECTOR.

B. SLIDE TPA ONTO CONNECTOR AND SNAP BOTH LOCK TABS INTO PLACE USING FINGERS.

COMPLETED STEP 2
ASSEMBLY INSTRUCTIONS
16-WAY MALE GT MIXED 150/280
SEALED CONNECTOR ASSEMBLY

STEP 3: SEAT PRIMARY LOCK REINFORCEMENT (PLR) FROM THE PRE-STAGE POSITION TO THE FINAL LOCK POSITION.

COMPLETED
STEP 3
FINAL ASSEMBLY INSTRUCTIONS FOR
16-WAY FEMALE & MALE GT MIXED 150/280
SEALED CONNECTOR ASSEMBLY

MALE AND FEMALE CONNECTORS PRIOR TO MATING

COMPLETED FINAL ASSEMBLY
of the Mated Parts