



# ASSEMBLY, INSTALLATION, AND REMOVAL OF CONTACTS AND MODULES

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FOR PNEUMATIC CONTACTS AND MODULES

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*Please note that any printed or downloaded User Manuals may not reflect the most current revisions. The information contained in these materials is subject to change.  
For the most current information available, visit [vpc.com](http://vpc.com).*

## 3/8" RECEIVER CONTACT INSTALLATION AND REMOVAL

PART # 610 131 101 / 610 131 104

### TOOLS REQUIRED

3/4" Wrench

13/16" Wrench

### CONTACT INSTALLATION INSTRUCTIONS

*Note: This contact is for 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 3/4" wrench, replace nut and tighten to 8 in-lbs [0.90 N·m] using the 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 3/4" wrench, loosen and remove nut with 13/16" wrench.
4. Remove contact from module.

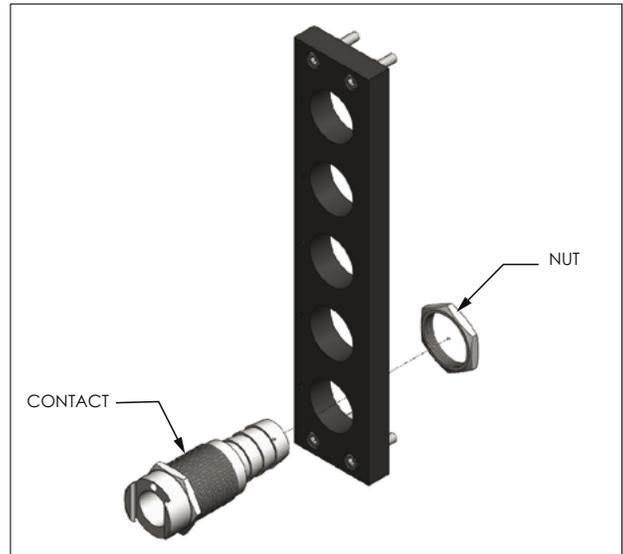


Figure A. Insert contact into module and tighten nut.

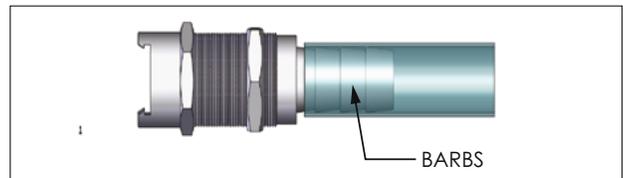


Figure B. Slide hose onto contact.

## 1/8" RECEIVER CONTACT INSTALLATION AND REMOVAL

PART # 610 132 105 / 610 131 107

### 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 # 610 131 106 in the remaining module.*



Figure A. Press contact into module.

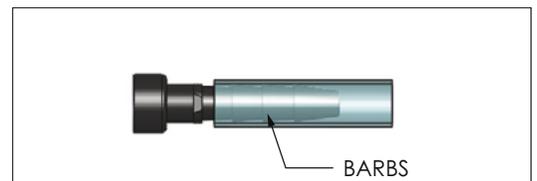


Figure B. Slide hose onto contact.

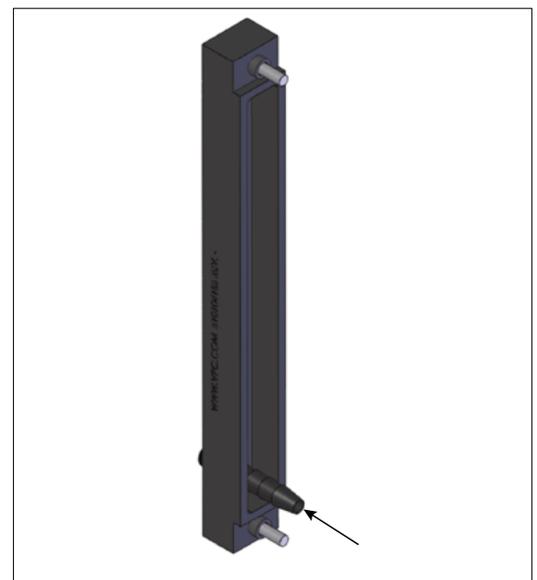


Figure C. Press contact out of module.

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

PART # 610 132 101 / 610 132 104

### 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.

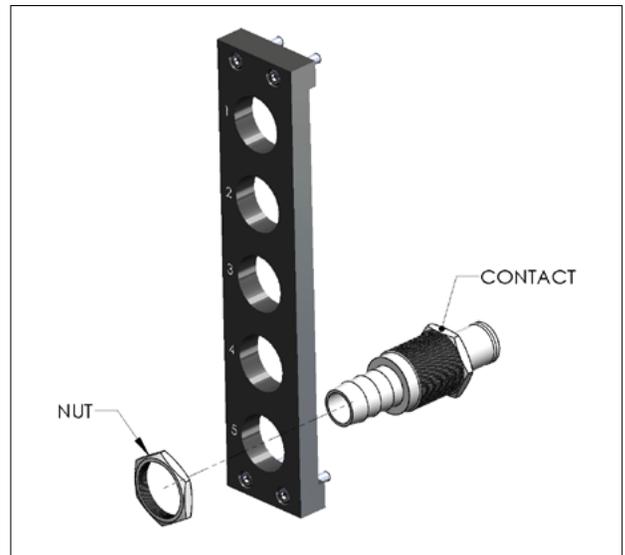


Figure A. Insert contact into module and tighten nut.

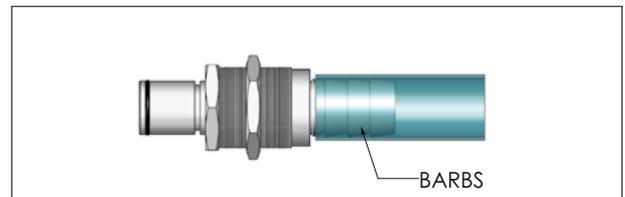


Figure B. Slide hose onto contact.

## 1/8" ITA CONTACT INSTALLATION AND REMOVAL

PART # 610 131 106

### 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.

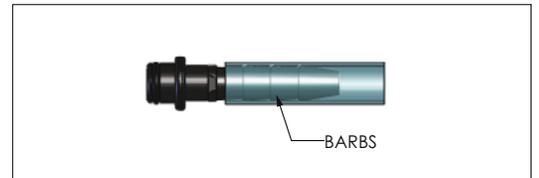


Figure B. Slide hose onto contact.



Figure C. Press contact out of module.

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## 90 SERIES MODULE INSTALLATION AND REMOVAL

PART # 510 104 185/ 510 108 160/ 510 108 264

510 104 160/ 510 104 276/ 510 108 144

### 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.*

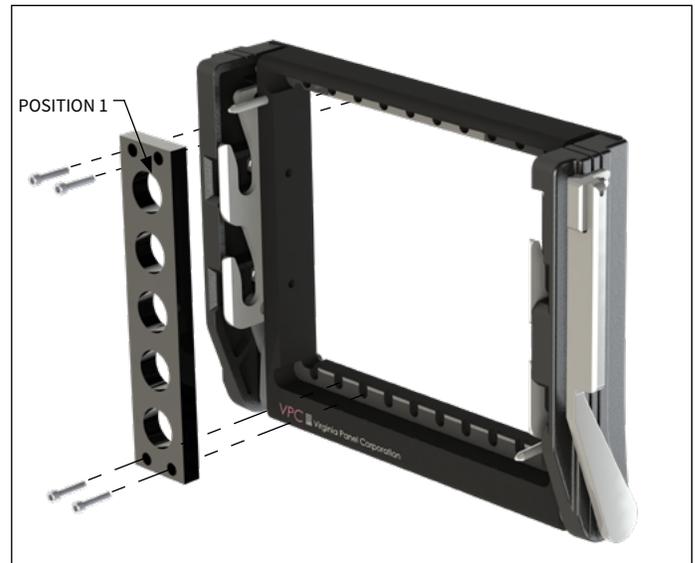


Figure A. Receiver Module.

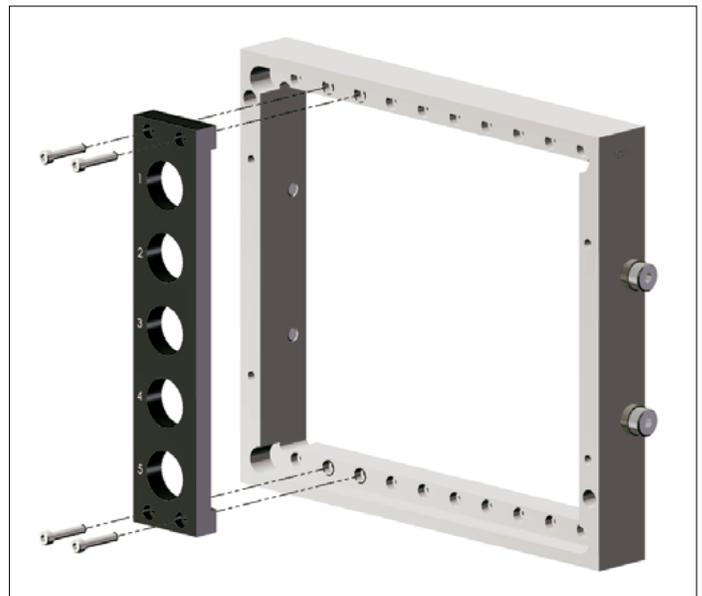
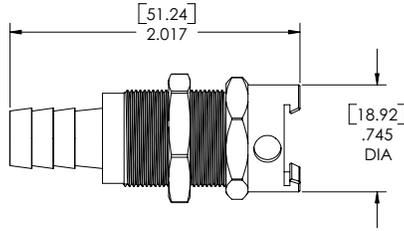
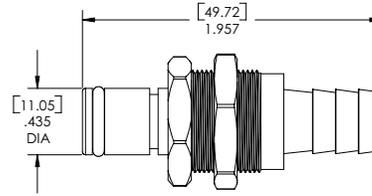


Figure B. ITA Module.

### 3/8" PERFORMANCE SPECIFICATIONS



**Receiver Contact**  
Part # 610 131 104



**ITA Contact**  
Part # 610 132 104

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]

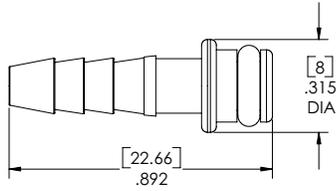
#### Mechanical Characteristics

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

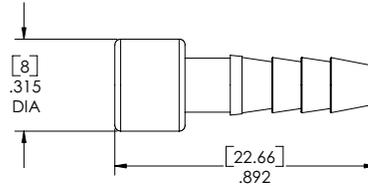
#### Material

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



**Receiver Contact**  
Part # 610 131 106



**ITA Contact**  
Part # 610 132 105

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		
	510 104 160	510 104 185	510 104 276
610 131 101	X		X
610 131 104	X		X
610 132 105		X	
610 131 107		X	

ITA CONTACTS	STANDARD/ 90 SERIES ITA MODULES		
	510 108 144	510 108 160	510 108 264
610 132 101	X		X
610 132 104	X		X