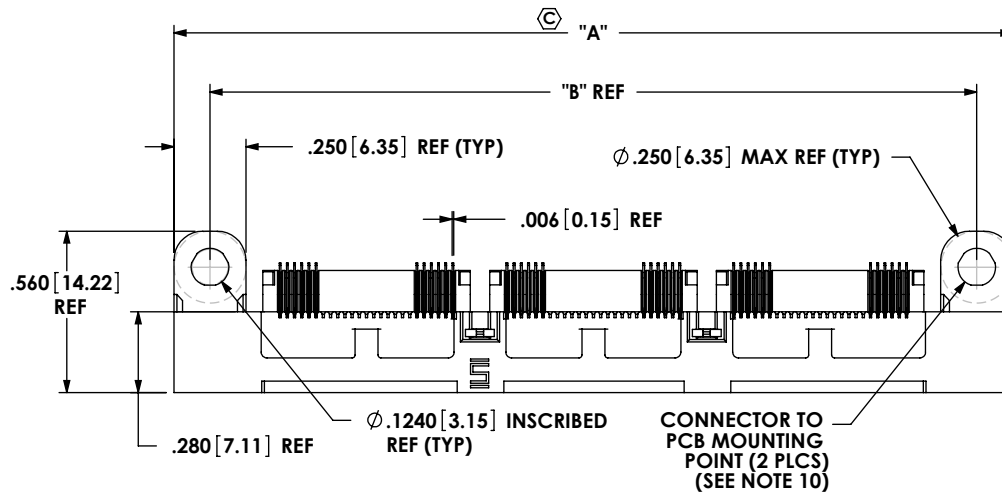


DO NOT SCALE FROM THIS PRINT



No OF POSITIONS
-025, -050, -075, -100
(PER ROW)
(SEE NOTE 4)

LEAD STYLE
-01: .062 BOARD
-02: .093 BOARD

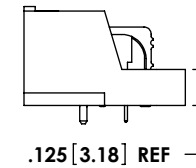
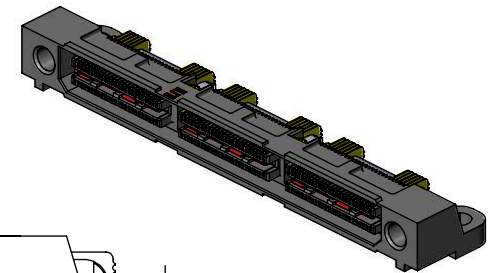
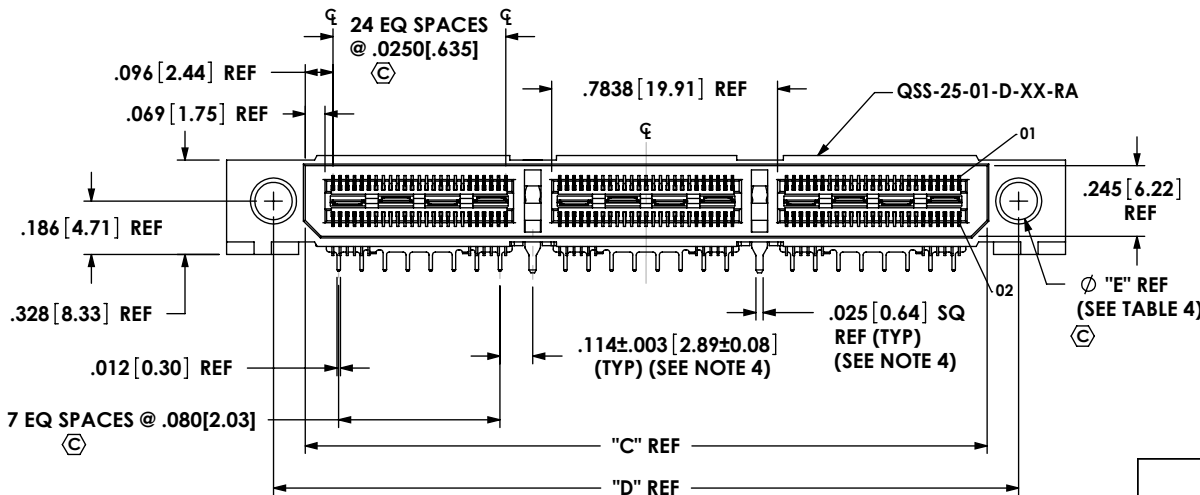
PLATING SPECIFICATION
SEE TABLE 2

ROW SPECIFICATION
-D: DOUBLE
(USE QSS-25-01-D-XX-RA)

-RA: RIGHT ANGLE

OPTION
-LS1: LOCKING SCREW
(SEE FIG. 2, SHT 3)
(FOR MATING WITH
QTS-...-RA-..LS1)
-MTI: THREADED INSERT
(SEE FIG. 5, SHT 5)
-SP: SOLDER PIN
(NOT AVAILABLE
W/LS1 OPTION)
(USE SP-19-T)
(SEE FIG. 3, SHT 4)
-K: KAPTON PAD
(SEE FIG. 4, SHEET 4)
(USE K-500-300)

-WT: WELD TAB
(SEE NOTE 4)
(USE WT-16-XX-T)



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

POSITION	"A"	"B"	"C"	"D"
-025	1.338 0.00	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]

FIG 1
QSS-075-01-XXX-D-RA SHOWN
(SOME CENTER DETAILS REMOVED FOR CLARITY)

NOTES:

- REPRESENTS A CRITICAL DIMENSION.
- BURR ALLOWANCE: .0010 MAX.
- MINIMUM PUSHOUT FORCE: 6 OZ.
- WELD TABS (WT-16-XX-T) NOT AVAILABLE ON -025 POSITION.
- IF NEEDED, -L PLATING CAN BE SUBSTITUTED FOR -F PLATING.
- IM-1G18-XX-1-XX RETENTION TO BE 1.0 LBS. MINIMUM PRIOR TO SECOND ROW FILL.
- DESIGNED FOR USE WITH A .062 OR .093 THICK PCB
- ASSEMBLIES TO BE PACKAGED IN TRAYS.
- NOTE DELETED
- TORQUE TO BE 10.0 IN-OZ USING 4-40 UNC SCREW.
- USE -Z- DATUM ZONE ONLY FOR MEASUREMENTS.

UNLESS OTHERWISE SPECIFIED,
DIMENSIONS ARE IN INCHES.
TOLERANCES ARE:
DECIMALS ANGLES
.XX: ±.01 [3] 2°
.XXX: ±.005 [13]
.XXXX: ±.0020 [051]

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MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 1.5:1

INSULATOR: LCP, COLOR: BLACK

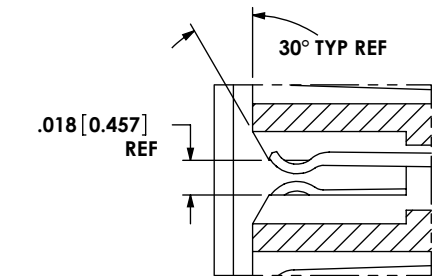
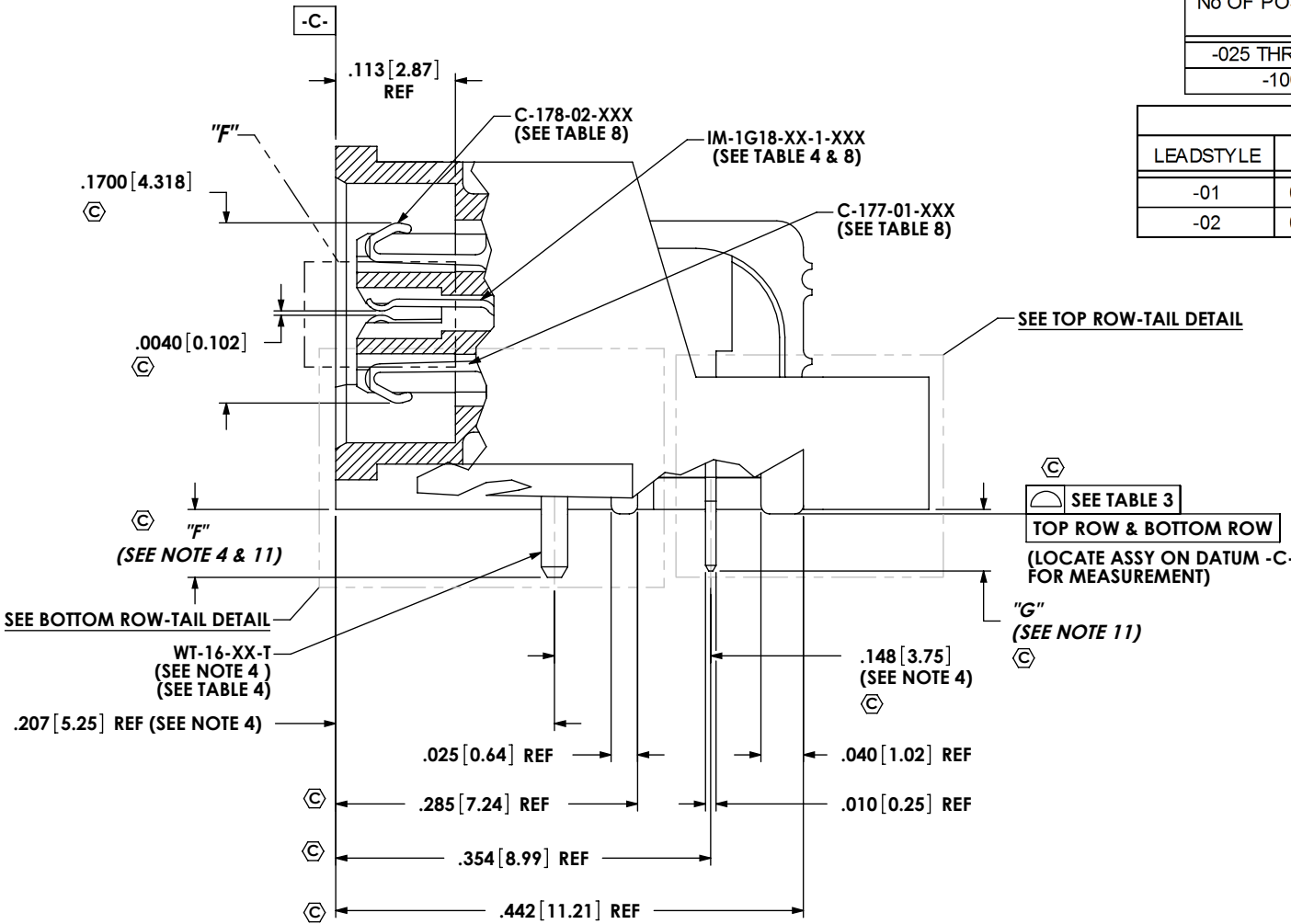
TERMINAL, GROUND PLANE &
WELD TAB: PHOS BRONZE

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

DESCRIPTION:
.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

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

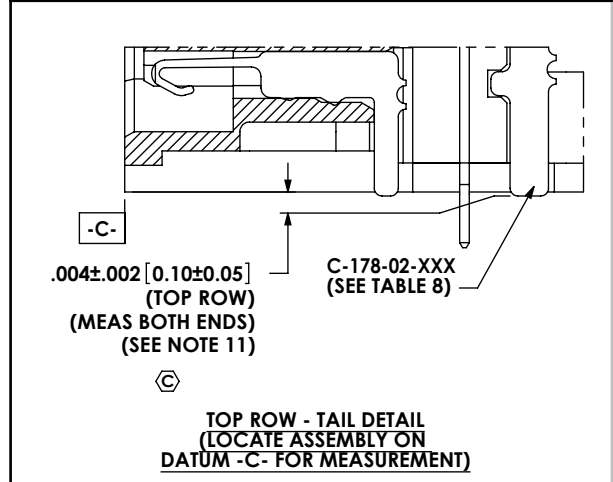
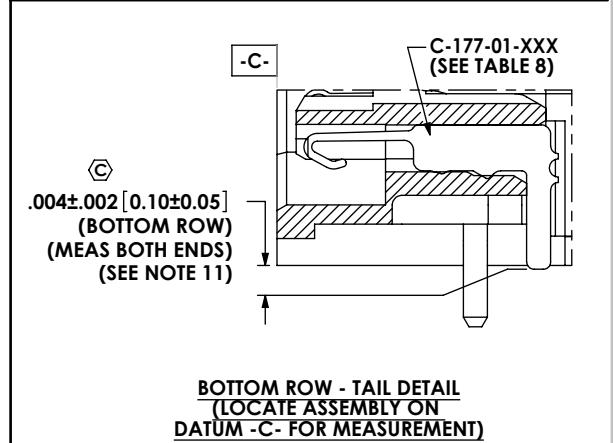
BY: KEVIN B 01/22/02 SHEET 1 OF 6



DETAIL "F"
SCALE 10 : 1

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]

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



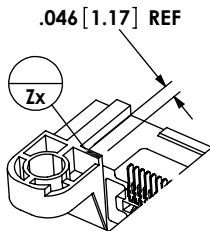
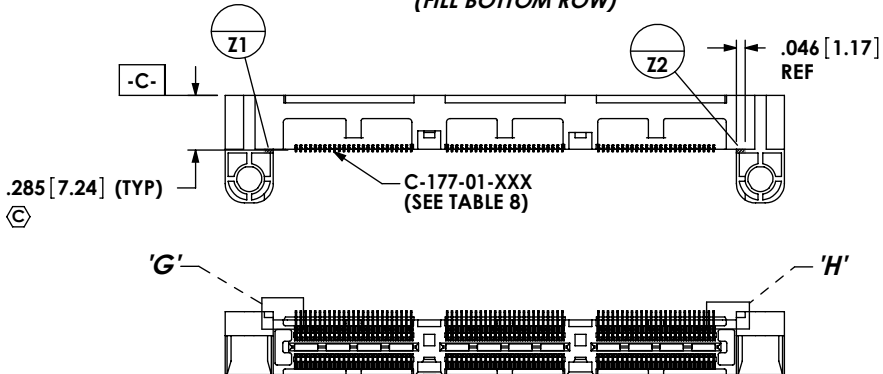
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SHEET SCALE: 6:1

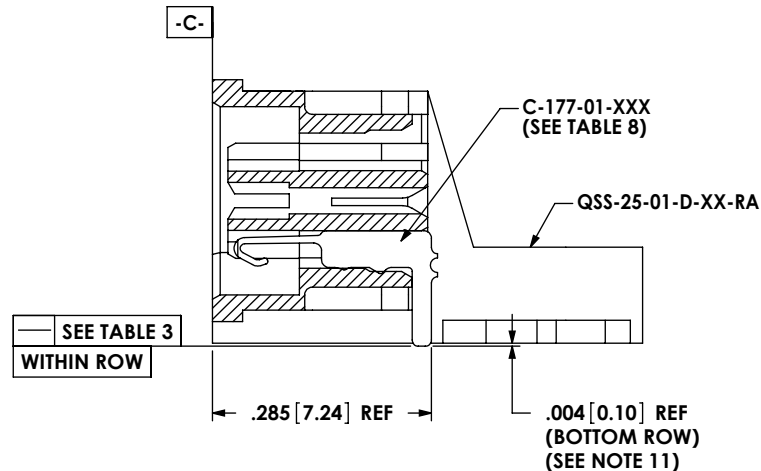
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e-Mail info@SAMTEC.com code 55322

DESCRIPTION:
.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP
DWG. NO.
QSS-XXX-XX-XXX-D-RA-WT-XXX
BY: KEVIN B 01/22/02 SHEET 2 OF 6

INSPECTION VIEW 1
(FILL BOTTOM ROW)

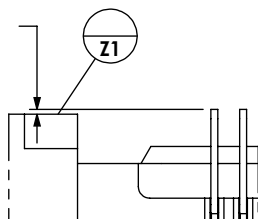


ISO VIEW OF
-Z- DATUM ZONE

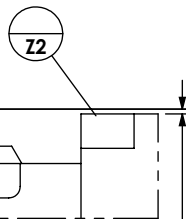


IN-PROCESS 1
(FILL BOTTOM ROW)
(SEE INSPECTION VIEW 1 FOR ORIENTATION AND CPC'S)

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



DETAIL 'G'
SCALE 6:1



DETAIL 'H'
SCALE 6:1

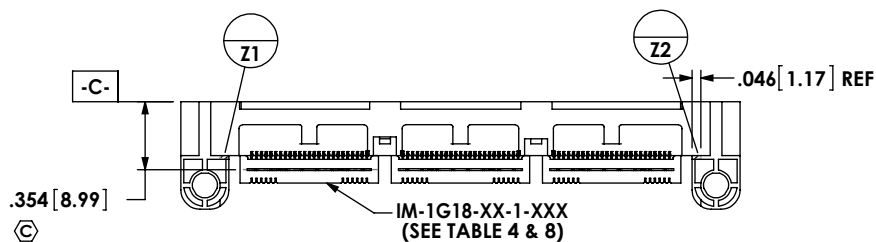
SEE TABLE 3
WITHIN ROW



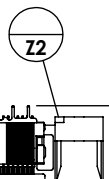
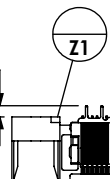
.004±.002 [0.10±0.05]
(BOTTOM ROW)
(SEE NOTE 11)



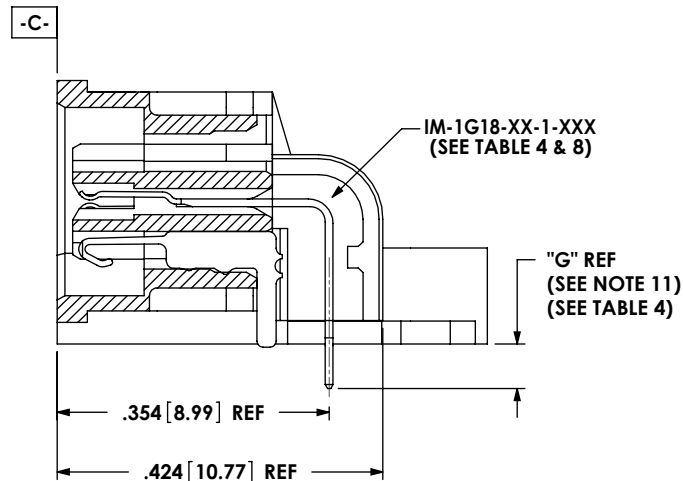
INSPECTION VIEW 2
(FILL IM-1G18)



"G"
(SEE NOTE 11)



"G"
(SEE NOTE 11)



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

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DESCRIPTION:
.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

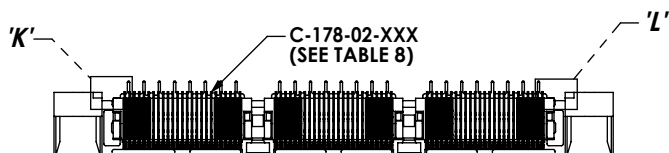
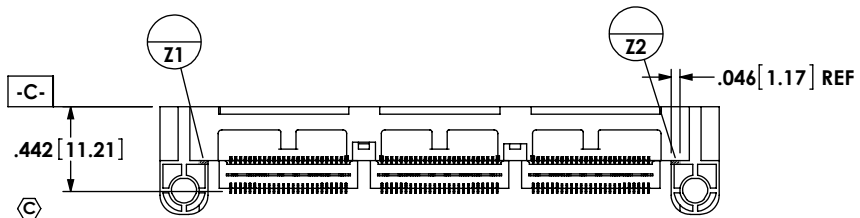
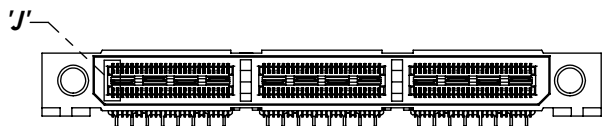
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QSS-XXX-XX-XXX-D-RA-WT-XXX

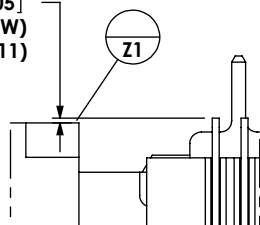
BY: KEVIN B 01/22/02

SHEET 3 OF 6

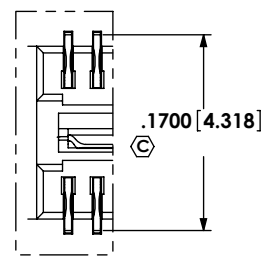
INSPECTION VIEW 3
(FILL TOP ROW)



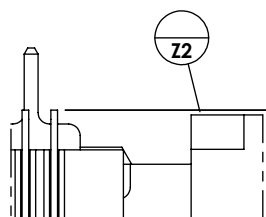
⊕
.004±.002 [0.10±0.05]
(TOP ROW)
(SEE NOTE 11)



DETAIL 'K'
SCALE 6:1



DETAIL 'J'
SCALE 6:1



DETAIL 'L'
SCALE 6:1

⊕
— SEE TABLE 3
WITHIN ROW

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

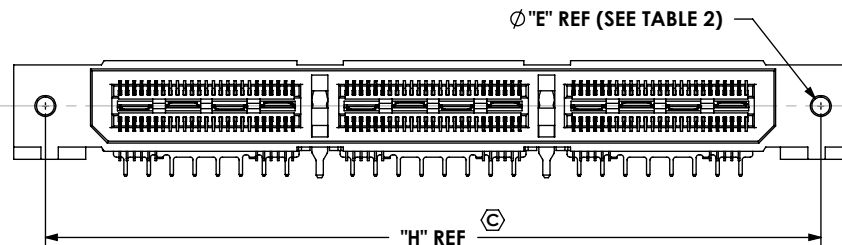
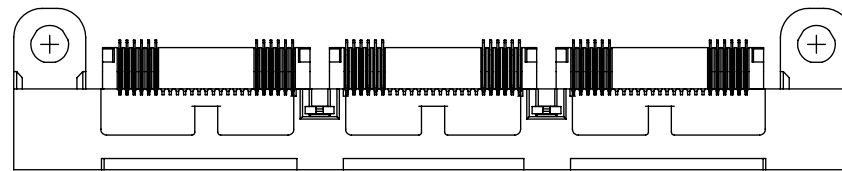
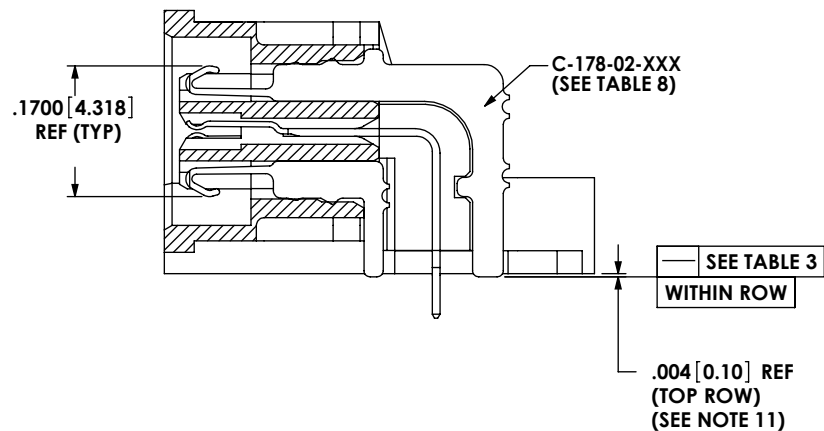


FIG 2
QSS-075-01-XXX-D-RA-LS1 SHOWN
(SAME AS FIG. 1, EXCEPT AS SHOWN)
(SOME CENTER DETAILS REMOVED FOR CLARITY)

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



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

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DESCRIPTION:
.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

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

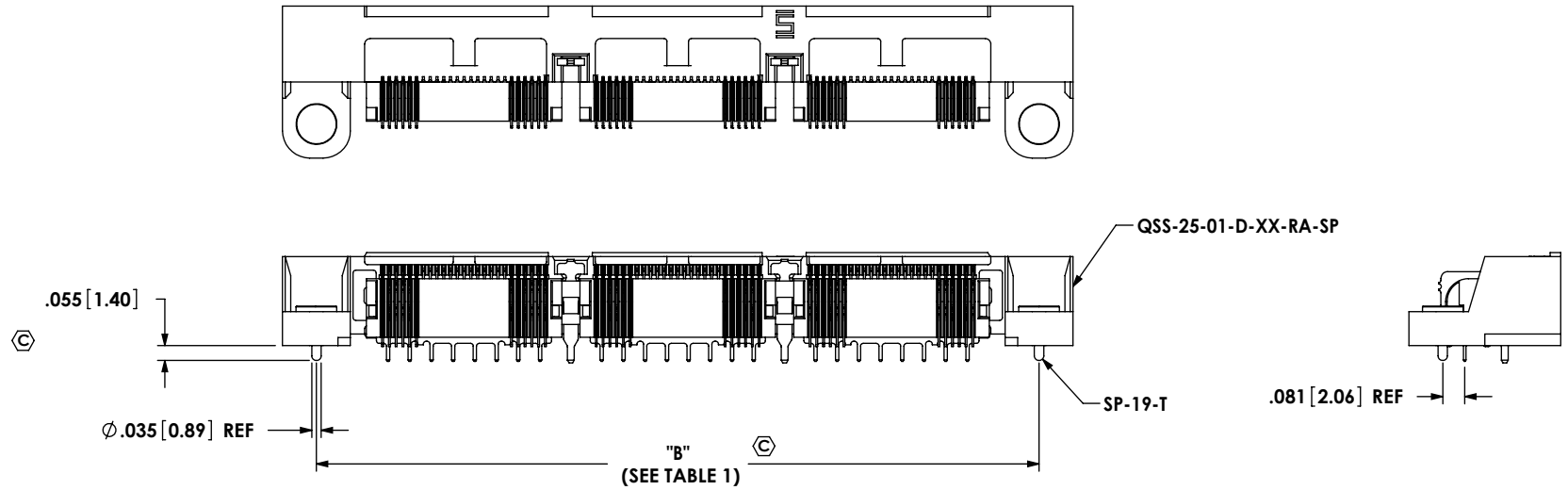


FIG 4
 -K OPTION
 QSS-075-01-XXX-D-RA-WT-K SHOWN
 (SAME AS FIG. 1, EXCEPT AS SHOWN)
 (SOME CENTER DETAILS REMOVED FOR CLARITY)

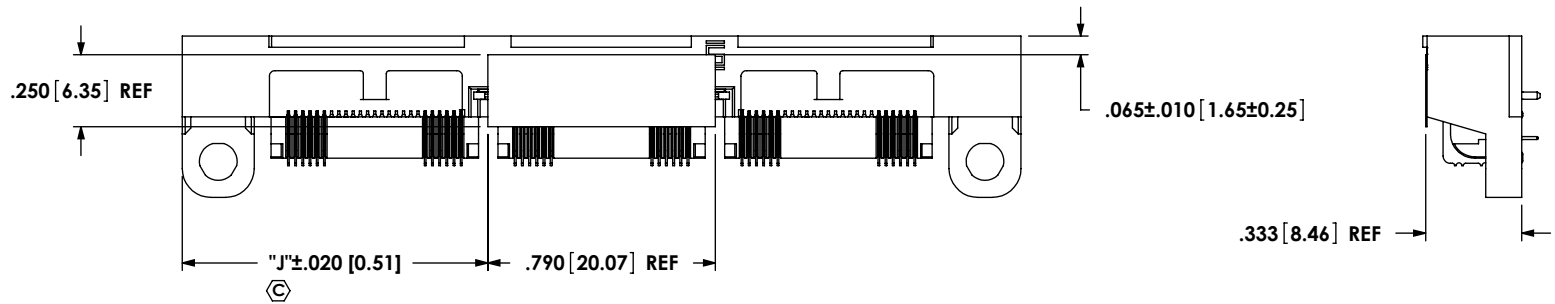


TABLE 6

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]

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DESCRIPTION:
 .635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

DWG. NO.

QSS-XXX-XX-XXX-D-RA-WT-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)

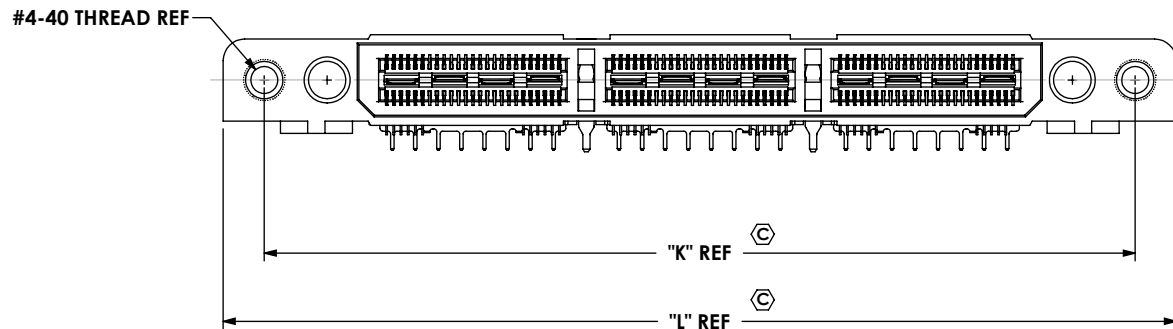
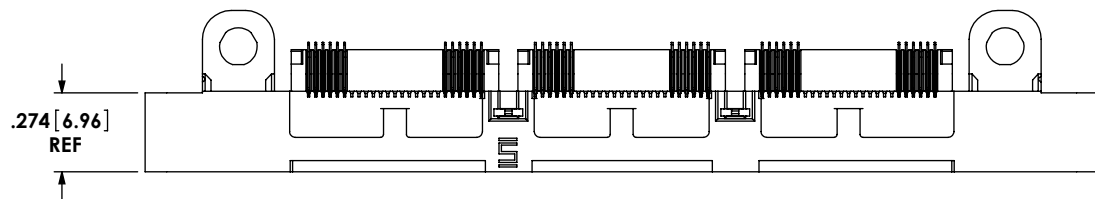


TABLE 7		
POSITION	"K"	"L"
-025	1.450 [36.82]	1.735 [44.06]
-050	2.237 [56.82]	2.522 [64.06]
-075	3.025 [76.82]	3.310 [84.06]
-100	3.812 [96.82]	4.097 [104.06]

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-L: 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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.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

DWG. NO.

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

BY: KEVIN B 01/22/02

SHEET 6 OF 6