

PART NUMBER	REV	DESCRIPTION
2305479-1	C	HV DIE SET
7-2305479-7	C	CRIMP TOOLING KIT
9-2305479-1	C	DIE SET WITH DIE HOLDER

REVISIONS					
P	LTR	DESCRIPTION	DATE	DWN	APVD
	A	RELEASED	22APR2019	CAK	CAM
	B	ECR-21-003196	12MAR2021	AJ	YY
	B1	REVISED PER ECR-22-151280	01SEP2022	GK	TE
	C	ECR-23-174496	06MAY2023	KH	YY

TERMINAL NAME	HV 8mm DRAWN SOCKET 90DEG	
TE TERMINAL PART NUMBER(S)	2141211-2 1-2141211-2	
APPLICATION SPECIFICATION	114-94083	
REFERENCE DRAWING	-	
USED ON	2305470-1	2326378-1
INSTRUCTION SHEET	408-35069	

CABLE SUPPLIER/ SPECIFICATION	CABLE SIZE	CRIMP HEIGHT	CRIMP HEIGHT REFERENCE SETTING
COROPLAST /FHLR2GCB2G	25mm ²	7.15±0.15	F1
LEONI /FHLR2GCB2G	25mm ²	7.15±0.15	F1
LEONI /ISO 6722 CLASS C	25mm ²	7.15±0.15	F1
COROPLAST /FHLR2GCB2G	35mm ²	7.70±0.15	E0
LEONI /FHLR2GCB2G	35mm ²	7.70±0.15	E0
COROPLAST /FHLR2GCB2G	50mm ²	8.50±0.15	C1

CABLE SUPPLIER/ SPECIFICATION	CABLE SIZE	CRIMP HEIGHT OPTI 5	CRIMP HEIGHT REFERENCE SETTING
COROPLAST /FHLR2GCB2G	25mm ²	6.80±0.10	G1
LEONI /FHLR2GCB2G	25mm ²	6.80±0.10	G1
LEONI /ISO 6722 CLASS C	25mm ²	6.80±0.10	G1
COROPLAST /FHLR2GCB2G	35mm ²	7.30±0.15	F
LEONI /FHLR2GCB2G	35mm ²	7.30±0.15	F
COROPLAST /9FHLR2GCB2G	50mm ²	8.10±0.15	D2

1	-	-	-	2305470-1	HV DIE HOLDER WITH FINE ADJUST	100
1	-	1	-	18023-5	SCR, SKT HD CAP M3 X 12.0	16
1	-	1	-	1-22278-0	SPRING, COMPRESSION	15
1	-	1	-	18032-3	SCR, SET, FLT PNT, M4 X 10.0	14
1	-	1	-	6-993111-7	PIN, SLOTTED SPRING 3.0 X 16.0	13
1	-	1	-	2-18023-1	SCR, SKT HD CAP M5 X 20.0	12
1	-	1	-	6-22282-3	SPRING, COMPRESSION	11
2	-	2	-	7-18023-6	SCR, SKT HD CAP M3 X 25.0	10
2	-	2	-	1-18023-2	SCR, SKT HD CAP M4 X 12.0	9
1	-	1	-	2385645-1	WIRE STOP	8
1	-	1	-	2375517-2	WIRE STOP MOUNT	7
1	-	1	-	2305471-1	HOLD DOWN, HV TERMINAL	6
1	-	1	-	2305821-3	PIN, EXTRUSION -	5
1	-	1	-	2305469-1	RETAINER, SPRING	4
1	-	1	-	2305468-1	LOCATOR, HV TERMINAL	3
1	1	1	-	3-2305824-4	CRIMPER HVM F	2
1	1	1	-	2305823-7	ANVIL HVM F	1
-91	-77	-1	U/M	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT.			DWN C. KERSTETTER 09AUG2017	TE Connectivity		
DIMENSIONS:			CHK R. DOBSON 09AUG2017			
MM		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME R. SCHAEFFER 09AUG2017		
		0 PLC ±		PRODUCT SPEC		
		1 PLC ±		APPLICATION SPEC		
		2 PLC ±		SIZE		
		3 PLC ±		CAGE CODE		
		4 PLC ±		DRAWING NO		
		ANGLES		RESTRICTED TO		
		FINISH		A100779C=2305479		
		MATERIAL		WEIGHT		
Customer Accessible Production Drawing			SCALE	1:1	SHEET	1 OF 1
			REV	C		

D

C

B

A

- 1
- APPLY "DIE SET PN" PER TEC-115-67-2 IN APPROXIMATE AREA SHOWN.
- 2
- IDENTIFY PART NUMBER AND REVISION LETTER PER TEC-115-67-2 IN APPROXIMATE AREA SHOWN.
- 3
- IDENTIFY SERIAL NUMBER PER TEC-115-67-2 IN APPROXIMATE AREA SHOWN.
- 4
- TORQUE RECOMMENDATIONS PER 101-35000 UNLESS OTHERWISE SPECIFIED.
- 5
- OPTIMIZED CRIMP HEIGHT NEEDED TO MEET THE SLOW MOTION BENDING TEST REQUIREMENTS.