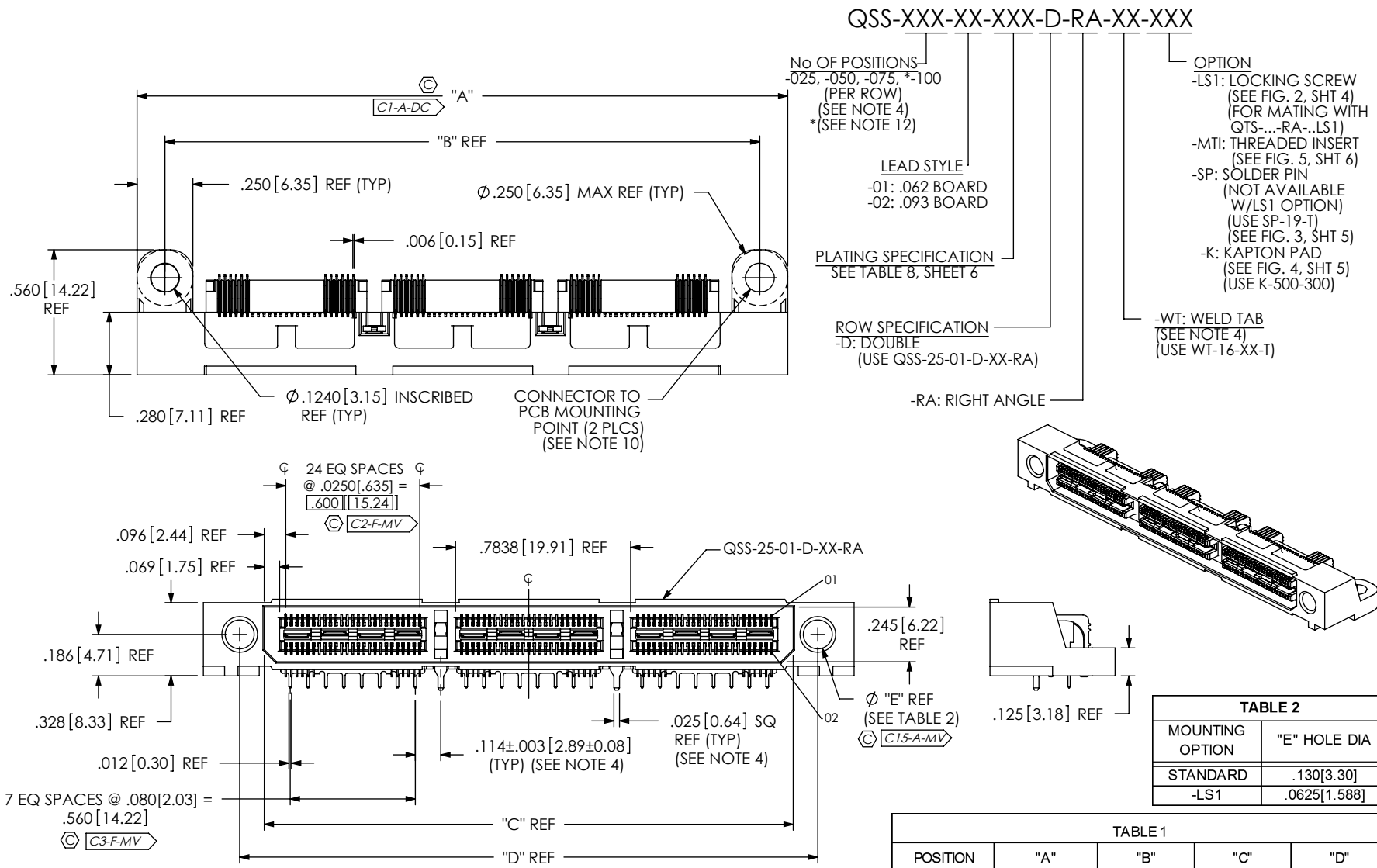


DO NOT
SCALE FROM
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NOTES:

1. **CX-XX** REPRESENTS A CRITICAL DIMENSION.
2. BURR ALLOWANCE: .0010 MAX.
3. MINIMUM PUSHOUT FORCE: 6 OZ.
4. WELD TABS (WT-16-XX-T) NOT AVAILABLE ON -025 POSITION. WT OPTION MUST BE SELECTED FOR -050, -075 & -100 POSITIONS.
5. IF NEEDED, -L PLATING CAN BE SUBSTITUTED FOR -F PLATING.
6. IM-1G18-XX-1-XX RETENTION TO BE 1.0 LBS. MINIMUM PRIOR TO SECOND ROW FILL.
7. DESIGNED FOR USE WITH A .062 OR .093 THICK PCB
8. ASSEMBLIES TO BE PACKAGED IN TRAYS.
9. NOTE DELETED
10. TORQUE TO BE 10.0 IN-OZ USING 4-40 UNC SCREW.
11. USE -Z- DATUM ZONE ONLY FOR MEASUREMENTS.
12. AVAILABLE FOR EXISTING CUSTOMERS ONLY.

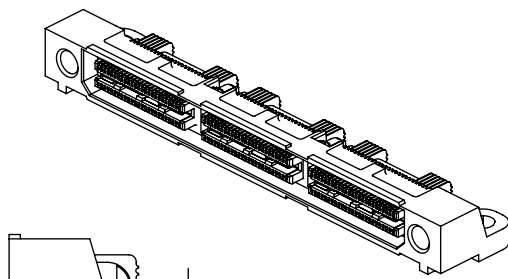


TABLE 2	
MOUNTING OPTION	"E" HOLE DIA
STANDARD	.130[3.30]
-LS1	.0625[1.588]

TABLE 1				
POSITION	"A"	"B"	"C"	"D"
-025	1.338 [33.97]	1.088 [27.62]	0.793 [20.13]	1.013 [25.72]
-050	2.125 [53.98]	1.875 [47.63]	1.580 [40.13]	1.800 [45.72]
-075	2.913 [73.98]	2.663 [67.63]	2.368 [60.13]	2.588 [65.72]
*-100	3.700 [93.98]	3.450 [87.63]	3.155 [80.14]	3.375 [85.73]

* = SEE NOTE 12

CPC FREQUENCY THIS SHEET	A	C1, C15	UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE: DECIMALS ANGLES .XX: ±.01 [.3] 2° .XXX: ±.005 [.13] .XXXX: ±.0020 [.051] MATERIAL: DO NOT SCALE DRAWING INSULATOR: LCP, COLOR: BLACK TERMINAL, GROUND PLANE & WELD TAB: PHOS BRONZE F:\DWG\MISC\MKTG\QSS-XXX-XX-XXX-D-RA-XX-XXX-MKT.SLDDRW	PROPRIETARY NOTE THIS DOCUMENT CONTAINS INFORMATION CONFIDENTIAL AND PROPRIETARY TO SAMTEC, INC. AND SHALL NOT BE REPRODUCED OR TRANSFERRED TO OTHER DOCUMENTS OR DISCLOSED TO OTHERS OR USED FOR ANY PURPOSE OTHER THAN THAT WHICH IT WAS OBTAINED WITHOUT THE EXPRESSED WRITTEN CONSENT OF SAMTEC, INC.	 520 PARK EAST BLVD, NEW ALBANY, IN 47150 PHONE: 812-944-6733 FAX: 812-948-5047 e-Mail: info@SAMTEC.com code 55322	
B						
C						
D						
SHEET SCALE: 1.5:1						
DESCRIPTION: .635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP						
DWG. NO. QSS-XXX-XX-XXX-D-RA-XX-XXX						
BY: KEVIN B 01/22/02 SHEET 1 OF 6						

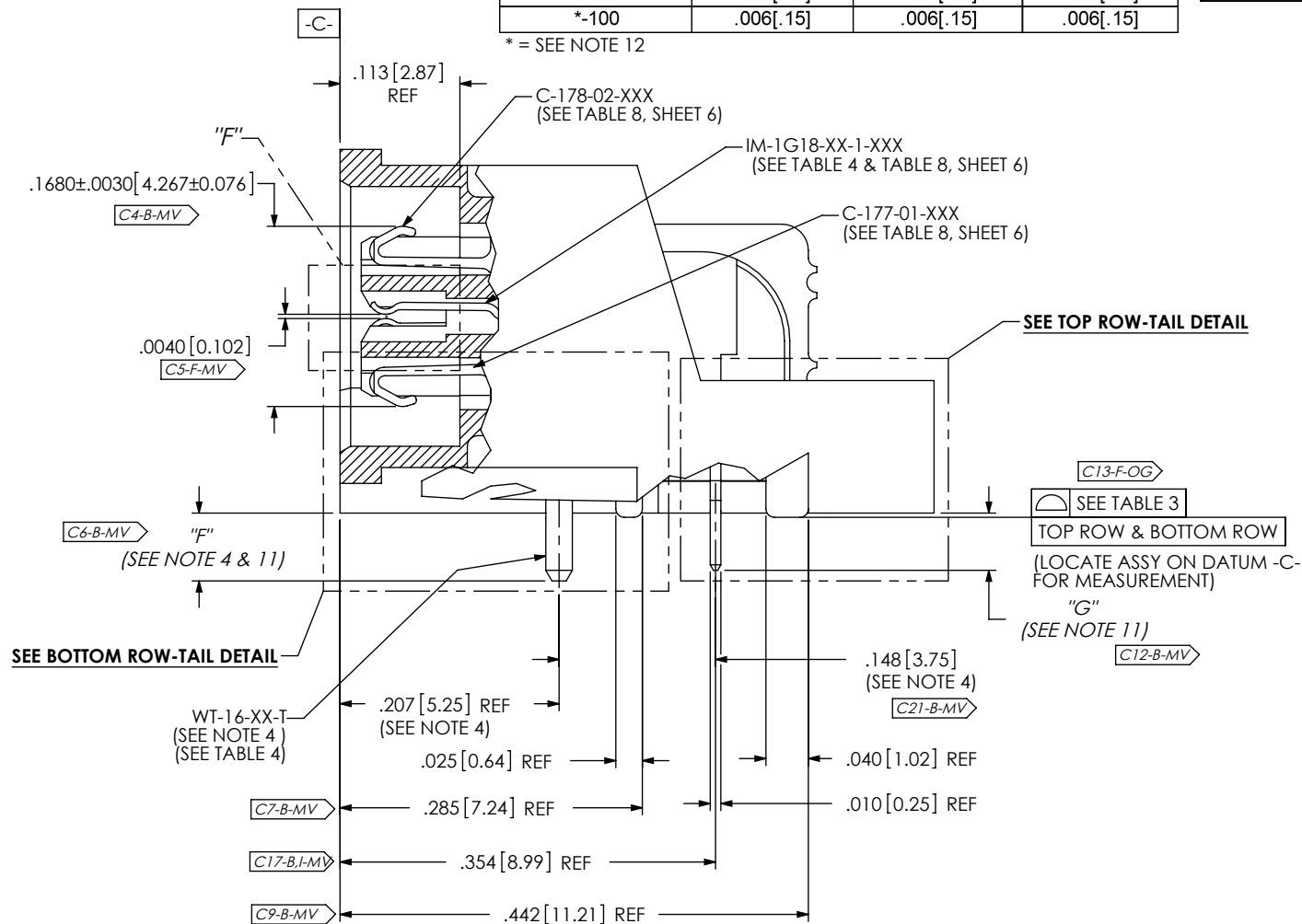
TABLE 3

No OF POSITIONS	COPLANARITY	STRAIGHTNESS ROW 1	STRAIGHTNESS ROW 2
-025 THRU -075	.004[.10]	.004[.10]	.004[.10]
*-100	.006[.15]	.006[.15]	.006[.15]

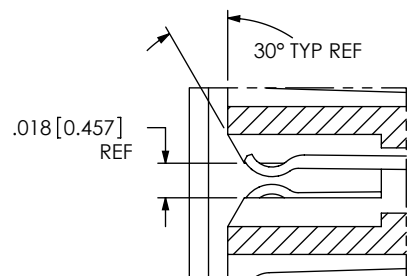
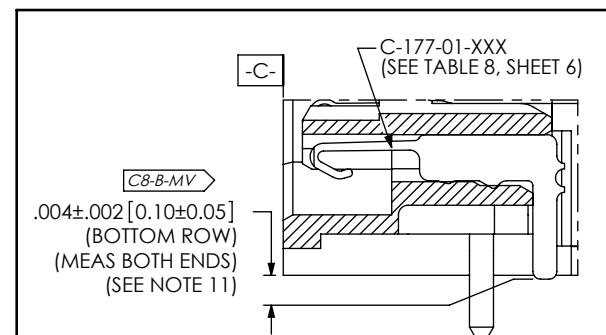
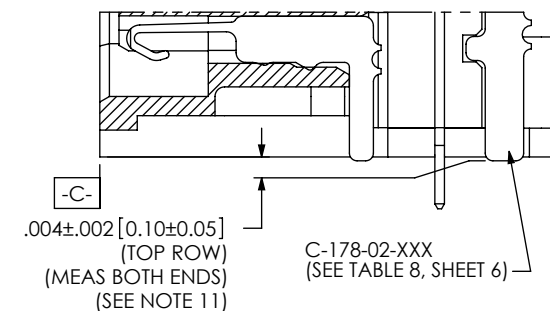
* = SEE NOTE 12

TABLE 4

LEADSTYLE	"F"	"G"	IM-1G18-XX-1-XXX	WT-16-XX-T
-01	0.064 [1.63]	0.058 [1.47]	IM-1G18-01-1-XXX	WT-16-02-T
-02	0.125 [3.18]	0.125 [3.18]	IM-1G18-02-1-XXX	WT-16-04-T



SEE BOTTOM ROW-TAIL DETAIL


 DETAIL "F"
 SCALE 10:1

 BOTTOM ROW - TAIL DETAIL
 (LOCATE ASSEMBLY ON
 DATUM -C- FOR MEASUREMENT)

 TOP ROW - TAIL DETAIL
 (LOCATE ASSEMBLY ON
 DATUM -C- FOR MEASUREMENT)

CPC FREQUENCY THIS SHEET	
A	
B	C4, C6, C7, C8, C9, C11, C12, C17, C21
C	
D	

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SHEET SCALE: 6:1

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 e-Mail: info@SAMTEC.com code 55322

DESCRIPTION:

.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

DWG. NO.

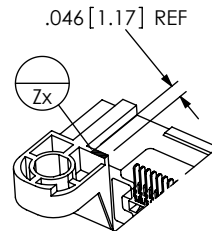
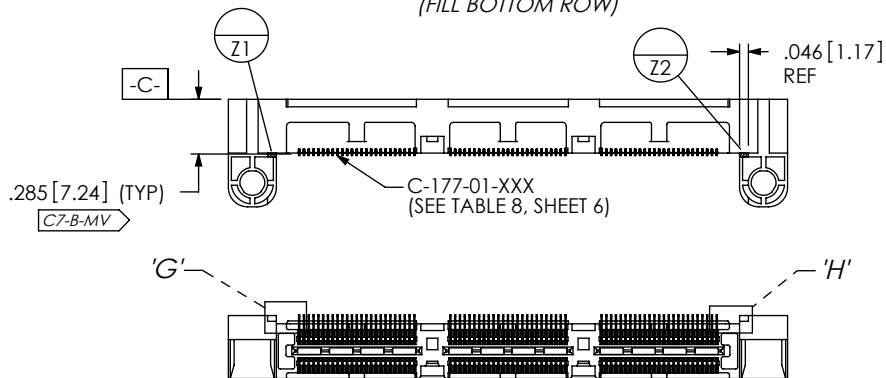
QSS-XXX-XX-XXX-D-RA-XX-XXX

BY: KEVIN B

01/22/02

SHEET 2 OF 6

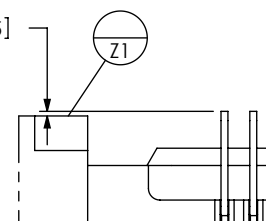
INSPECTION VIEW 1
(FILL BOTTOM ROW)



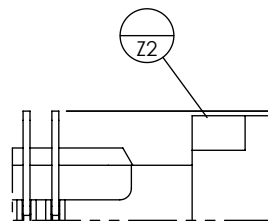
**ISO VIEW OF
-Z- DATUM ZONE**

.004±.002 [0.10±0.05]
(BOTTOM ROW)
(SEE NOTE 11)

C8-B-MV



DETAIL 'G'
SCALE 6:1



DETAIL 'H'
SCALE 6:1

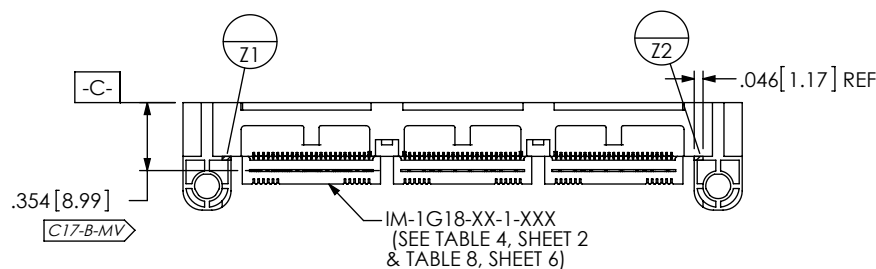
SEE TABLE 3, SHT 2
WITHIN ROW

C10-B,I-MV

.004±.002 [0.10±0.05]
(BOTTOM ROW)
(SEE NOTE 11)

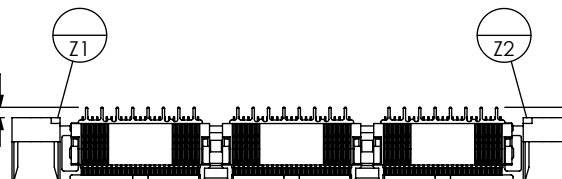
C8-B-MV

INSPECTION VIEW 2
(FILL IM-TG18)



"G"
(SEE TABLE 4, SHEET 2)
(SEE NOTE 11)

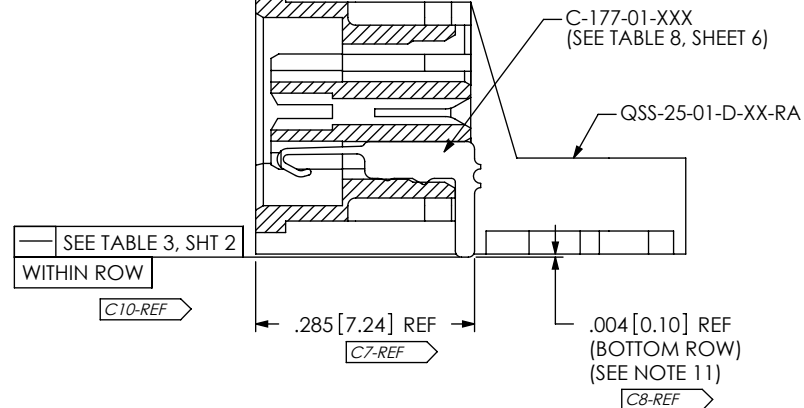
C12-B-MV



"G"
(SEE TABLE 4, SHEET 2)
(SEE NOTE 11)

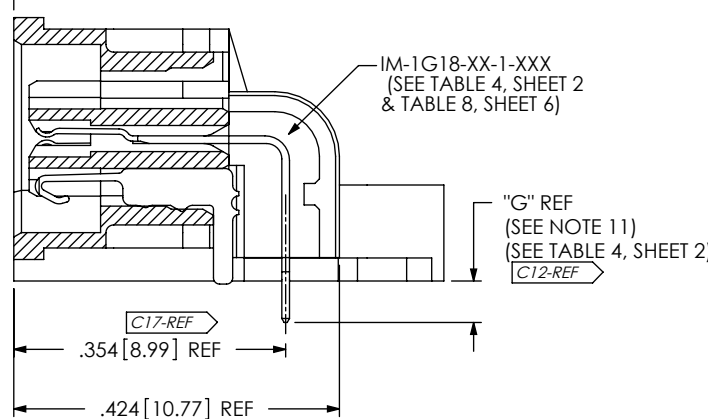
C12-B-MV

-C-



IN-PROCESS 1
(FILL BOTTOM ROW)
(SEE INSPECTION VIEW 1 FOR ORIENTATION AND CPC'S)

-C-



IN-PROCESS 2
(FILL IM-TG18)
(SEE INSPECTION VIEW 2 FOR ORIENTATION AND CPC'S)

CPC FREQUENCY THIS SHEET	
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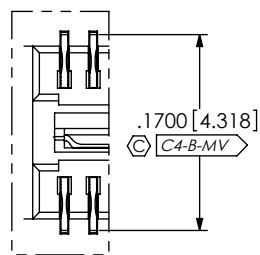
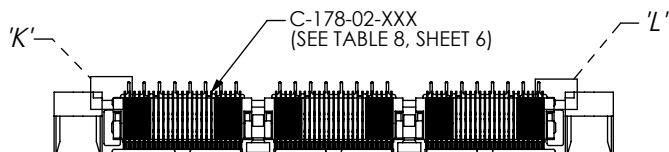
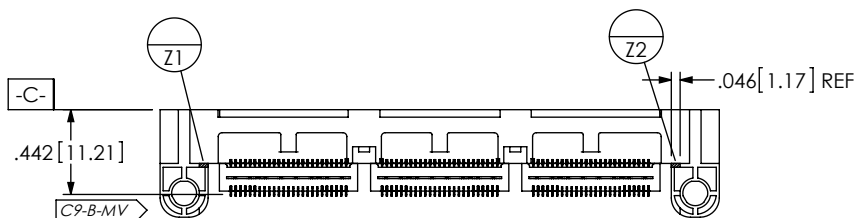
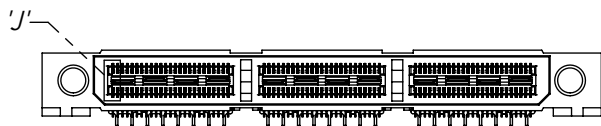
SHEET SCALE: 1.5:1

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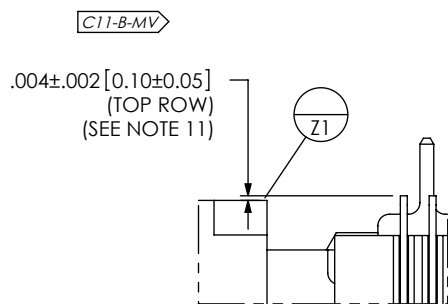
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e-Mail: info@SAMTEC.com code 55322

DESCRIPTION:
.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP
DWG. NO.
QSS-XXX-XX-XXX-D-RA-XX-XXX
BY: KEVIN B 01/22/02 SHEET 3 OF 6

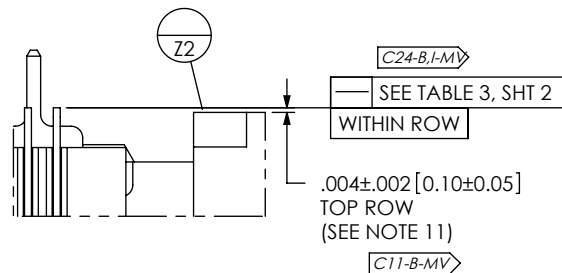
INSPECTION VIEW 3
(FILL TOP ROW)



DETAIL 'J'
SCALE 6:1



DETAIL 'K'
SCALE 6:1



DETAIL 'L'
SCALE 6:1

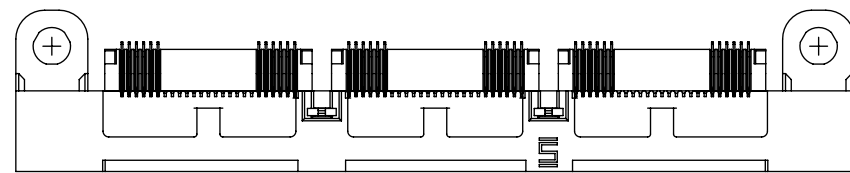
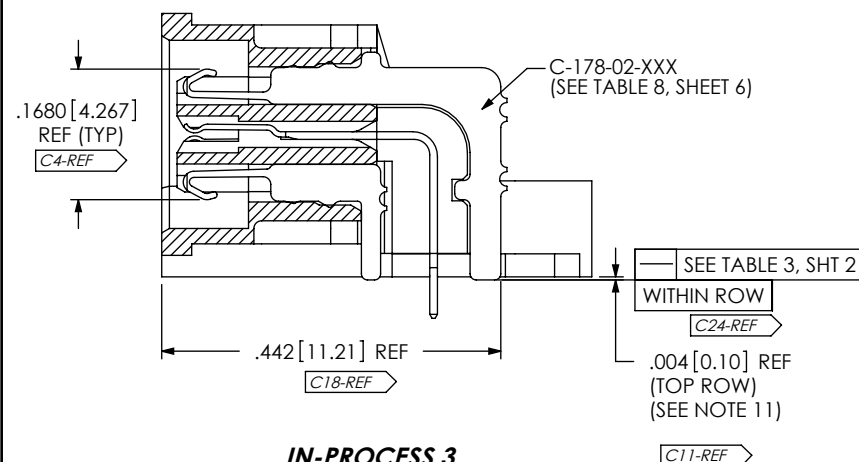


FIG 2

QSS-075-01-XXX-D-RA-WT-LS1 SHOWN
(SAME AS FIG. 1, EXCEPT AS SHOWN)
(SOME CENTER DETAILS REMOVED FOR CLARITY)

TABLE 5	
POSITION	"H"
-025	1.118 [28.38]
-050	1.905 [48.39]
-075	2.693 [68.39]
*-100	3.480 [88.39]

* = SEE NOTE 12



IN-PROCESS 3
(FILL TOP ROW)

(SEE INSPECTION VIEW 3 FOR ORIENTATION AND CPC'S)

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C	
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DESCRIPTION:

.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

DWG. NO.

QSS-XXX-XX-XXX-D-RA-XX-XXX

BY: KEVIN B

01/22/02

SHEET 4 OF 6

FIG 3
QSS-075-01-XXX-D-RA-WT-SP SHOWN
(SAME AS FIG. 1, EXCEPT AS SHOWN)
(NOT AVAILABLE WITH LS1 OPTION)
(SOME CENTER DETAILS REMOVED FOR CLARITY)

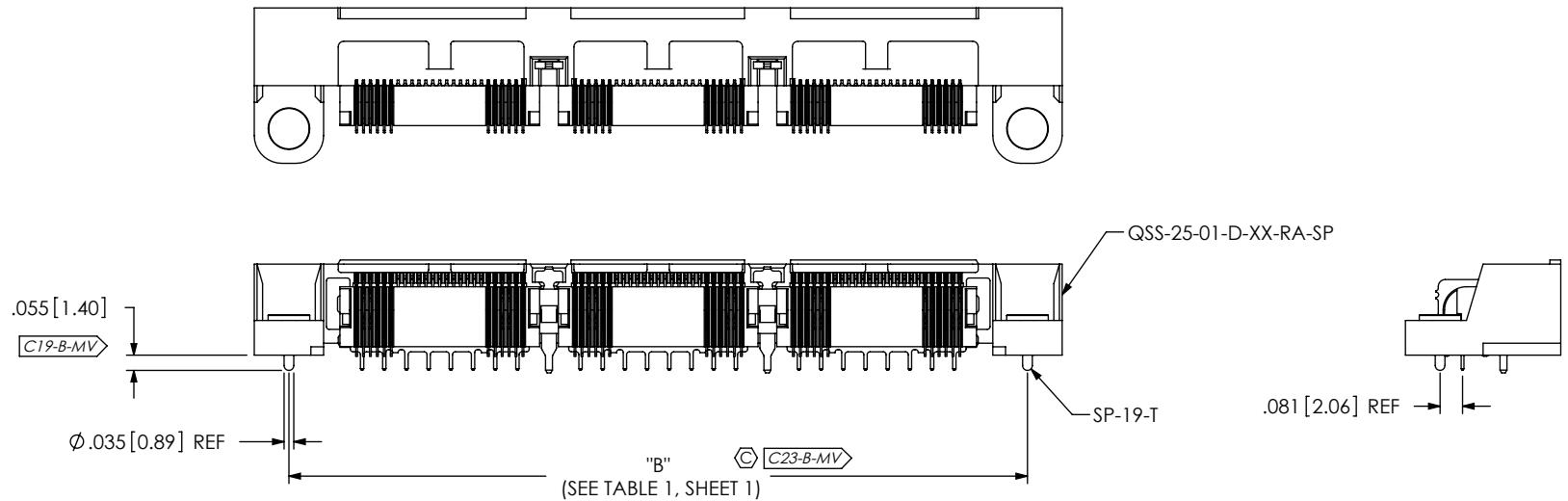


FIG 4
-K OPTION
QSS-075-01-XXX-D-RA-WT-K SHOWN
(SAME AS FIG. 1, EXCEPT AS SHOWN)
(SOME CENTER DETAILS REMOVED FOR CLARITY)

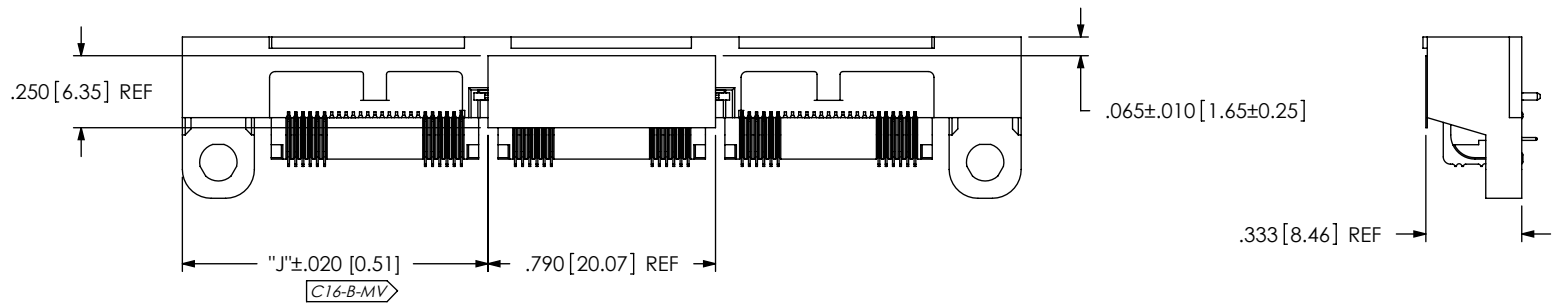


TABLE 6		
No OF POS	"J"	"J" - MTI OPTION
-25	0.274 [6.95]	0.472 [12.00]
-50	0.668 [16.95]	0.866 [22.00]
-75	1.061 [26.96]	1.260 [32.00]
*-100	1.455 [36.96]	1.654 [42.00]

* = SEE NOTE 12

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B	C16, C19, C23			
C				
D				
			DESCRIPTION: .635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP	
			DWG. NO. QSS-XXX-XX-XXX-D-RA-XX-XXX	
			BY: KEVIN B 01/22/02 SHEET 5 OF 6	

FIG 5
QSS-075-01-XXX-D-RA-WT-MTI SHOWN
(SAME AS FIG. 1, EXCEPT AS SHOWN)
(SOME CENTER DETAILS REMOVED FOR CLARITY)

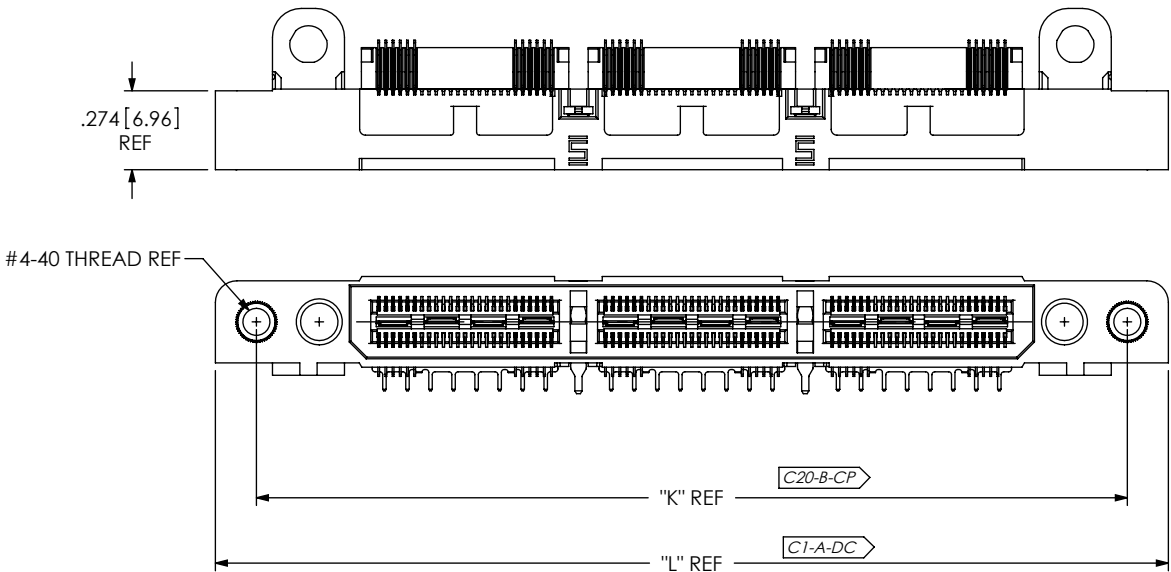


TABLE 7		
POSITION	"K"	"L"
-025	1.450 [36.82]	1.735 [44.06]
-050	2.237 [56.82]	2.522 [64.06]
-075	3.025 [76.82]	3.310 [84.06]
*-100	3.812 [96.82]	4.097 [104.06]

* = SEE NOTE 12

CRITICAL DIMENSION INSPECTION INSTRUCTION TABLE	
ASSEMBLY OPERATION	IN-PROCESS INSPECTION
FILL C-177-XX-XXX	C1, C7, C8, C10
FILL IM-1G18-XX-1-XXX	C12, C17
FILL C-178-XX-XXX	C4, C5, C11, C24
FILL WT-16-XX-XX	C6, C21
-LS1	C1, C22
-MTI	C1, C20
-SP	C1, C19, C23
-K	C1, C16

TABLE 8: PLATING SPECIFICATIONS			
	CONTACT 1	CONTACT 2	GROUND PLANE
-F	C-177-01-F: 3μ" FLASH GOLD CONTACT, MATTE TIN TAIL	C-178-02-F: 3μ" FLASH GOLD CONTACT, MATTE TIN TAIL	IM-1G18-XX-F: 3μ" FLASH GOLD CONTACT, MATTE TIN TAIL
-L	C-177-01-L: 10μ" LIGHT GOLD CONTACT, MATTE TIN TAIL	C-178-02-L: 10μ" LIGHT GOLD CONTACT, MATTE TIN TAIL	IM-1G18-XX-L: 10μ" LIGHT GOLD CONTACT, MATTE TIN TAIL
-H	C-177-01-H: 30μ" HEAVY GOLD CONTACT, 3μ" FLASH GOLD TAIL	C-178-02-H: 30μ" HEAVY GOLD CONTACT, 3μ" FLASH GOLD TAIL	IM-1G18-XX-H: 10μ" LIGHT GOLD CONTACT, MATTE TIN TAIL
-STL	C-177-01-STL: 30μ" SELECTIVE GOLD CONTACT, TIN/LEAD (90/10 +/-5%) TAIL	C-178-02-STL: 30μ" SELECTIVE GOLD CONTACT, TIN/LEAD (90/10 +/-5%) TAIL	IM-1G18-XX-STL: 30μ" SELECTIVE GOLD CONTACT, TIN/LEAD (90/10 +/-5%) TAIL
-FTL	C-177-01-FTL: 3μ" FLASH GOLD CONTACT, TIN/LEAD (90/10 +/-5%) TAIL	C-178-02-FTL: 3μ" FLASH GOLD CONTACT, TIN/LEAD (90/10 +/-5%) TAIL	IM-1G18-XX-FTL: 3μ" FLASH GOLD CONTACT, TIN/LEAD (90/10 +/-5%) TAIL

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A C1

B C20

C

D

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DWG. NO. QSS-XXX-XX-XXX-D-RA-XX-XXX

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F:\DWG\MISC\MKTG\QSS-XXX-XX-XXX-D-RA-XX-XXX-MKT.SLDDRW