4 Way GT 280 Sealed Connection System
GT 2.8 Female Terminal System (Sealed)

February 2017
Assembly Manual
4 Way GT 280 Sealed Connection System
GT 2.8 Terminal System (Sealed)

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## REVISIONS

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ASSEMBLY OF THE FEMALE CONNECTOR

PRE-ASSEMBLY  HARNESS ASSEMBLY  CAR ASSEMBLY

4 Way GT 280 Sealed Connection System
## LIST OF COMPONENTS & EXPLODED VIEW

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<th>COMPONENTS</th>
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<tr>
<td>1</td>
<td>PLR</td>
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<tr>
<td>1</td>
<td>CONNECTOR SEAL</td>
</tr>
<tr>
<td>1</td>
<td>FEMALE CONNECTOR</td>
</tr>
<tr>
<td>1</td>
<td>CPA *</td>
</tr>
</tbody>
</table>

* OPTIONAL COMPONENT

---

Pictures used in this Assembly Manual and original parts may differ in some details. These differences have no influence on the assembly process.
STEP 1a – Insert Connector Seal

VERIFY THE ORIENTATION OF THE SEAL AND INSERT IT INTO THE CONNECTOR

STEP 1b – Insert Connector Seal

IMPORTANT! VERIFY THAT CONNECTOR SEAL IS NOT BUNCHE OR ROLLED DURING THE INSERTION

CONNECTOR SEAL ASSEMBLED
STEP 2a – Install PLR to Pre-Stage Position

IDENTIFY THE CORRECT ORIENTATION OF THE PLR

INSERT PLR ONTO THE CONNECTOR

STEP 2b – Install PLR to Pre-Stage Position

VERIFY AUDIBLE CLICK

VERIFY THAT THE LOCKS ON CONNECTOR ARE FASTENED ON THE PLR SLOTS

PLR IS NOW IN PRE-STAGE POSITION
STEP 3 – Assemble CPA to Pre-Stage Position (Optional Component)

IDENTIFY THE CORRECT ORIENTATION OF CPA AND PUSH IT ONTO THE CONNECTOR

VERIFY AUDIBLE CLICK

CPA IS NOW IN PRE-STAGE POSITION

FEMALE CONNECTOR ASSEMBLY – COMPLETED
ASSEMBLY OF THE FEMALE HARNESS ASSEMBLY

4 Way GT 280 Sealed Connection System
## LIST OF COMPONENTS & EXPLODED VIEW

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<td>FEMALE CONNECTOR ASSEMBLY</td>
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<td>4 MAX</td>
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<td>AS REQUIRED</td>
<td>CAVITY PLUG *</td>
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</tbody>
</table>

* OPTIONAL COMPONENT

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**FEMALE CONNECTOR ASSEMBLY**

**SEARED TERMINAL GT 2.8**

**CAVITY PLUG ***

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*Pictures used in this Assembly Manual and original parts may differ in some details, these differences have no influence on the assembly process.*
STEP 1 – Identify Cavities

CAVITY ID NUMBERS LOCATED AT THE BACK OF THE CONNECTOR

STEP 2a – Assemble Cavity Plug (If Required)

PUSH THE PLUG INTO ITS RESPECTIVE CAVITY UNTIL THE PLUG IS EVEN WITH THE EDGE OF THE CAVITY

PLUG CAN BE INSERTED WITH THE FINGERS OR WITH TOOL 10914973 IF NECESSARY
STEP 2b – Assemble Cavity Plug (If Required)

STEP 3 – Align Terminals Female GT 2.8 (Or Equivalent) and Female Assembly

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

INDEX FEATURES

TERMINAL FRONT VIEW

CAVITY PLUG INSTALLED
**STEP 4a – Insert Terminals Female GT 2.8 (Or Equivalent)**

1. **PUSH THE TERMINAL STRAIGHT INTO THE CAVITY**

2. **VERIFY AUDIBLE CLICK**

   - TERMINAL FULLY ENGAGED UNDER THE FLEX LOCK

**STEP 4b – Insert Terminals Female GT 2.8 (Or Equivalent)**

3. **GENTLY PULL ON THE CABLE TO VERIFY THE LOCK SYSTEM**

4. **USE THE SAME PROCESS TO INSERT THE REMAINING TERMINALS NEEDED**
ASSEMBLY

STEP 5a – Lock PLR to Full-Stage Position

PUSH THE PLR FORWARD

DO NOT FORCE THE PLR, IF IT CAN’T BE LOCKED REVISE IF TERMINALS ARE PROPERLY SEATED

STEP 5b – Lock PLR to Full-Stage Position

VERIFY AUDIBLE CLICK

VERIFY THAT THE LOCK ON CONNECTOR IS FASTENED ON THE PLR SLOT

PLR IS NOW IN FULL-STAGE POSITION
PERFORM TESTS. APPLY COVERINGS AS REQUIRED. INSPECT THE ASSEMBLY.
ASSEMBLY OF THE
CONNECTION SYSTEM

4 Way GT 280 Sealed Connection System

FEMALE ASSEMBLY

MATING PART

PRE-ASSEMBLY  HARNESS ASSEMBLY  CAR ASSEMBLY
## LIST OF COMPONENTS & EXPLODED VIEW

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<tr>
<td>1</td>
<td>FEMALE ASSEMBLY</td>
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Pictures used in this Assembly Manual and original parts may differ in some details. These differences have no influence on the assembly process.
STEP 1 – Identify Index Features

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

STEP 2a – Align Index Features and Mate Female Assembly and Mating Part Together
**ASSEMBLY**

**STEP 2b – Align Index Features and Mate Female Assembly and Mating Part Together**

VERIFY

AUDIBLE CLICK

**STEP 3a – Lock CPA to Full-Stage Position (Optional Component)**

SLIDE THE CPA FORWARD, AS SHOWN BELOW, TO SECURE THE ASSEMBLY
STEP 3b – Lock CPA to Full-Stage Position (Optional Component)

VERIFY AUDIBLE CLICK

CPA IS FLUSH WITH THE CONNECTOR LOCK

CPA IS NOW IN FULL-STAGE POSITION

CONNECTION SYSTEM – COMPLETED
DISASSEMBLY OF THE CONNECTION SYSTEM

4 Way GT 280 Sealed Connection System

MATING PART

FEMALE ASSEMBLY

PRE - ASSEMBLY
HARNESS ASSEMBLY
CAR ASSEMBLY
**Disassembly**

**STEP 1a – Move CPA to Pre-Stage Position (Optional Component)**

**SLIDE THE CPA BACK TO PLACE IT IN PRE-STAGE**

**STEP 1b – Move CPA to Pre-Stage Position (Optional Component)**

**VERIFY AUDIBLE CLICK**

**CPA IS NOW IN PRE-STAGE POSITION**

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DISASSEMBLY

STEP 2 – Disconnect

LOCATE AND PRESS DOWN THE CONNECTOR LOCK (1); WITH THE LOCK DEFLECTED, DISENGAGE THE CONNECTORS (2)

CONNECTION SYSTEM – COMPLETED DISASSEMBLY
REPAIR / REPLACEMENT OF THE FEMALE ASSEMBLY

4 Way GT 280 Sealed Connection System
PLR REPLACEMENT (Remove PLR) – STEP 1a

PLACE TOOL 12122647 BETWEEN THE PLR AND CONNECTOR

ROTATE THE TOOL AND PULL THE PLR UNTIL IT’S PLACED IN PRE-STAGE POSITION

PLR REPLACEMENT (Remove PLR) – STEP 1b

USE THE SAME PROCEDURE TO REMOVE THE PLR COMPLETELY

PLR RELEASED
PLR REPLACEMENT (Install PLR) – STEP 2

REFER TO PRE-ASSEMBLY SECTION

FEMALE TERMINAL GT 2.8 REPLACEMENT (Remove Terminal) – STEP 1a

PLR MUST BE RELEASED BEFORE TERMINAL REMOVAL

TERMINAL

FLEX LOCK
**FEMALE TERMINAL GT 2.8 REPLACEMENT (Remove Terminal) – STEP 1b**

**REPLACE TERMINALS**

Identify
Terminal Flex Lock

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

---

**FEMALE TERMINAL GT 2.8 REPLACEMENT (Remove Terminal) – STEP 1c**

**REPLACE TERMINALS**

Locate Flex Lock at the front of the cavity. Insert (Operation 1) tool 15315247 (with the angular side facing the lock) or tool 12094429 between Flex Lock and Terminal, deflect the Flex Lock to unseat the Terminal and gently pull on the cable to remove (Operation 2) the Female Terminal from the receptacle.

* This graph just represents how this kind of terminals are removed.
FEMALE TERMINAL GT 2.8 REPLACEMENT (Insert Terminal) – STEP 2

REFER TO HARNESS ASSEMBLY SECTION
## RECOMMENDED REPAIR TOOLS

<table>
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<th>DELPHI PART NUMBER</th>
<th>J-38125-H NUMBER</th>
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<td>10914973</td>
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<tr>
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<td>12094429</td>
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* Alternative Tool for Item 3
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