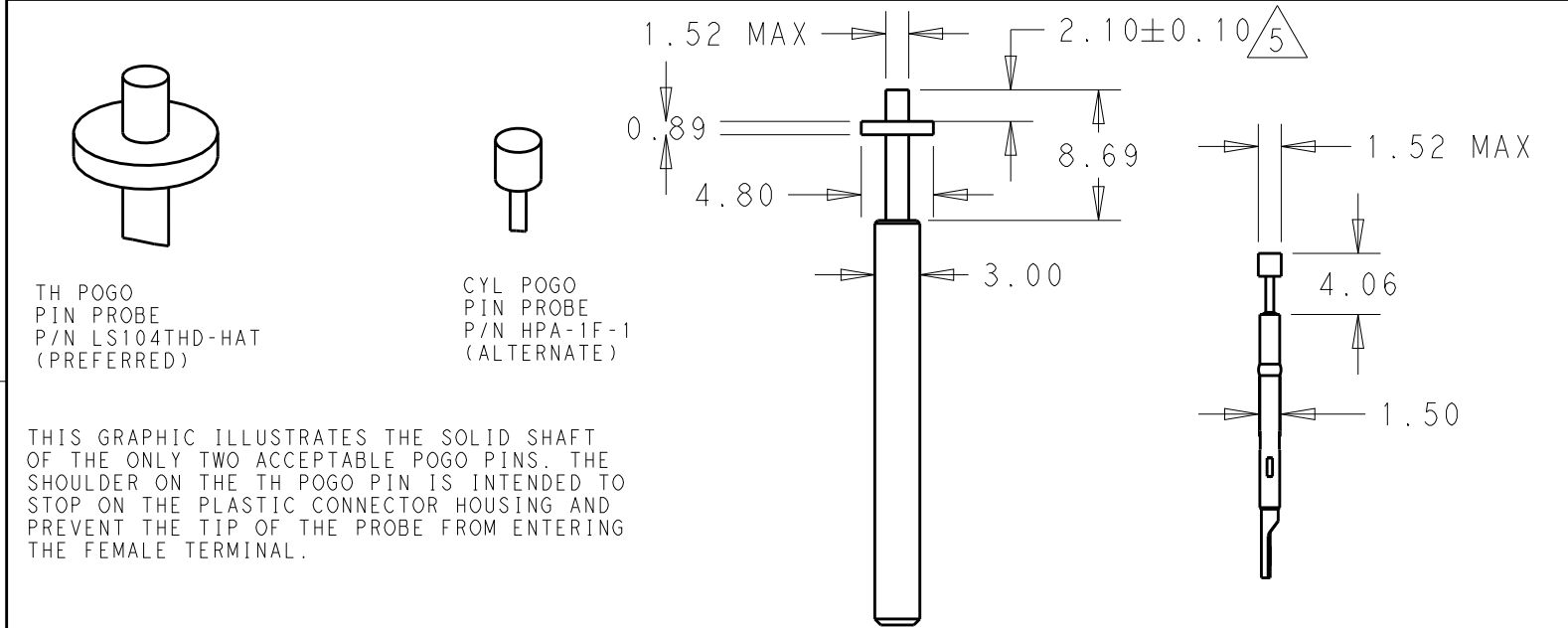


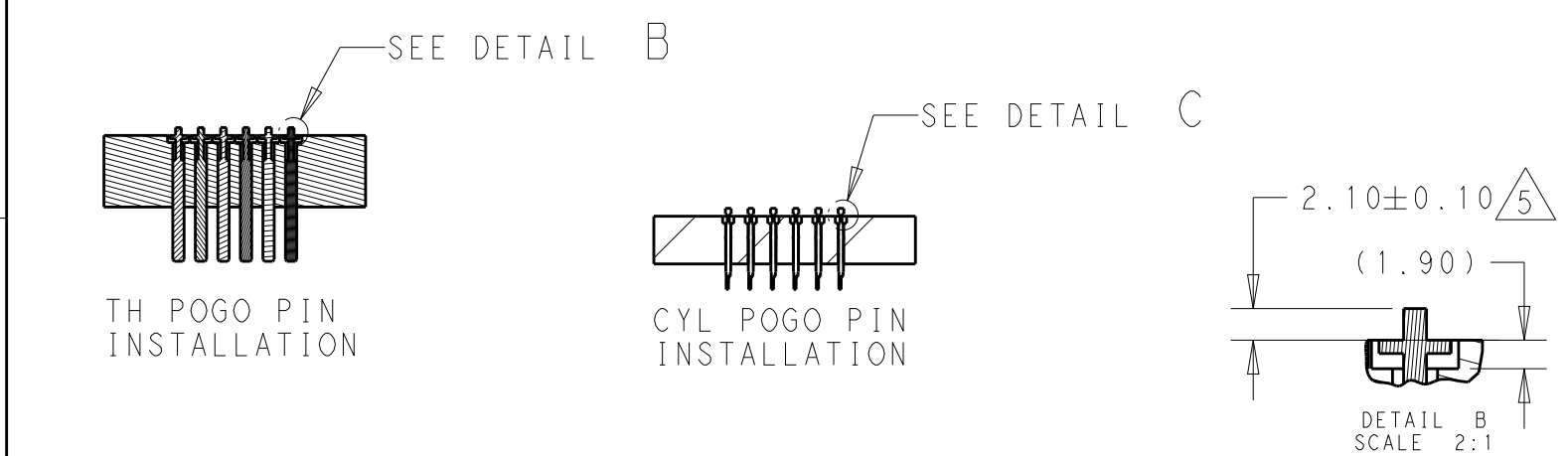


TH POGO
PIN PROBE
P/N LS104THD-HAT
(PREFERRED)

CYL POGO
PIN PROBE
P/N HPA-1F-1
(ALTERNATE)

TH POGO PIN
AND RECEPTACLE
P/N LS104THD-HAT
(PREFERRED)

CYL POGO PIN
AND RECEPT.
P/N HPA-1F-1
(ALTERNATE)



TH POGO PIN
INSTALLATION

CYL POGO PIN
INSTALLATION

NOTES:

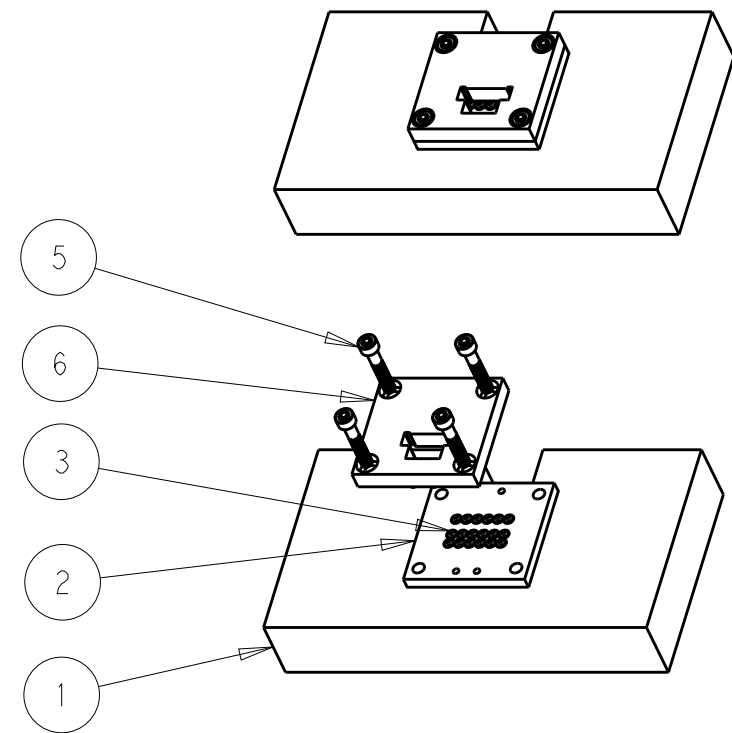
1. THIS DRAWING IS TO BE USED IN CONJUNCTION WITH #408-32184. ALTERATIONS TO THE BASE, PLATES, AND HOLDERS CAN BE MADE AS NEEDED.

2. MINIMUM POGO PIN NORMAL FORCE OF 0.20 NEWTONS AT CONTACT.

3. DO NOT USE POGO PINS TO PROBE INSIDE THE RECEPTACLE TERMINAL. PTL FIXTURE IS DESIGNED TO PROBE ON THE EDGE OF THE TERMINAL FACE ONLY.

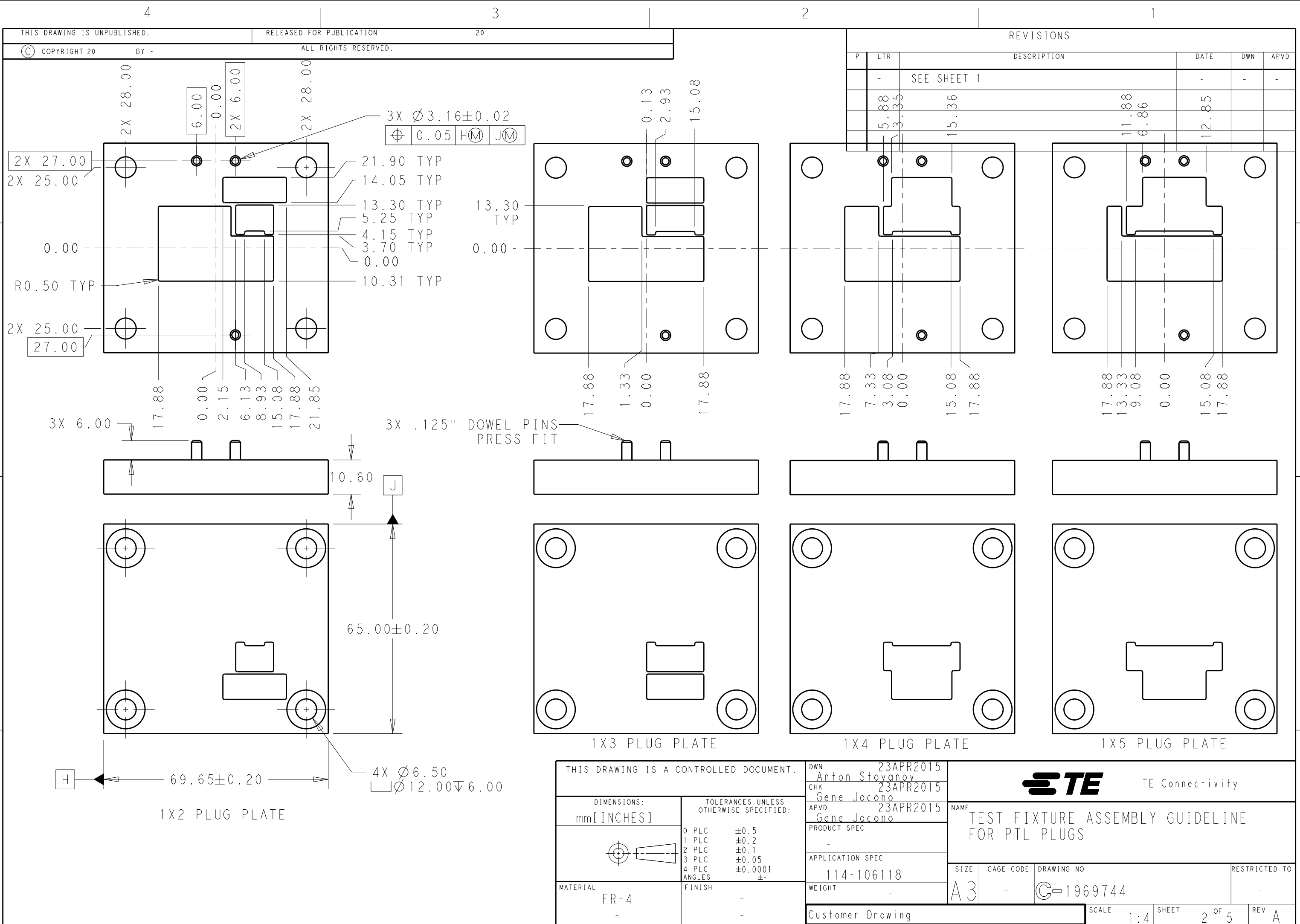
- 4 PREFERRED CONFIGURATION.
- 5 CRITICAL DIMENSION. DO NOT DEVIATE.
6. BREAK ALL SHARP CORNERS AND EDGES.

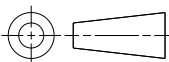
REVISIONS				
P	LTR	DESCRIPTION	DATE	APVD



NO.	QTY.	NAME	P/N	SUPPLIER
1	1	1	BASE	-
2	1	-	PIN ARRAY HOLDER (CYL)	-
	-	1	PIN ARRAY HOLDER (TH)	-
3	18	-	CYL POGO PIN	HPA-1F-1
	-	18	TH POGO PIN	LS104THD-HAT XXX
4	18	-	CYL POGO PIN RECEPTACLE	SPR-1W-1
	-	18	TH POGO PIN RCPT.	LS118THDRCP
5	4	4	M6X35 CAP SCREW	91290A334
6	1 / ASSY	1 / ASSY	MODULAR PLUG PLATE	-
-	1	-	CYL RCPT. INSTALL TOOL	ARIT-1
-	-	1	TH RCPT. INSTALL TOOL	LS104THD-WRCH
PTL CYL FIXTURE ASSY		PTL TH FIXTURE ASSY	4	

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN 23APR2015 Anton Stoyanov		
DIMENSIONS: mm[INCHES]		CHK 23APR2015 Gene Jacono		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD 23APR2015 Gene Jacono	NAME TEST FIXTURE ASSEMBLY GUIDELINE FOR PTL PLUGS	
0 PLC ±0.5 1 PLC ±0.2 2 PLC ±0.1 3 PLC ±0.05 4 PLC ±0.0001 ANGLES ±		PRODUCT SPEC -	SIZE A3	
MATERIAL -		APPLICATION SPEC 114-106118	CAGE CODE -	
FINISH -		WEIGHT -	DRAWING NO C-1969744	
Customer Drawing		SCALE 1:4	SHEET 1 OF 5	
			RESTRICTED TO -	
			REV A	



THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN 23APR2015 Anton Stoyanov		TE Connectivity			
		CHK 23APR2015 Gene Jacono					
DIMENSIONS: mm[INCHES]		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME TEST FIXTURE ASSEMBLY GUIDELINE FOR PTL PLUGS			
		APVD 23APR2015 Gene Jacono					
		PRODUCT SPEC -		SIZE A3			
APPLICATION SPEC 114-106118		CAGE CODE -					
MATERIAL FR-4						WEIGHT -	
FINISH -		Customer Drawing		RESTRICTED TO -			
				SHEET 2 OF 5			

4

3

2

1

THIS DRAWING IS UNPUBLISHED.

RELEASED FOR PUBLICATION

20

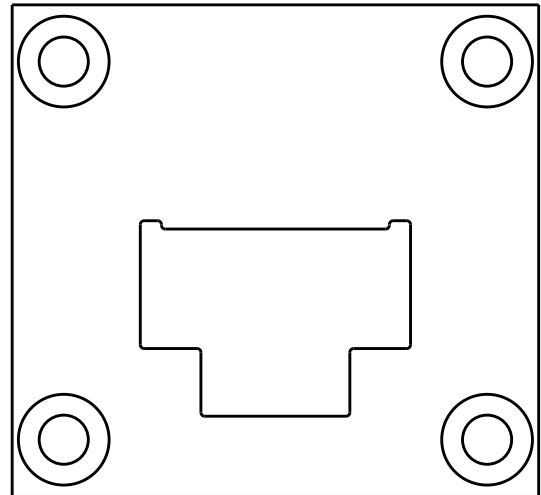
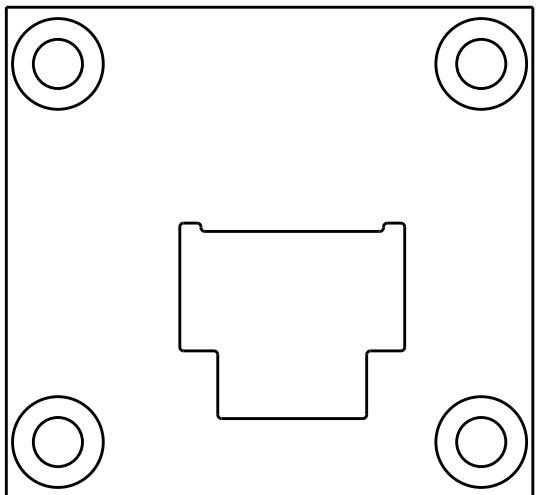
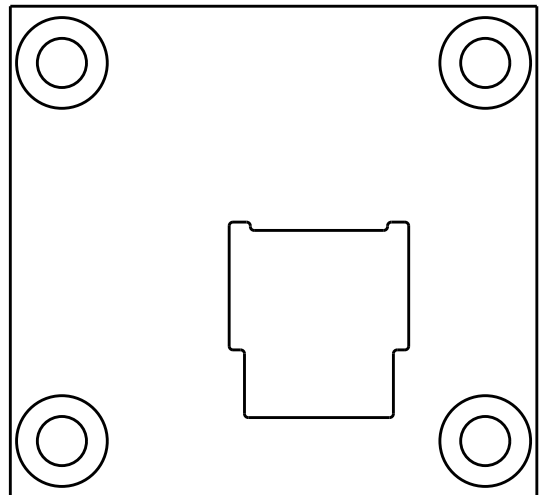
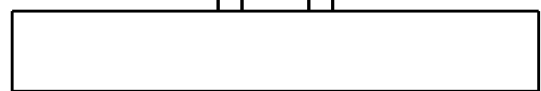
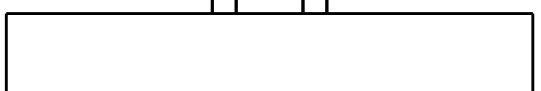
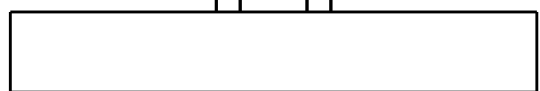
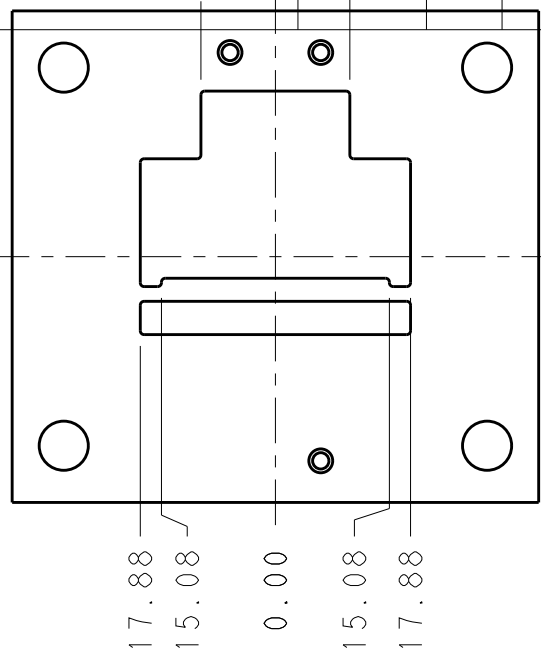
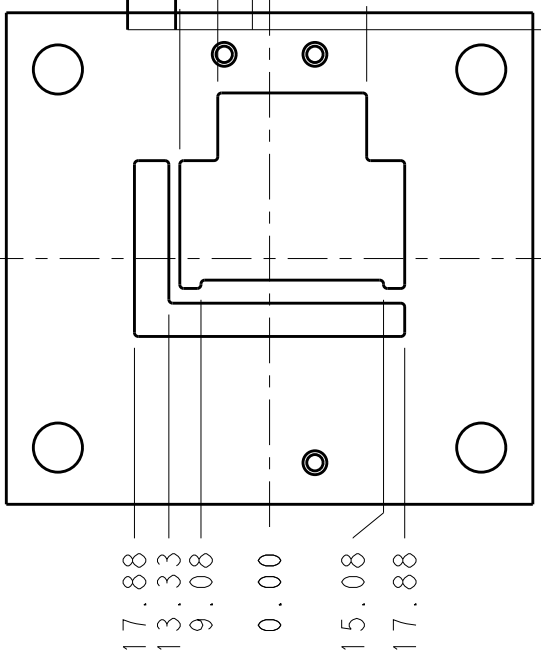
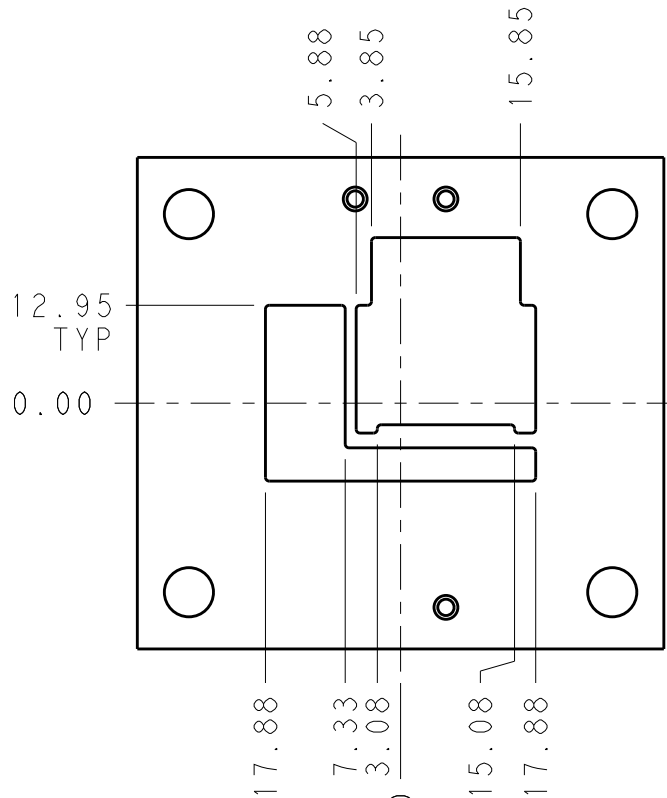
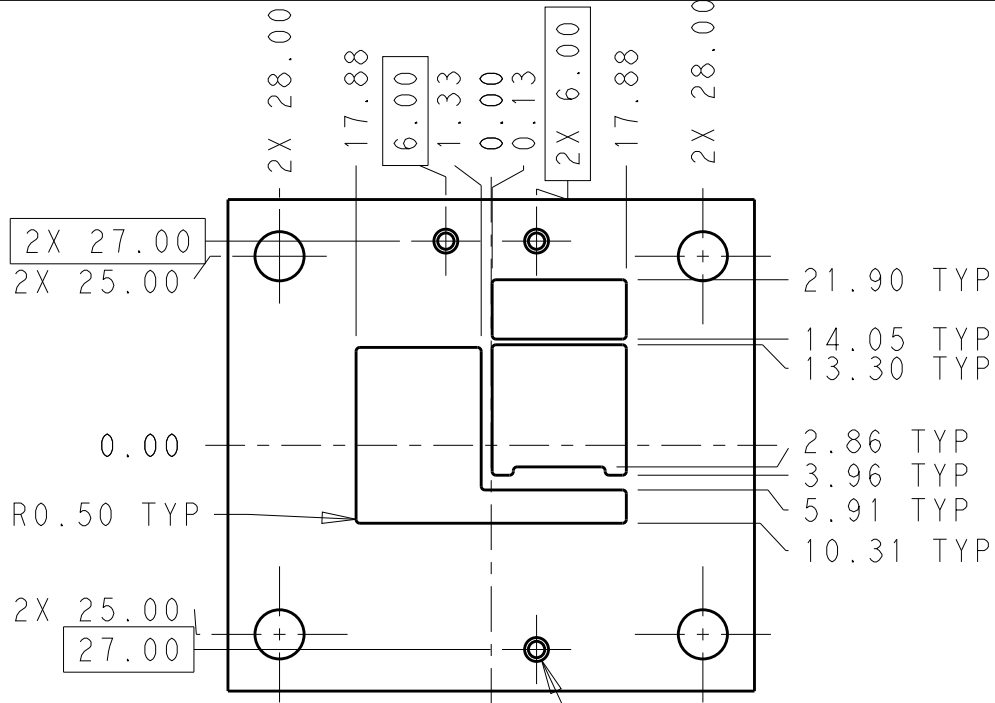
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REVISIONS

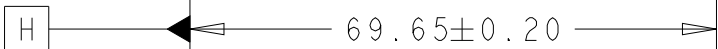
P	LTR	DESCRIPTION	DATE	DWN	APVD
-	-	SEE SHEET 1	-	-	-
1	6.86	12.85	9.85	-	-
2	9.86	9.86	-	-	-



2X4 PLUG PLATE

2X5 PLUG PLATE

2X6 PLUG PLATE



2X3 PLUG PLATE

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: mm[INCHES]	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.2 2 PLC ±0.1 3 PLC ±0.05 4 PLC ±0.0001 ANGLES ±
MATERIAL FR-4	FINISH -

DWN Anton Stoyanov 23APR2015	CHK Gene Jacono 23APR2015	APVD Gene Jacono 23APR2015
PRODUCT SPEC -		
APPLICATION SPEC 114-106118		
WEIGHT -		
Customer Drawing		

TE TE Connectivity

NAME
TEST FIXTURE ASSEMBLY GUIDELINE FOR PTL PLUGS

SIZE A3	CAGE CODE -	DRAWING NO C-1969744	RESTRICTED TO -
SCALE 1:4			SHEET 3 OF 5
REV A			

