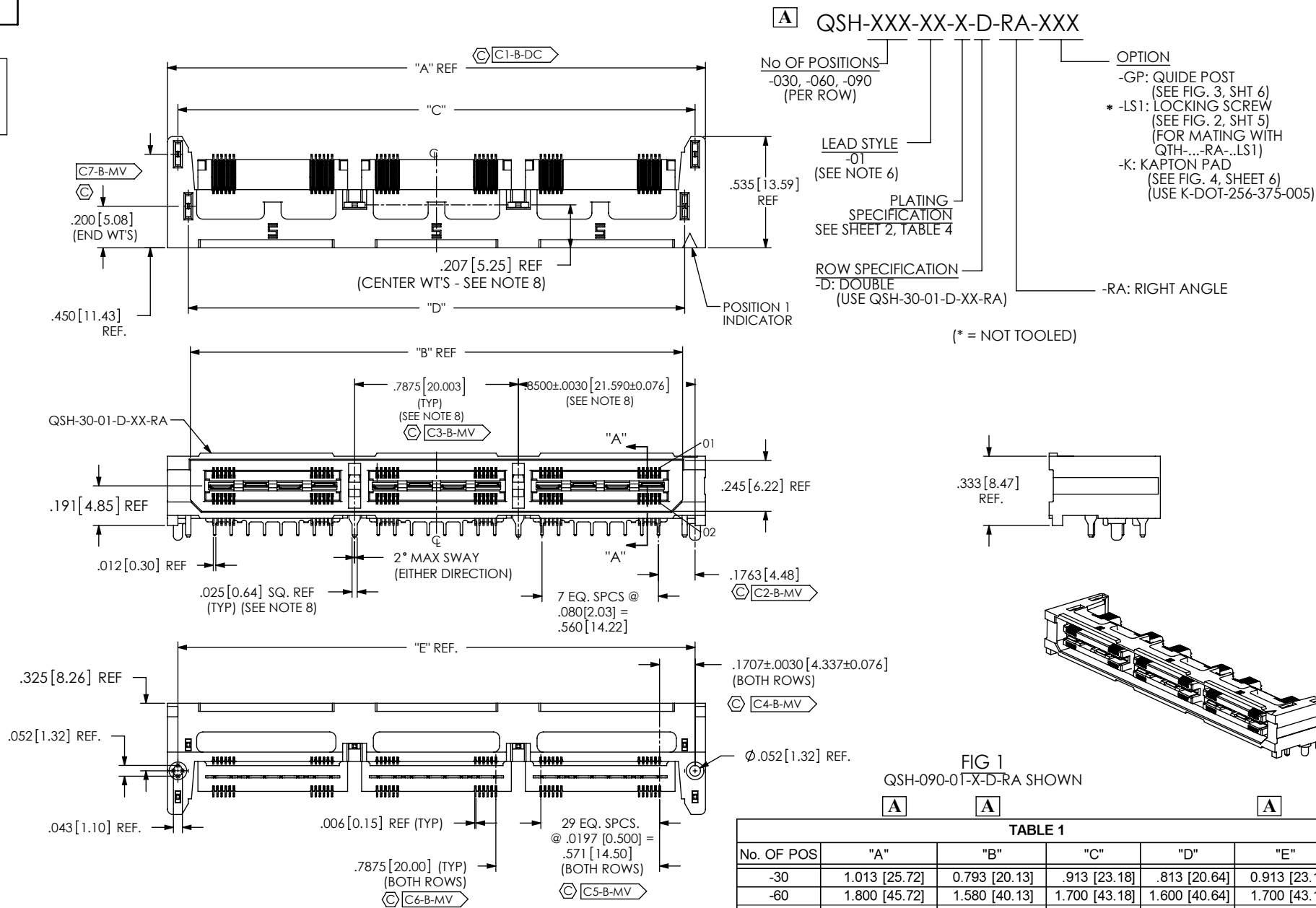



DO NOT  
SCALE FROM  
THIS PRINT



NOTES:

1.  REPRESENTS A CRITICAL DIMENSION.
2. BURR ALLOWANCE: .0010 MAX.
3. MINIMUM PUSHOUT FORCE: 6 OZ.
4. IF NEEDED, -L PLATING CAN BE SUBSTITUTED FOR -F PLATING.
5. IM-1G18-01-2-XX RETENTION TO BE 1.0 LBS. MINIMUM PRIOR TO SECOND ROW FILL.
6. DESIGNED FOR USE WITH A .062 OR .093 THICK PCB
7. ASSEMBLIES TO BE PACKAGED IN TRAYS.
8. CENTER WELD TABS ARE NOT AVAILABLE ON -030 POSITION.
9. USE -Z- DATUM ZONE ONLY FOR MEASUREMENTS.

No. OF POS	"A"	"B"	"C"	"D"	"E"
-30	1.013 [25.72]	0.793 [20.13]	.913 [23.18]	.813 [20.64]	0.913 [23.18]
-60	1.800 [45.72]	1.580 [40.13]	1.700 [43.18]	1.600 [40.64]	1.700 [43.18]
-90	2.588 [65.72]	2.368 [60.13]	2.488 [63.18]	2.388 [60.64]	2.488 [63.18]



CPC FREQUENCY THIS SHEET		UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE: DECIMALS                      ANGLES .XX: ±.01 [0.3]                      2° .XXX: ±.005 [0.13] .XXXX: ±.0020 [0.051]		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	
A				DESCRIPTION:			
B	C1-C7	MATERIAL:                      DO NOT SCALE DRAWING                      SHEET SCALE: 2:1		.50mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP			
C		INSULATOR: LCP UL94V-0, COLOR BLACK  TERMINAL, GROUND PLANE & WELD TAB: PHOS BRONZE		DWG. NO. QSH-XXX-XX-X-D-RA-XXX			
D				BY: DUKES Z                      01/31/2010		SHEET 1 OF 6	

TABLE 2			
No OF POSITIONS	COPLANARITY	STRAIGHTNESS ROW 1	STRAIGHTNESS ROW 1
-030 THRU -090	.004[0.10]	.004[0.10]	.004[0.10]

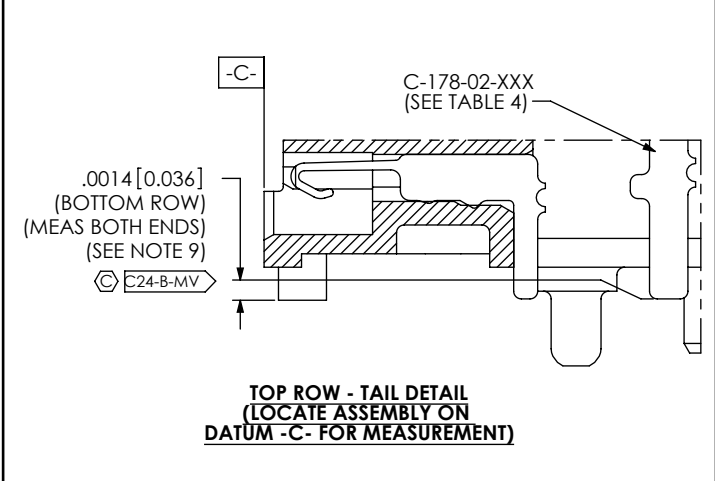
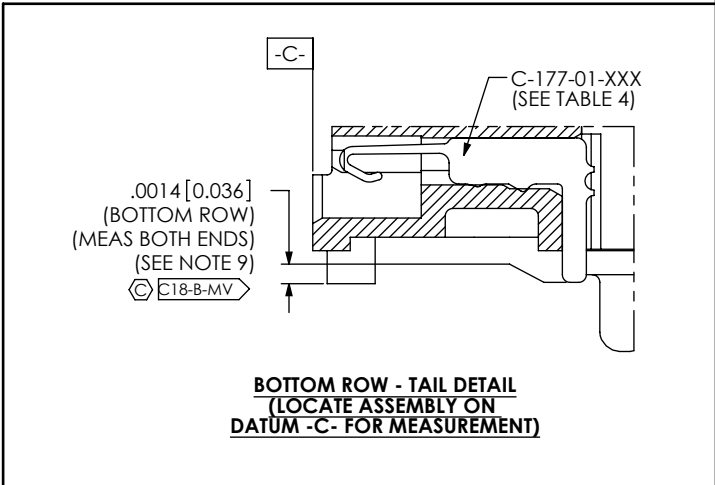
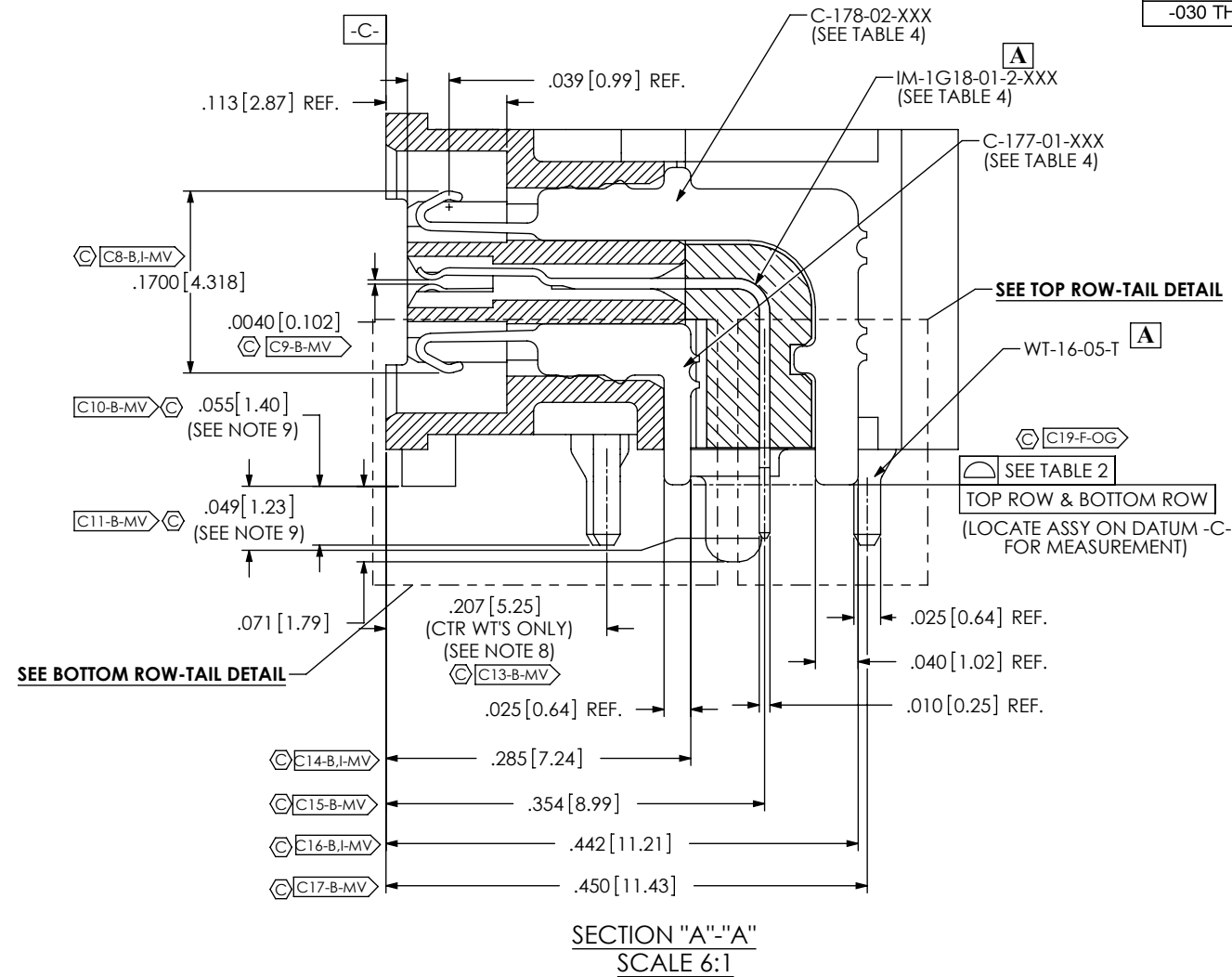
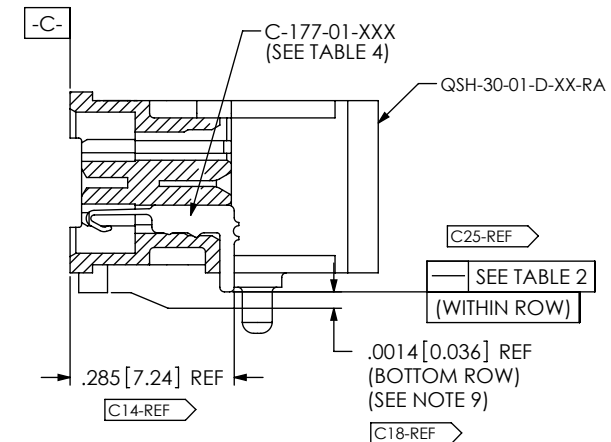
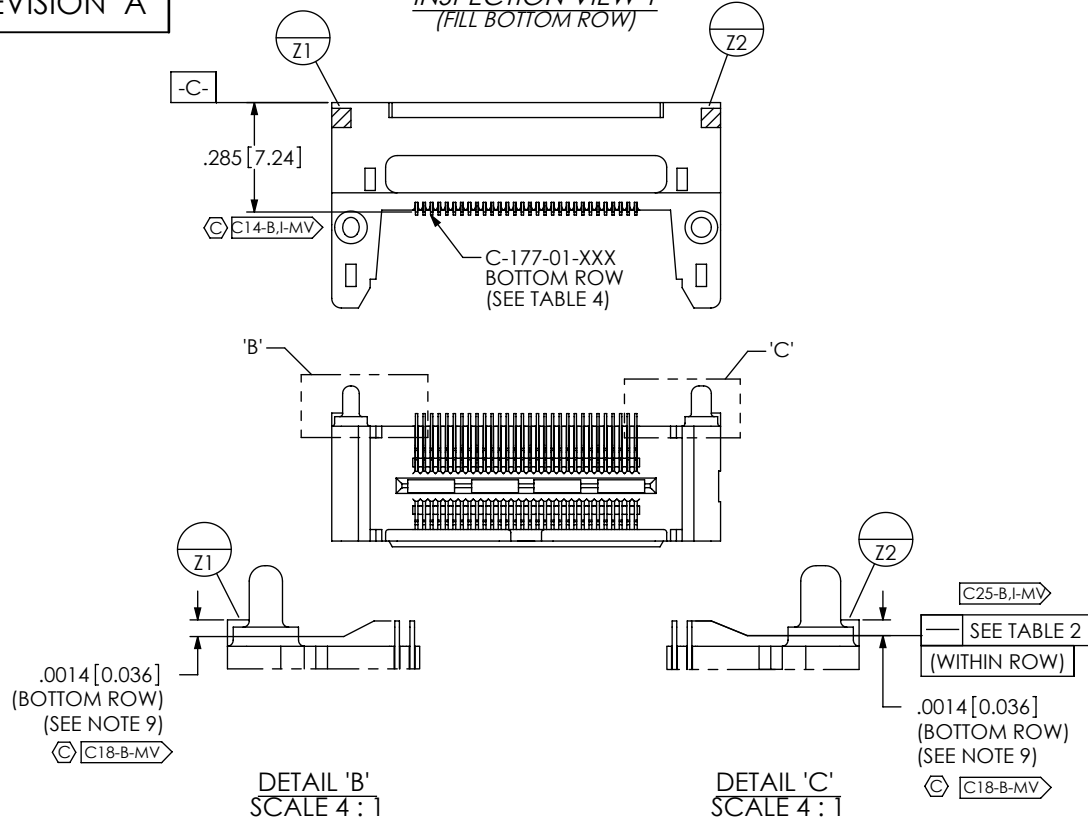


TABLE 4: PLATING SPECIFICATIONS				
	C-177-01-XXX CONTACT	C-178-02-XXX CONTACT	IM-1G18-01-2-X GROUND PLANE	WT-16-05-T WELD TAB
-F	3 - 5μ" FLASH GOLD ON CONTACT, MATTE TIN TAIL	3 - 5μ" FLASH GOLD CONTACT, MATTE TIN TAIL	3μ" MIN. FLASH GOLD CONTACT, MATTE TIN TAIL	MATTE TIN
-L	10μ" MIN. LIGHT GOLD CONTACT, MATTE TIN TAIL	10μ" MIN. LIGHT GOLD CONTACT, MATTE TIN TAIL	10μ" MIN. LIGHT GOLD CONTACT, MATTE TIN TAIL	MATTE TIN

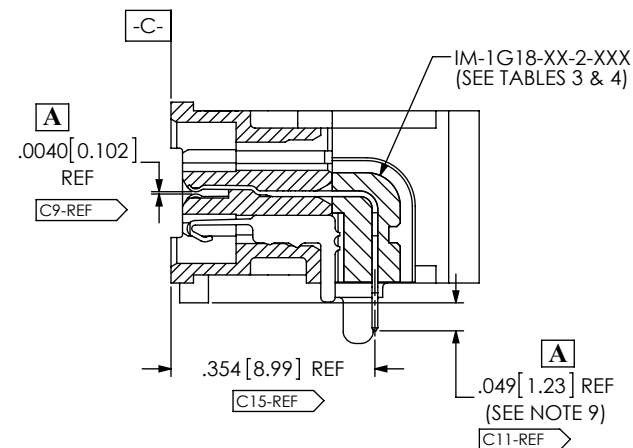
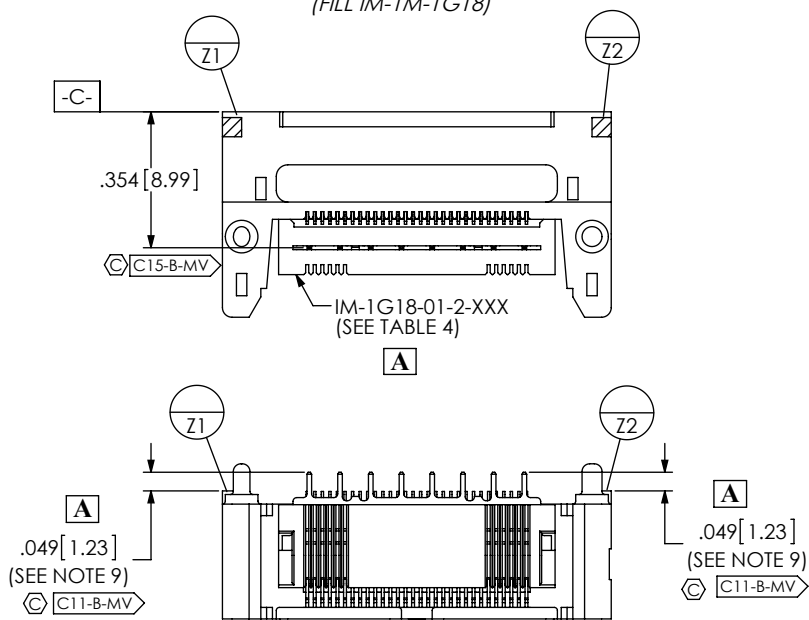
CPC FREQUENCY THIS SHEET	A	<b>PROPRIETARY NOTE</b> THIS DOCUMENT CONTAINS INFORMATION CONFIDENTIAL AND PROPRIETARY TO SAMTEC, INC. AND SHALL NOT BE REPRODUCED OR TRANSFERRED TO OTHER DOCUMENTS OR DISCLOSED TO OTHERS OR USED FOR ANY PURPOSE OTHER THAN THAT WHICH IT WAS OBTAINED WITHOUT THE EXPRESSED WRITTEN CONSENT OF SAMTEC, INC.  DO NOT SCALE DRAWING  SHEET SCALE: 6:1	 520 PARK EAST BLVD, NEW ALBANY, IN 47150 PHONE: 812-944-6733 FAX: 812-948-5047 e-Mail: info@SAMTEC.com code 55322	DESCRIPTION: .50mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP
	B			DWG. NO. <b>QSH-XXX-XX-X-D-RA-XXX</b>
	C			BY: DUKES Z 01/31/2010
	D			SHEET 2 OF 6

**INSPECTION VIEW 1**  
(FILL BOTTOM ROW)



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

**INSPECTION VIEW 2**  
(FILL IM-1M-1G18)



**IN-PROCESS 2**  
(FILL IM-1G18)  
(SEE INSPECTION VIEW 2 FOR ORIENTATION AND CPC'S)

CPC FREQUENCY THIS SHEET	
A	
B	C11, C14, C15, C18, C25
C	
D	

**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.

DO NOT SCALE DRAWING

SHEET SCALE: 6:1

**samtec**

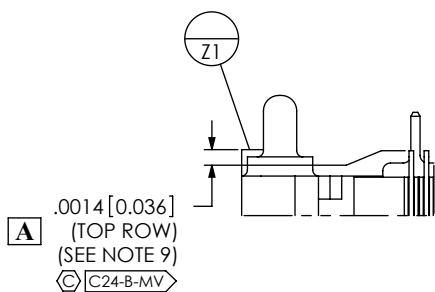
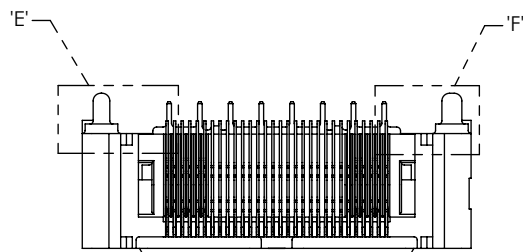
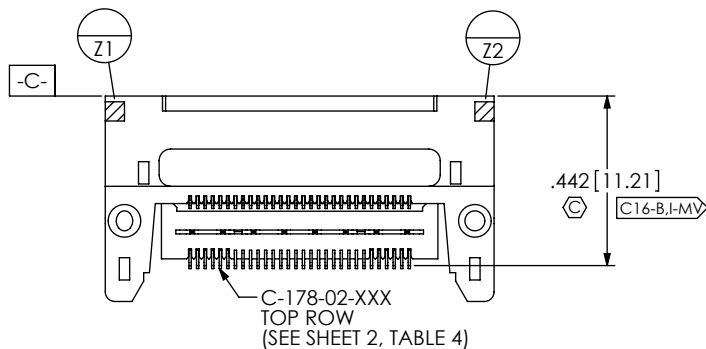
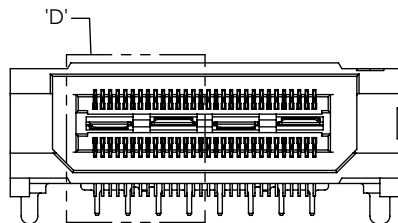
520 PARK EAST BLVD, NEW ALBANY, IN 47150  
PHONE: 812-944-6733 FAX: 812-948-5047  
e-Mail: info@SAMTEC.com code 55322

DESCRIPTION:  
.50mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

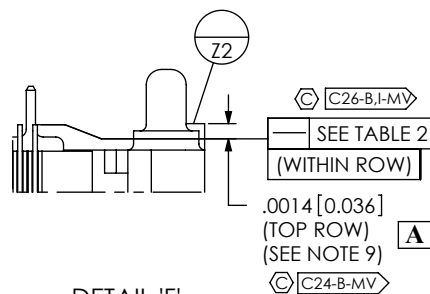
DWG. NO.  
**QSH-XXX-XX-X-D-RA-XXX**

BY: DUKES Z 01/31/2010 SHEET 3 OF 6

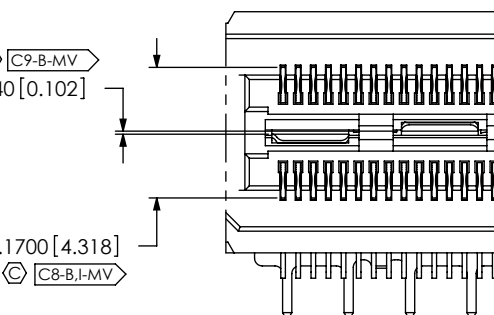
**INSPECTION VIEW 3**  
(FILL TOP ROW)



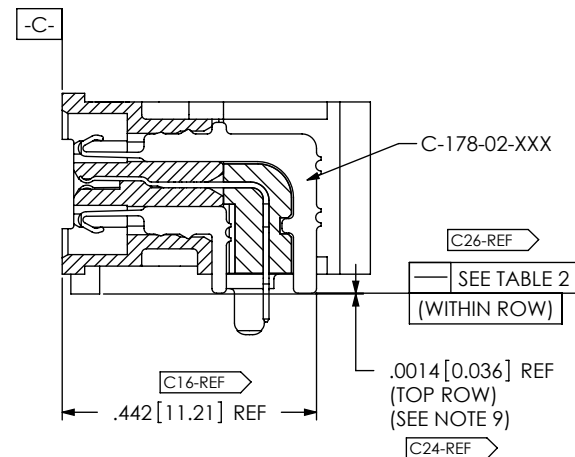
**DETAIL 'E'**  
SCALE 4 : 1



**DETAIL 'F'**  
SCALE 4 : 1



**DETAIL 'D'**  
SCALE 4 : 1



**IN-PROCESS 3**  
(FILL TOP ROW)  
(SEE INSPECTION VIEW 3 FOR ORIENTATION AND CPC'S)

CPC FREQUENCY THIS SHEET	
A	
B	C8, C9, C16, C24, C26
C	
D	

**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.

DO NOT SCALE DRAWING

SHEET SCALE: 6:1

**samtec**

520 PARK EAST BLVD, NEW ALBANY, IN 47150  
PHONE: 812-944-6733 FAX: 812-948-5047  
e-Mail: info@SAMTEC.com code 55322

DESCRIPTION:  
.50mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

DWG. NO.  
**QSH-XXX-XX-X-D-RA-XXX**

BY: DUKES Z 01/31/2010 SHEET 4 OF 6

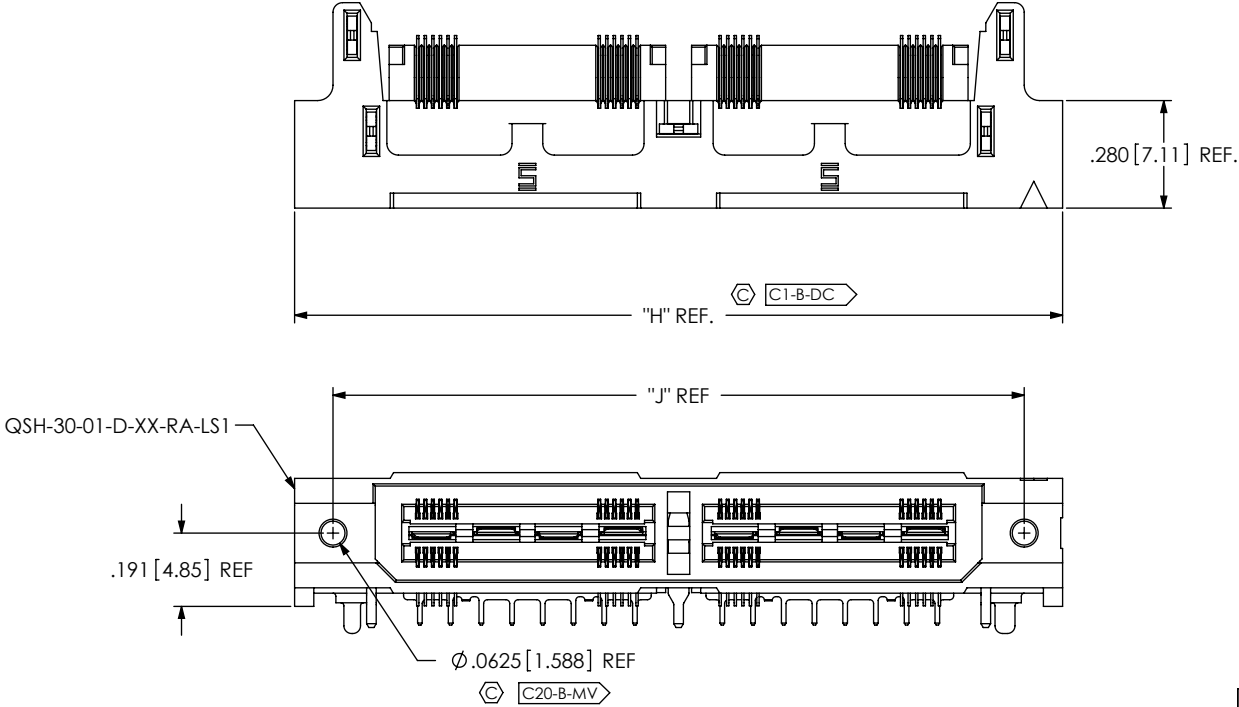


FIG 2  
QSH-060-01-X-D-RA-LS1 SHOWN  
(SAME AS FIG. 1, EXCEPT AS SHOWN)  
(NOT TOOLED)

TABLE 5		
NO OF POS	"H"	"J"
-30	1.213 [30.80]	1.013 [25.72]
-60	2.000 [50.80]	1.800 [45.72]
-90	2.788 [70.80]	2.588 [65.72]

A

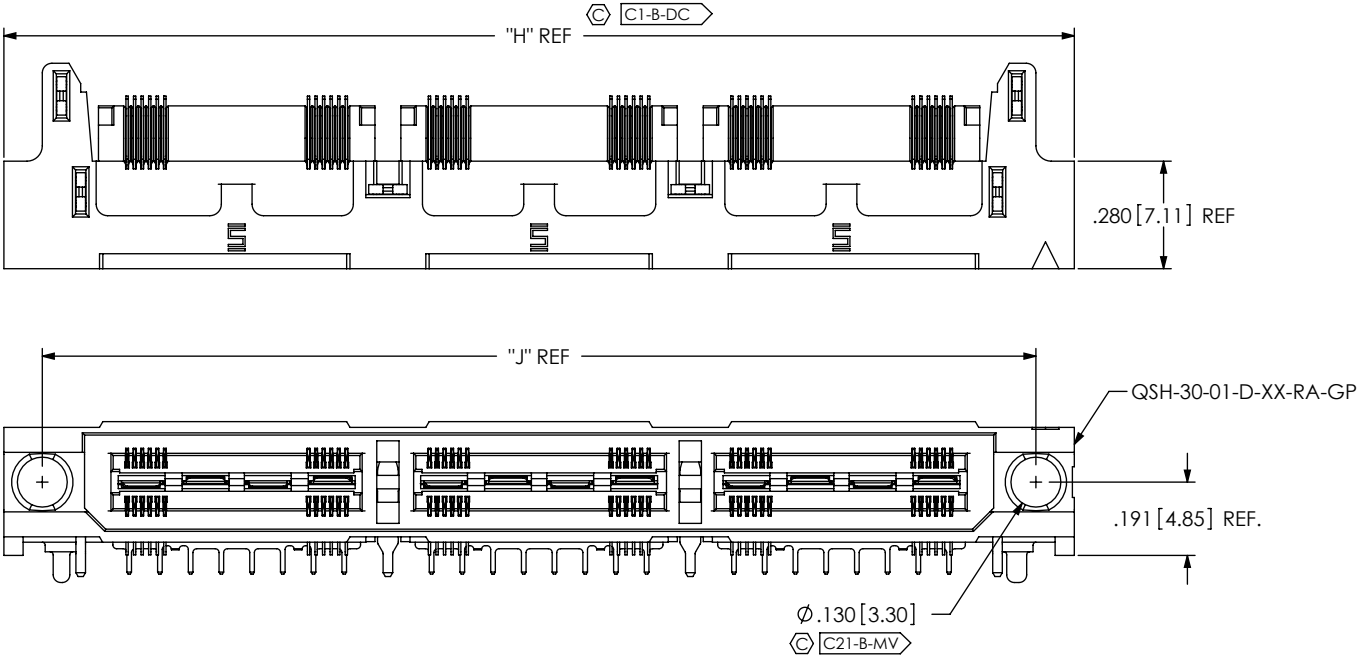
CRITICAL DIMENSION INSPECTION INSTRUCTION TABLE

ASSEMBLY OPERATION	IN-PROCESS INSPECTION
FILL C-177-01-XXX	C1, C4, C5, C6, C14, C18, C25
FILL IM-1G18-01-2-XXX	C2, C9, C11, C15
FILL C-178-02-XXX	C4, C5, C6, C8, C16, C24, C26
FILL WT-16-XXX-T	C3, C7, C10, C13, C17
APPLY K-DOT	C22, C23
FINAL ASSEMBLY	C1, C4, C5, C6, C8, C9

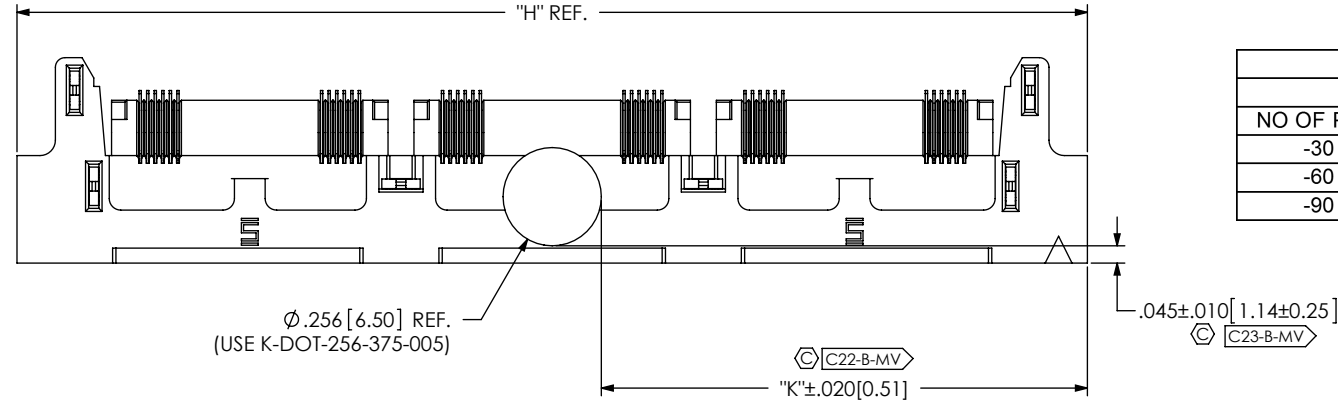
CPC FREQUENCY THIS SHEET	
A	
B	C1, C20
C	
D	

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.
DO NOT SCALE DRAWING
SHEET SCALE: 2:1

 520 PARK EAST BLVD, NEW ALBANY, IN 47150 PHONE: 812-944-6733 FAX: 812-948-5047 e-Mail info@SAMTEC.com code 55322	
DESCRIPTION: .50mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP	
DWG. NO. QSH-XXX-XX-X-D-RA-XXX	
BY: DUKES Z 01/31/2010	SHEET 5 OF 6



**A** FIG 3  
QSH-090-01-X-D-RA-GP SHOWN  
(SAME AS FIG. 1, EXCEPT AS SHOWN)



**A** FIG 4  
QSH-090-01-X-D-RA-GP-K SHOWN  
(SAME AS FIG. 1, EXCEPT AS SHOWN)

TABLE 6				
NO OF POS	"K"			
	-GP		NON -GP	
-30	.478	[12.14]	.378	[9.60]
-60	.872	[22.15]	.772	[19.61]
-90	1.266	[32.16]	1.166	[29.62]

CPC FREQUENCY THIS SHEET	
A	
B	C1, C21, C22, C23
C	
D	

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.

DO NOT SCALE DRAWING

SHEET SCALE: 1:0.666667

520 PARK EAST BLVD, NEW ALBANY, IN 47150  
PHONE: 812-944-6733 FAX: 812-948-5047  
e-Mail info@SAMTEC.com code 55322

DESCRIPTION:  
.50mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

DWG. NO.  
**QSH-XXX-XX-X-D-RA-XXX**

BY: DUKES Z 01/31/2010 SHEET 6 OF 6