

## DESIGNED & DIMENSIONED IN MILLIMETERS [INCHES]

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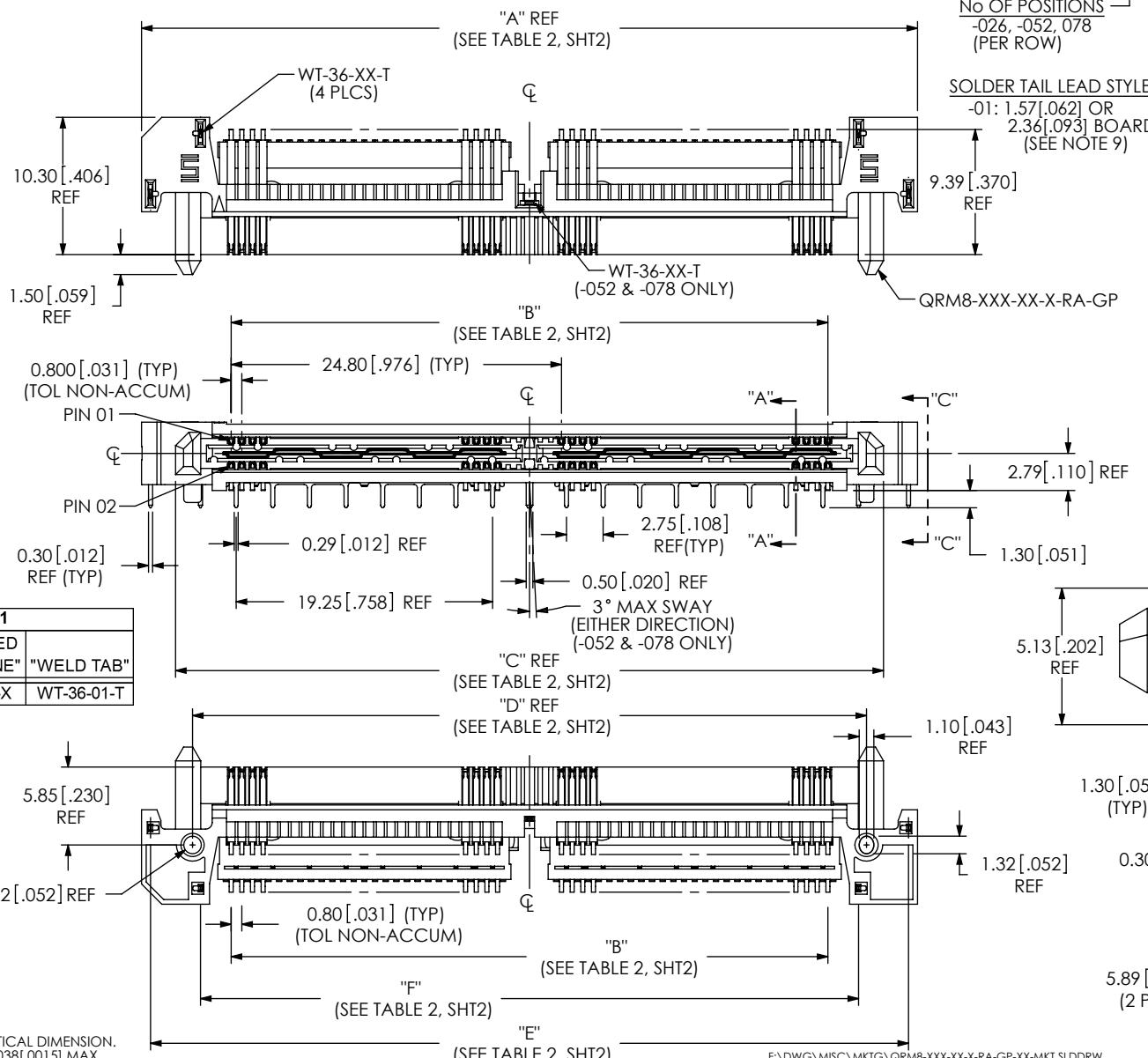


FIG 1  
(QRM8-052-01-X-RA-GP SHOWN)  
(SOME DETAIL REMOVED FOR CLARITY)

1.  REPRESENTS A CRITICAL DIMENSION.

2. BURR ALLOWANCE: 0.038[.0015] MAX.

3. MINIMUM PUSHOUT FORCE: SIGNAL: 2.22N[.5 LB]. GROUND PLANE: 4.45N[1 LB].

4. MEASURE AT BEND TANGENCY.

5. MEASURE ON PINS ONLY, STANDOFFS NOT INCLUDED IN MEASUREMENT.

6. POST HEIGHT VARIATION BETWEEN ANY TWO PINS: 0.05[.002] MAXIMUM.

7. NOTE DELETED

8. PARTS TO BE PACKAGED IN TRAYS, UNLESS -TR OPTION IS SPECIFIED.  
-078 POSITION IS NOT AVAILABLE IN TAPE AND REEL.

9. THE -01 SOLDER TAIL LEAD STYLE CAN BE USED FOR A 1.57[.062] OR A 2.36[.093] THICK PCB AND WILL ADHERE TO IPC-A-610 HOLE FILL STANDARDS IF SAMTEC'S RECOMMENDED STENCIL APERTURE IS UTILIZED.

10. DIMENSIONS MUST BE MEASURED BOTH ENDS OF COMB OR CONNECTOR.

11. NOTE DELETED.

12. NOTE DELETED.

13. USE INSPECTION FIXTURE # AT-2321-801-XX TO CHECK THIS DIMENSION.

14. THIS SURFACE MUST BE PARALLEL TO WITHIN 1.5° F.

15. SHEAR BURR ALLOWANCE: 0.15[.004] MAX ON THIS EDGE

(QRM8-05  
(SOME DETAILED INFORMATION IS CONTAINED ON THE FOLLOWING PAGES)

LESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN  
MILLIMETERS [INCHES].  
TOLERANCES ARE:  
DECIMALS ANGLES  
X.X:  $\pm 0.3$  [.01]  
X.XX:  $\pm 0.13$  [.005]  
X.XXX:  $\pm 0.050$  [.0020]

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**MATERIAL:** DO NOT SCALE DRAWING  
**INSULATORS:** LCP UL94V-0; **COLOR:** BLACK  
**CONTACT:** PHOS BRONZE  
**GROUND PLANE:** PHOS BRONZE

SHEET SCALE: 2:1



520 PARK EAST BLVD, NEW ALBANY, IN 47150  
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#### OPTION: S-Ω RATE RIGHT ANGLE TERMINAL ASSEMBLY

1 Q-RATE RIGHT ANGLE TERMINAL ASS

g. NO.: QRM8-XXX-XX-Y-PA-GP-XX

QRM8-XXXX-XX-X-RA-01 -XX  
P-A-1455658-16/06/2000 01/07/1

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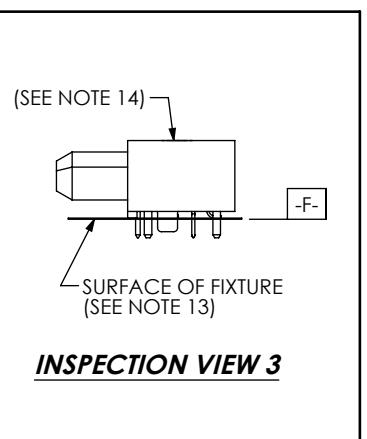
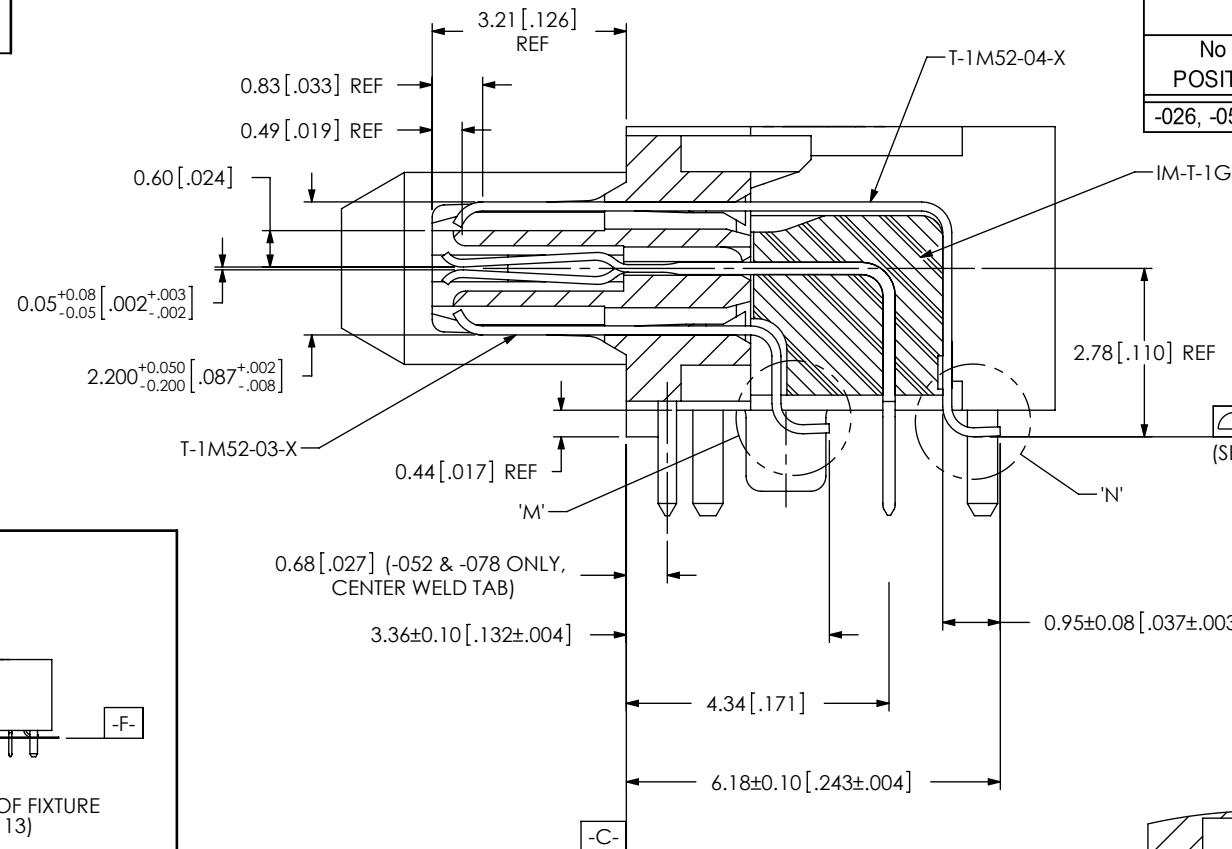
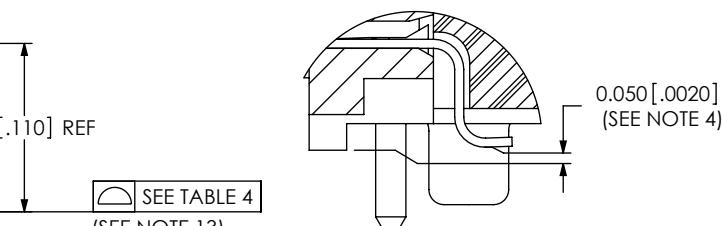
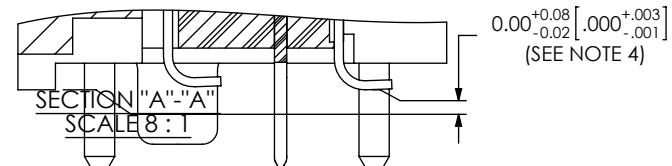
**INSPECTION VIEW 3**

TABLE 4			
NO OF POSITIONS	BOTTOM ROW STRAIGHTNESS	TOP ROW STRAIGHTNESS	COPLANARITY
-026, -052, -078	0.10 [0.004]	0.10 [0.004]	0.15 [0.006]



**DETAIL 'M'**  
BOTTOM ROW TAIL  
(LOCATE ASSY ON DATUM -C- FOR MEASUREMENT)



**DETAIL 'N'**  
TOP ROW TAIL  
(LOCATE ASSY ON DATUM -C- FOR MEASUREMENT)

TABLE 2						
NO OF POSITIONS	"A"	"B"	"C"	"D"	"E"	"F"
-026	33.46 [1.317]	20.00 [0.787]	28.35 [1.116]	25.80 [1.016]	32.11 [1.264]	24.61 [0.969]
-052	58.26 [2.294]	44.80 [1.764]	53.15 [2.093]	50.60 [1.992]	56.91 [2.240]	49.41 [1.945]
-078	83.06 [3.270]	69.60 [2.740]	77.95 [3.069]	75.40 [2.969]	81.71 [3.217]	74.21 [2.921]

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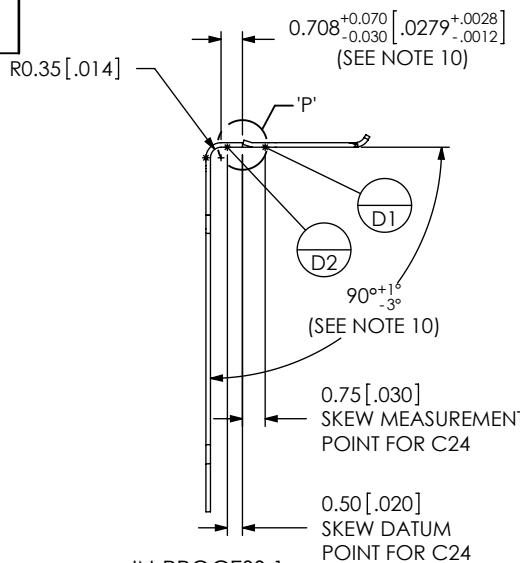
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DESCRIPTION: 0.8mm Q-RATE RIGHT ANGLE TERMINAL ASSEMBLY

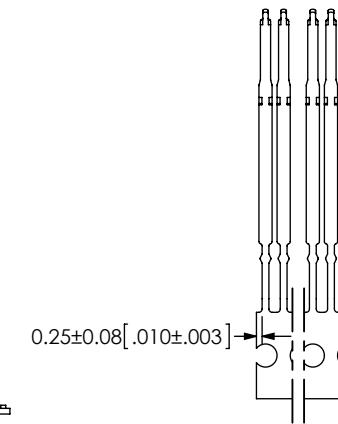
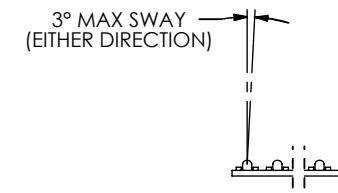
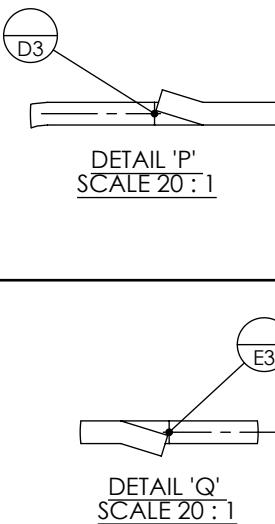
DWG. NO. QRM8-XXX-XX-X-RA-GP-XX

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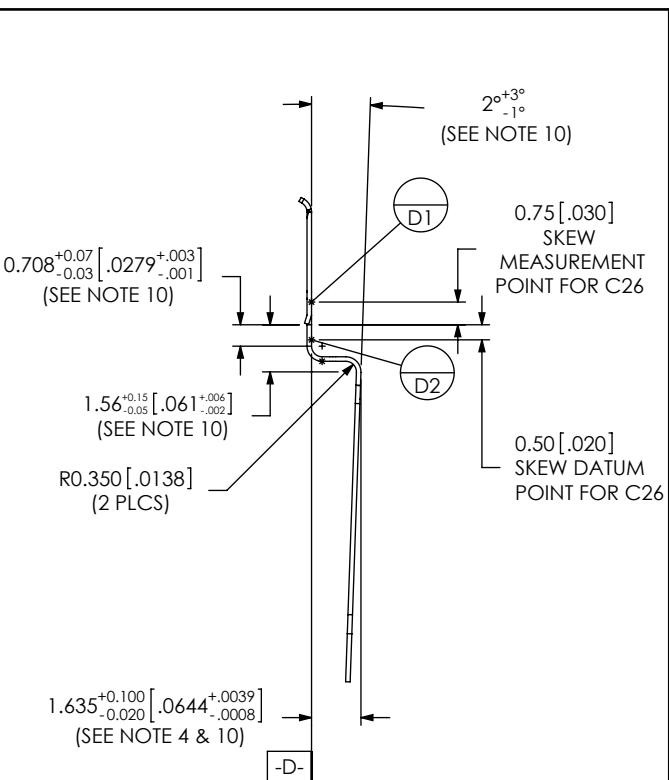
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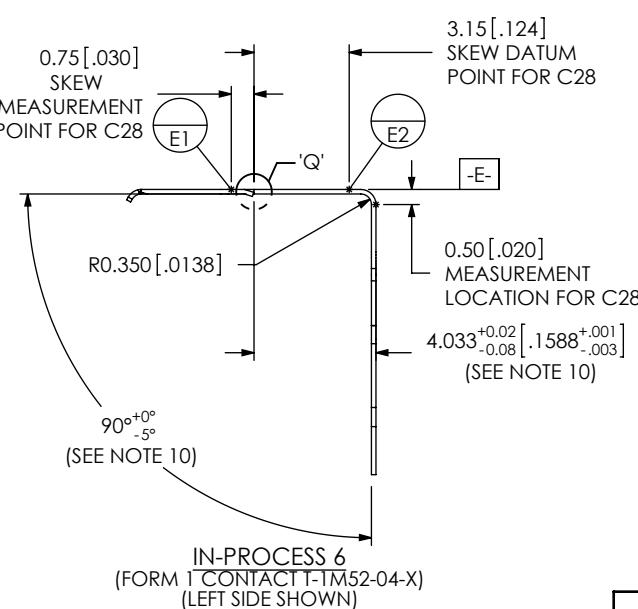
IN-PROCESS 1  
(FORM 1 CONTACT T-TM52-03-X)  
(RIGHT SIDE SHOWN)



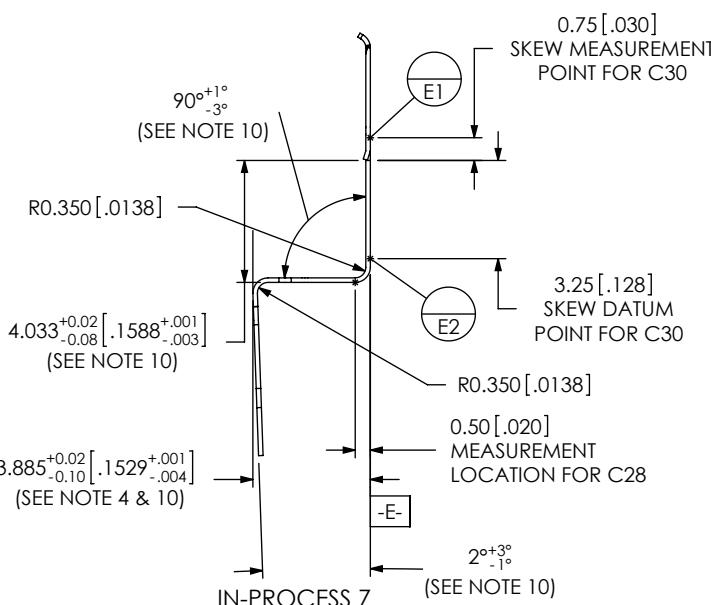
T-TM52-XX-X IN-PROCESS VIEW



IN-PROCESS 2  
(FORM 2 CONTACT T-TM52-03-X)  
(RIGHT SIDE SHOWN)



IN-PROCESS 6  
(FORM 1 CONTACT T-TM52-04-X)  
(LEFT SIDE SHOWN)



IN-PROCESS 7  
(FORM 2 CONTACT T-TM52-04-X)  
(LEFT SIDE SHOWN)

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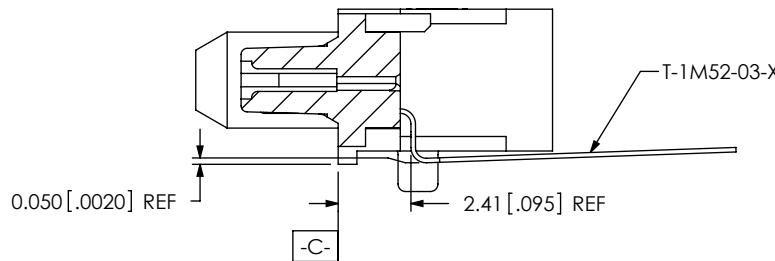
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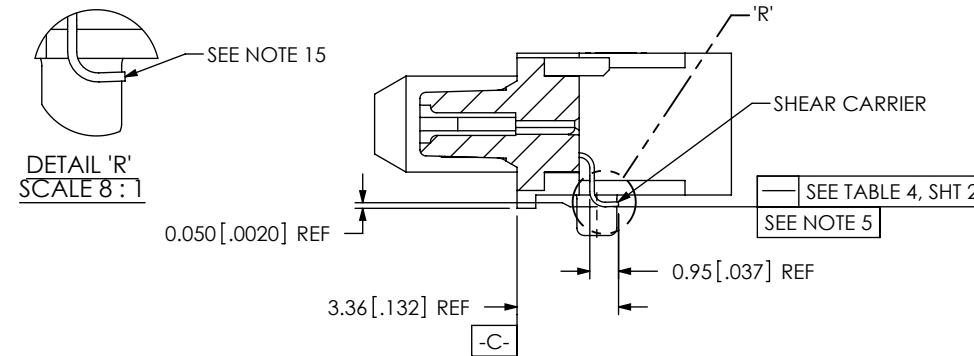
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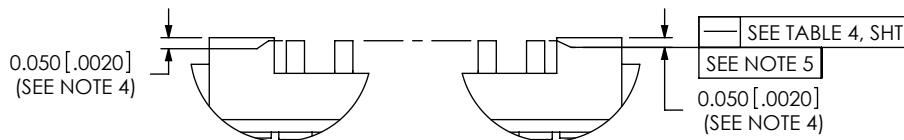
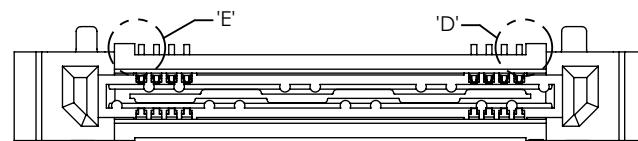


IN-PROCESS 3  
(FILL BOTTOM ROW)  
(SEE INSPECTION VIEW 1 FOR ASSEMBLY ORIENTATION AND CPC'S)



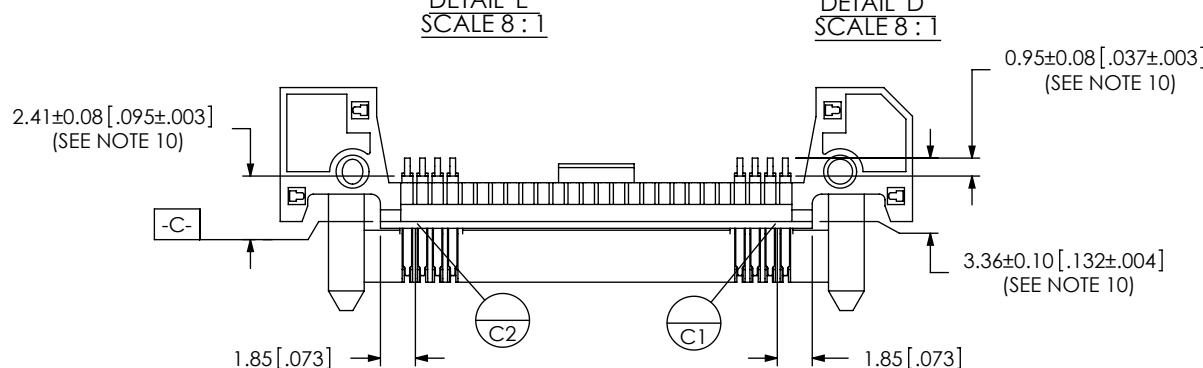
IN-PROCESS 4  
(CUTOFF OF CARRIER)  
(SEE INSPECTION VIEW 1 FOR ASSEMBLY ORIENTATION AND CPC'S)

INSPECTION VIEW 1

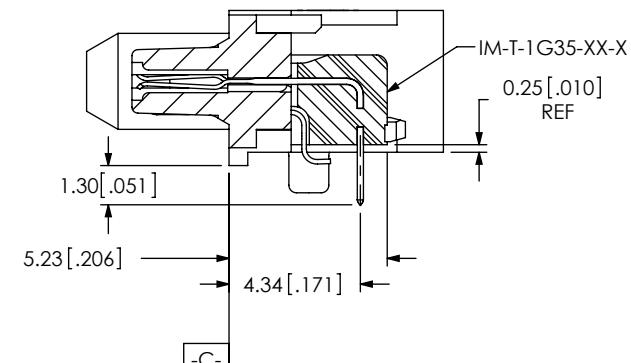


DETAIL 'E'  
SCALE 8 : 1

DETAIL 'D'  
SCALE 8 : 1



INSPECTION FOR IN-PROCESS 3 & 4  
(CARRIER NOT SHOWN FOR IN PROCESS 3 INSPECTIONS)



IN-PROCESS 5  
(FILL OVER MOLDED GROUND PLANE)  
(IM-T-1G35-XX-X)

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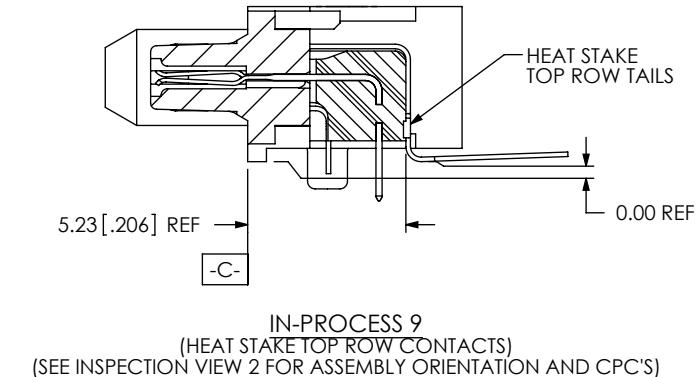
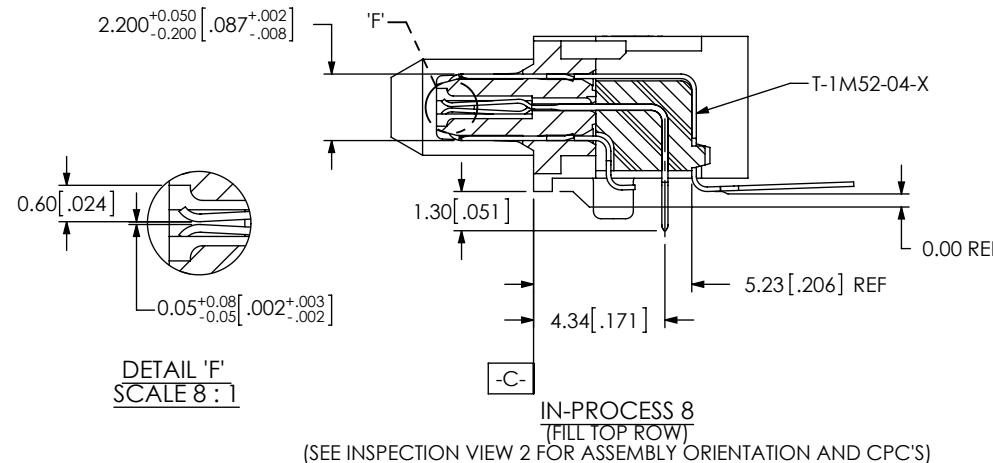
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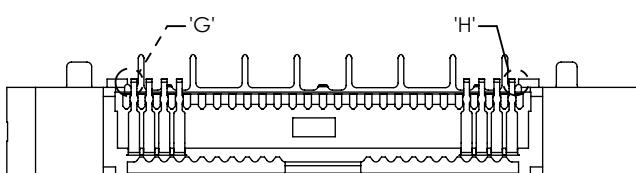
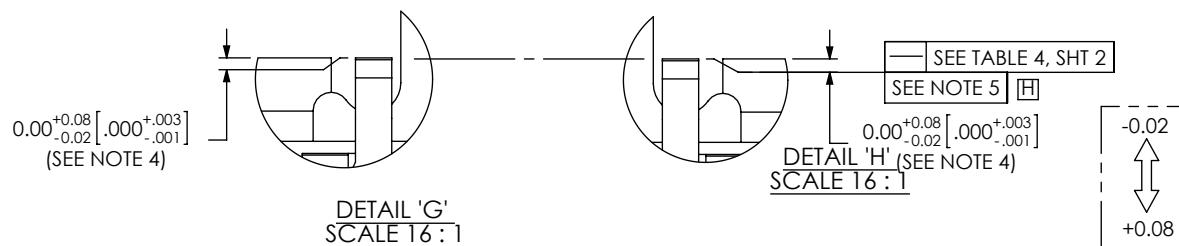
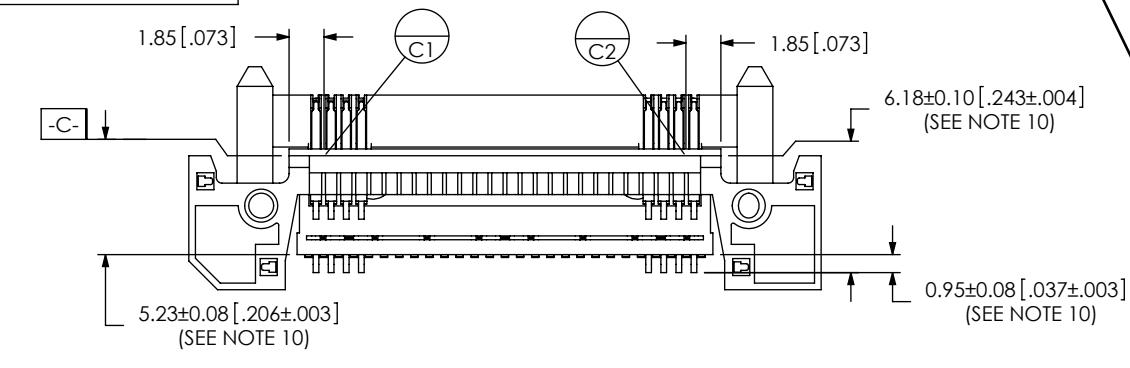
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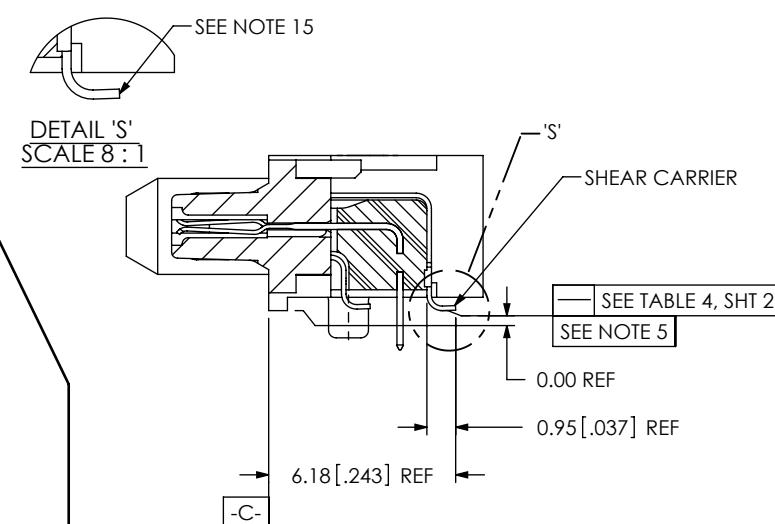
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INSPECTION VIEW 2



INSPECTION FOR IN-PROCESS 8, 9 & 10  
(CARRIER NOT SHOWN FOR IN-PROCESS 8 INSPECTIONS)



IN PROCESS-10  
(CUTOFF OF CARRIER)  
(SEE INSPECTION VIEW 2 FOR ASSEMBLY ORIENTATION AND CPC'S)

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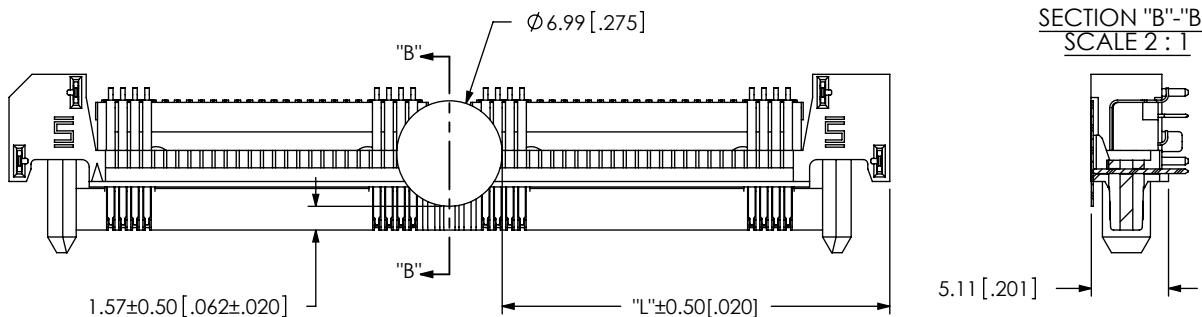
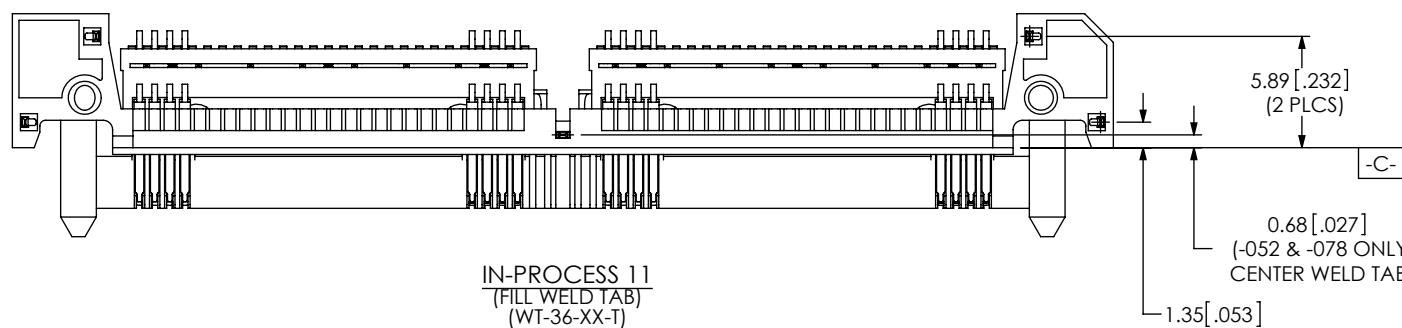
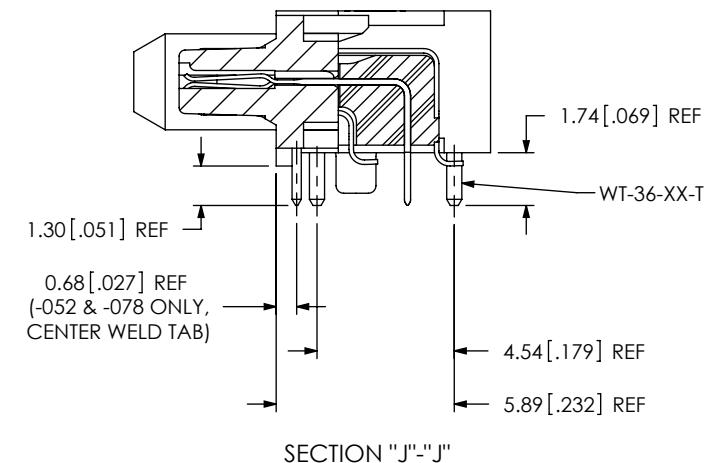
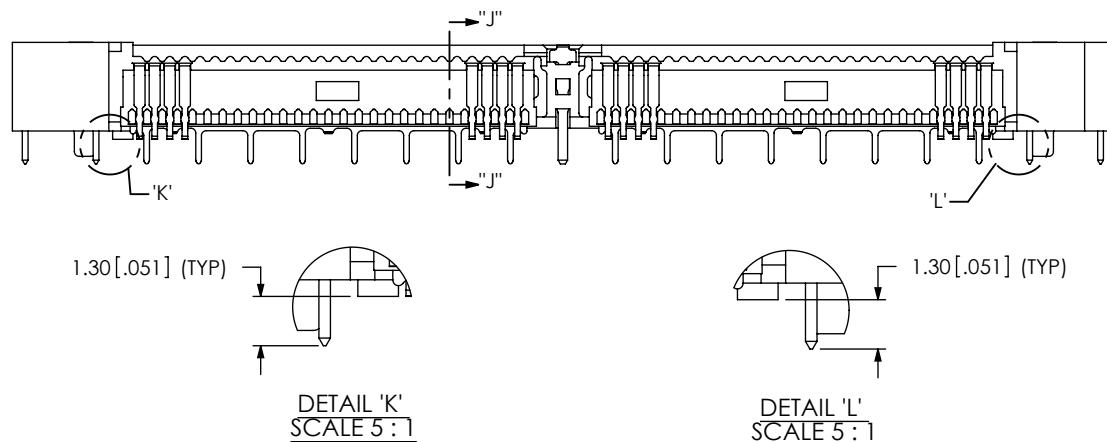


TABLE 5	
No OF POSITIONS	"L"
-026	13.24 [0.521]
-052	25.64 [1.009]
-078	38.04 [1.498]

FIG 2  
-K OPTION  
(USE K-DOT-.276-.375-.005)  
(QRM8-052-01-X-RA-GP-K SHOWN)  
(SOME DETAIL REMOVED FOR CLARITY)

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