


- 1.  REPRESENTS A CRITICAL DIMENSION.
- 2. MINIMUM CONTACT PUSHOUT FORCE: 0.5 LB.
- 3. MAXIMUM ALLOWABLE BOW .003[0.08] IN/IN AFTER ASSEMBLY.
- 4. FOR A 1 POSITION SINGLE ROW ALL SPACERS ARE TO BE LBS-S.
- 5. SPACERS SHALL BE ASSEMBLED AS SHOWN WITH SNAP GROOVES AWAY FROM SSW BODY.
- 6. SINGLE ROW, 33 POS PART TO USE 31 POS AND 2 POS SPACERS.
- 7. MAXIMUM CUT FLASH: .015.

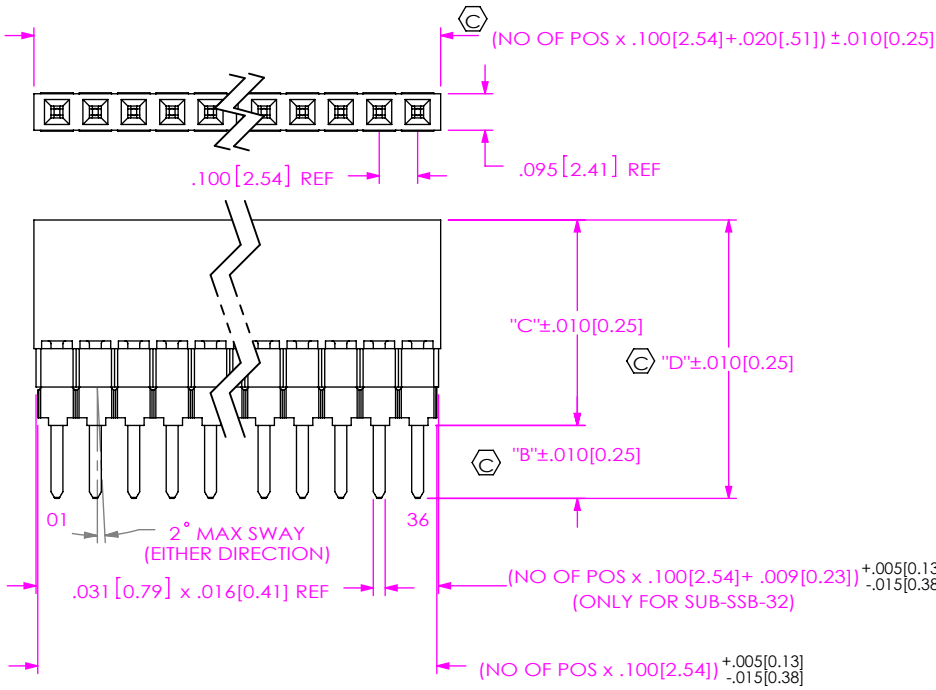


FIG 1  
ESW-1XX-XX-X-S SHOWN

TABLE 1						
STANDARD INSERTION FORCE	CONTACT	SPACER SPECIFICATION (SEE NOTE 4)		"B"	"C"	"D"
		ESW-S	ESW-D			
-12	C-8-2-X			.090 [2.29]	.435 [11.05]	.525 [13.34]
-13	C-8-3-X			.290 [7.37]	.435 [11.05]	.725 [18.42]
-14	C-8-5-X			.480 [12.19]	.435 [11.05]	.915 [23.24]
-23	C-8-3-X	(1) SUB-SSB-32	(1) DSB-XX	.190 [4.83]	.535 [13.59]	.725 [18.42]
-24	C-8-5-X	(1) SUB-SSB-32	(1) DSB-XX	.380 [9.65]	.535 [13.59]	.915 [23.24]
-33	C-8-3-X	(2) SUB-SSB-32	(2) DSB-XX	.090 [2.29]	.635 [16.13]	.725 [18.42]
-34	C-8-5-X	(2) SUB-SSB-32	(2) DSB-XX	.280 [7.11]	.635 [16.13]	.915 [23.24]
-44	C-8-5-X	(1) ESS-XX-S	(3) DSB-XX	.180 [4.57]	.735 [18.67]	.915 [23.24]
LOW INSERTION FORCE						
-37	C-17-2-X			.090 [2.29]	.435 [11.05]	.525 [13.34]
-38	C-17-3-X			.290 [7.37]	.435 [11.05]	.725 [18.42]
-39	C-17-5-X			.480 [12.19]	.435 [11.05]	.915 [23.24]
-48	C-17-3-X	(1) SUB-SSB-32	(1) DSB-XX	.190 [4.83]	.535 [13.59]	.725 [18.42]
-49	C-17-5-X	(1) SUB-SSB-32	(1) DSB-XX	.380 [9.65]	.535 [13.59]	.915 [23.24]
-58	C-17-3-X	(2) SUB-SSB-32	(2) DSB-XX	.090 [2.29]	.635 [16.13]	.725 [18.42]
-59	C-17-5-X	(2) SUB-SSB-32	(2) DSB-XX	.280 [7.11]	.635 [16.13]	.915 [23.24]
-69	C-17-5-X	(1) ESS-XX-S	(3) DSB-XX	.180 [4.57]	.735 [18.67]	.915 [23.24]

ESW-1XX-XX-X-X-XX-XX

**CONTACT STYLE**  
SOLDER TAIL  
STANDARD INSERTION USE C-8-X-X  
LOW INSERTION USE C-17-X-X  
(SEE TABLE 1)

**BODY LENGTH SPEC**  
POSITIONS 01 THRU 36 (SEE FIG 1)  
(SEE NOTE 4 FOR ONE POSITION  
SINGLE ROW)  
(FOR 33 POS, SEE NOTE 6)

**LEAD STYLE SPECIFICATION**  
(SEE TABLE 1)

**POLARIZING OPTION**  
INDICATES POS  
(SEE FIG 3, SHT 2)

**LOCKING LEAD OPTION**  
-LL (SEE FIG 4, SHT 2)  
(N/A ON 1 OR 2  
POSITION SINGLE ROW)

**ROW SPECIFICATION**  
-S: SINGLE (USE SSW-50-S)  
-D: DOUBLE (USE SSW-50-D)

**PLATING SPECIFICATION**

- G: 20µ" SELECTIVE GOLD IN CONTACT AREA,  
3µ" SELECTIVE GOLD ON TAIL.
- T: MATTE TIN ON ENTIRE PIN.  
(STANDARD INSERTION FORCE ONLY)
- S: 30µ" SELECTIVE GOLD IN CONTACT AREA,  
MATTE TIN ON TAIL.
- H: 30µ" SELECTIVE GOLD IN CONTACT AREA,  
3µ" SELECTIVE GOLD ON TAIL.
- F: 3µ" SELECTIVE GOLD IN CONTACT AREA,  
MATTE TIN ON TAIL.
- E: 50µ" SELECTIVE GOLD IN CONTACT AREA,  
3µ" SELECTIVE GOLD ON TAIL.
- L: 10µ" SELECTIVE GOLD IN CONTACT AREA,  
MATTE TIN ON TAIL.

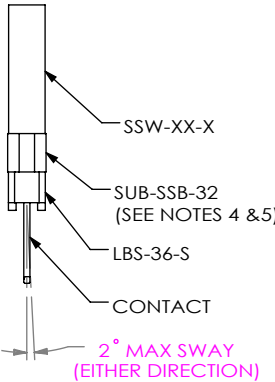


FIG 2  
ESW-1XX-XX-X-D SHOWN

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: 2:1  
SSW: LCP, UL 94 V0, COLOR: BLACK  
SSB, ESS, DSB: PBT, UL 94 V0, COLOR: BLACK  
LBS: HTN, UL 94 V0, COLOR: BLACK  
CONTACT: PHOS BRONZE



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

DESCRIPTION:  
ESW STRIP ASM.  
DWG. NO.  
ESW-1XX-XX-X-X-XX-XX  
BY: JORDAN 07/16/1985 SHEET 1 OF 2

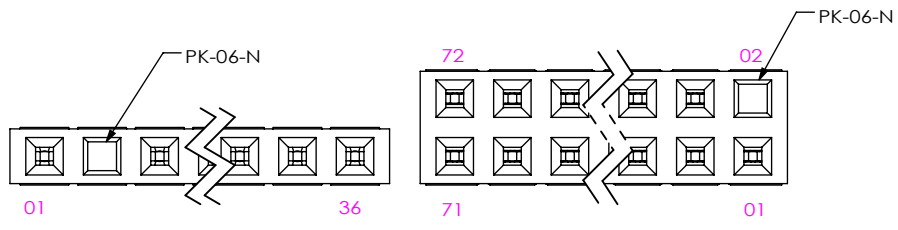


FIG 3  
POLARIZATION LOCATION  
INSERT PK-06-N INTO SPECIFIED POS AND BREAK OFF TAB  
(ESW-1XX-XX-X-X-02 SHOWN)  
(SAME AS FIG 1, DIFFERENT AS SHOWN)

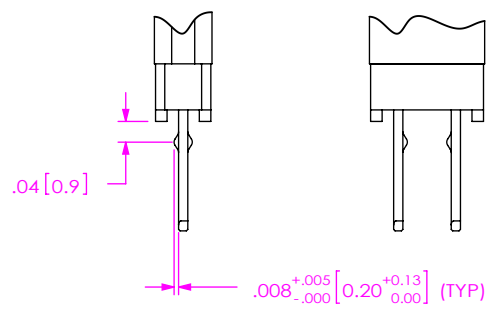


FIG 4  
LOCKING LEAD OPTION  
LOCATED ON OR ABOUT THE CENTERLINE  
(N/A IN 1 OR 2 POSITION SINGLE ROW)

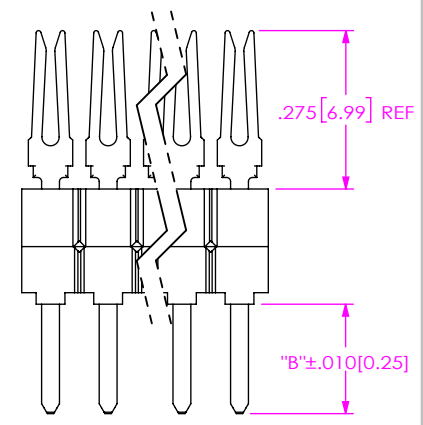


FIG 5  
IN PROCESS 'A'  
(LEAD STYLES -13, -14, -23, -24, -33, -34, -44, -38, -39, -48, -49, -58, -59, -69)

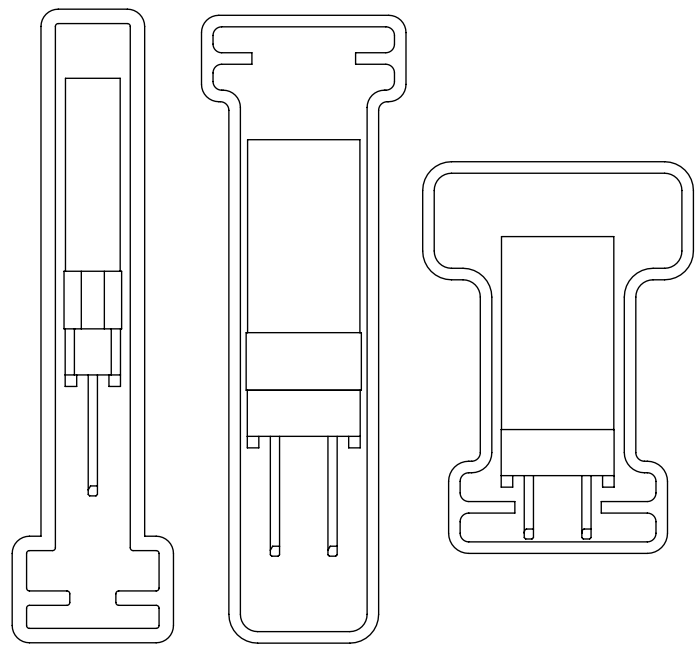


FIG 7  
TUBE VIEWS

NOTE:  
FOR -12 & -37 LEAD STYLES, TUBE PACKAGE -05 THRU -36 POSITIONS ONLY  
FOR -13, -23, -33, -38, -48 & -58 LEAD STYLES, TUBE PACKAGE -08 THRU -36 POSITIONS ONLY.  
FOR -14, -24, -34, -39, -44, -49, -59, & -69 LEAD STYLES TUBE PACKAGE -05 THRU -36 POSITIONS ONLY.

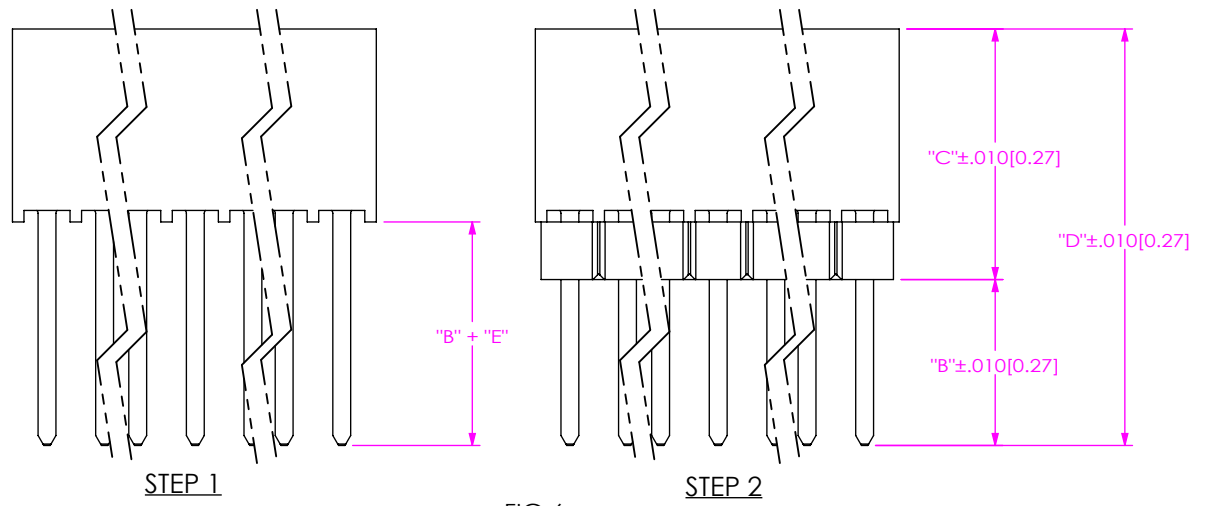


FIG 6  
IN PROCESS 'B'  
(LEAD STYLES -12 & -37)

STEPS:  
1. MACHINE FILL SSW-50-D TO 36 POS.  
2. MOUNT ESW-36-D.  
3. ROTO CUT TO POS. (SEE FIG 1)

TABLE 2			
LEAD STYLE	ROW	TUBE	PLUG
-12, -37	-S	PT-1-24-01-46	TP-24
-13, -14, -23, -24, -33, -34, -44, -38, -39, -48, -49, -58, -59, -69		PT-1-24-01-47	TP-09
-12, -37		PT-1-24-03-44	TP-07
-13, -14, -23, -24, -33, -34, -44, -38, -39, -48, -49, -58, -59, -69	-D	PT-1-24-02-47	TP-07

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DO NOT SCALE DRAWING

SHEET SCALE: 3:1



DESCRIPTION:  
ESW STRIP ASM.

DWG. NO.  
ESW-1XX-XX-X-X-XX-XX

BY: JORDAN 07/16/1985 SHEET 2 OF 2