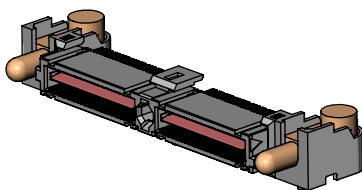


DO NOT
SCALE FROM
THIS PRINT

QMS-XXX-XX-XX-D-RA-XX-XXX-XX

No OF POSITIONS

-026, -052, -078, -104
(PER ROW)

LEAD STYLE

-01: .062[1.57] BOARD
-02: .093[2.36] BOARD

PACKAGING OPTION

-TR: TAPE & REEL PACKAGING
(-026 & -052 WITH NO OPTIONS)
(-026 & -052 WITH -PC4)
(-026 WITH -PC8)

OPTION

-K: KAPTON PAD (USE K-850-650)
-PC4: 4 POWER PINS
(SEE FIG. 2, SHEET 5)
(NOT AVAILABLE WITH -104 POS)
(NOT AVAILABLE WITH -MG)
-PC8: 8 POWER PINS
(SEE FIG. 3, SHEET 5)
(NOT AVAILABLE WITH -104 POS)
(NOT AVAILABLE WITH -MG)

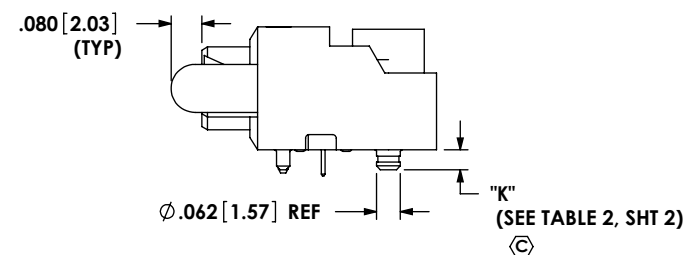
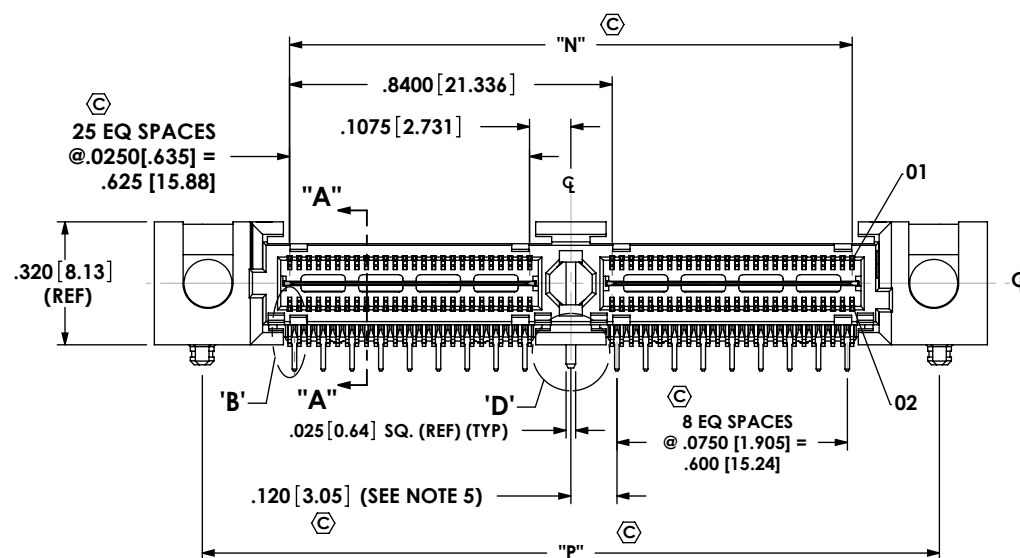
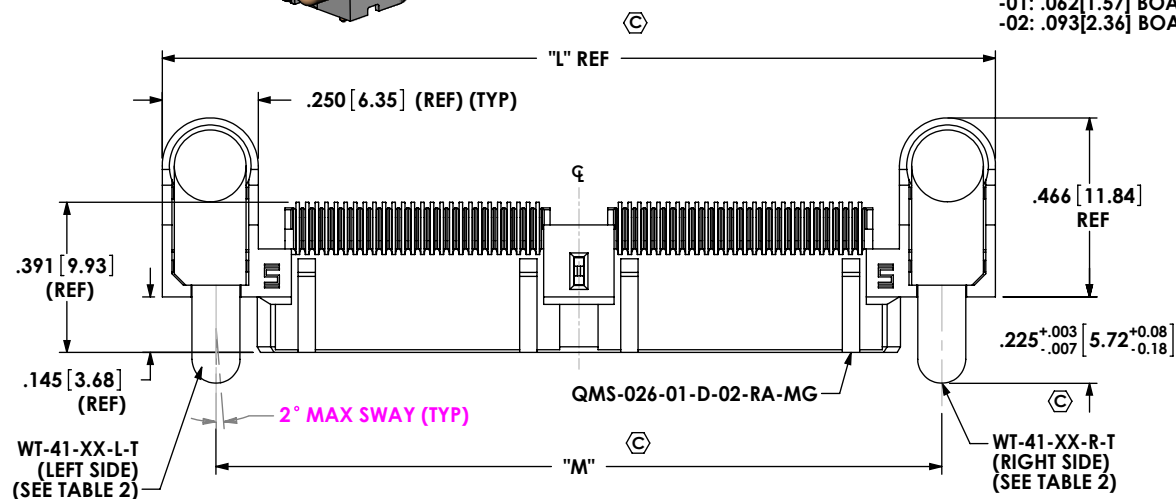
GUIDE POST

-MG: METAL GUIDE POST
(LEAVE BLANK FOR PLASTIC OR PCX.
PLASTIC AVAILABLE AS ASO ONLY.)

-RA: RIGHT ANGLE

ROW SPECIFICATION

-D: DOUBLE (USE QMS-XXX-01-D-XX-RA)

PLATING SPECIFICATION
(SEE TABLE 6, SHEET 4)-SL: 10μ" GOLD IN CONTACT AREA, MATTE TIN TAIL
-S: 30μ" GOLD IN CONTACT AREA, MATTE TIN TAIL
-L: 10μ" GOLD IN CONTACT AREA, 3μ" GOLD ON TAIL
-H: 30μ" GOLD IN CONTACT AREA, 3μ" GOLD ON TAILFIG. 1
(QMS-052-XX-XX-D-RA-MG SHOWN)

NOTES:

1. Ⓢ REPRESENTS A CRITICAL DIMENSION.
2. BURR ALLOWANCE: .0010 [0.02] MAX.
3. MINIMUM PUSHOUT FORCE: SIGNAL: .5 LB. [2.22N] SHIELD/GROUND, POWER PIN, COUNTERWEIGHT AND METAL GUIDE POST: 1 LB. [4.45N]
4. PARTS TO BE PACKAGED IN TRAYS AS STANDARD.
5. DOES NOT APPLY TO 1 BANK.
6. WT-28-XX-T NOT PRESENT ON SINGLE BANK WITH THE -MG OPTION
7. 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: 2:1

INSULATOR: LCP, COLOR BLACK

CONTACT, POWER PIN, & GROUND PLANE: PHOS BRONZE
COUNTERWEIGHT: BRASS
METAL GUIDE POST: ZINC

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

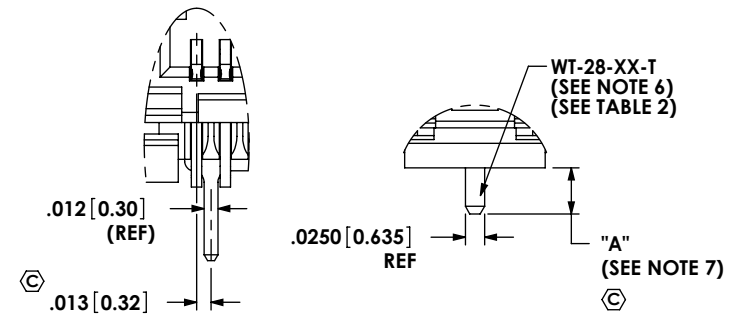
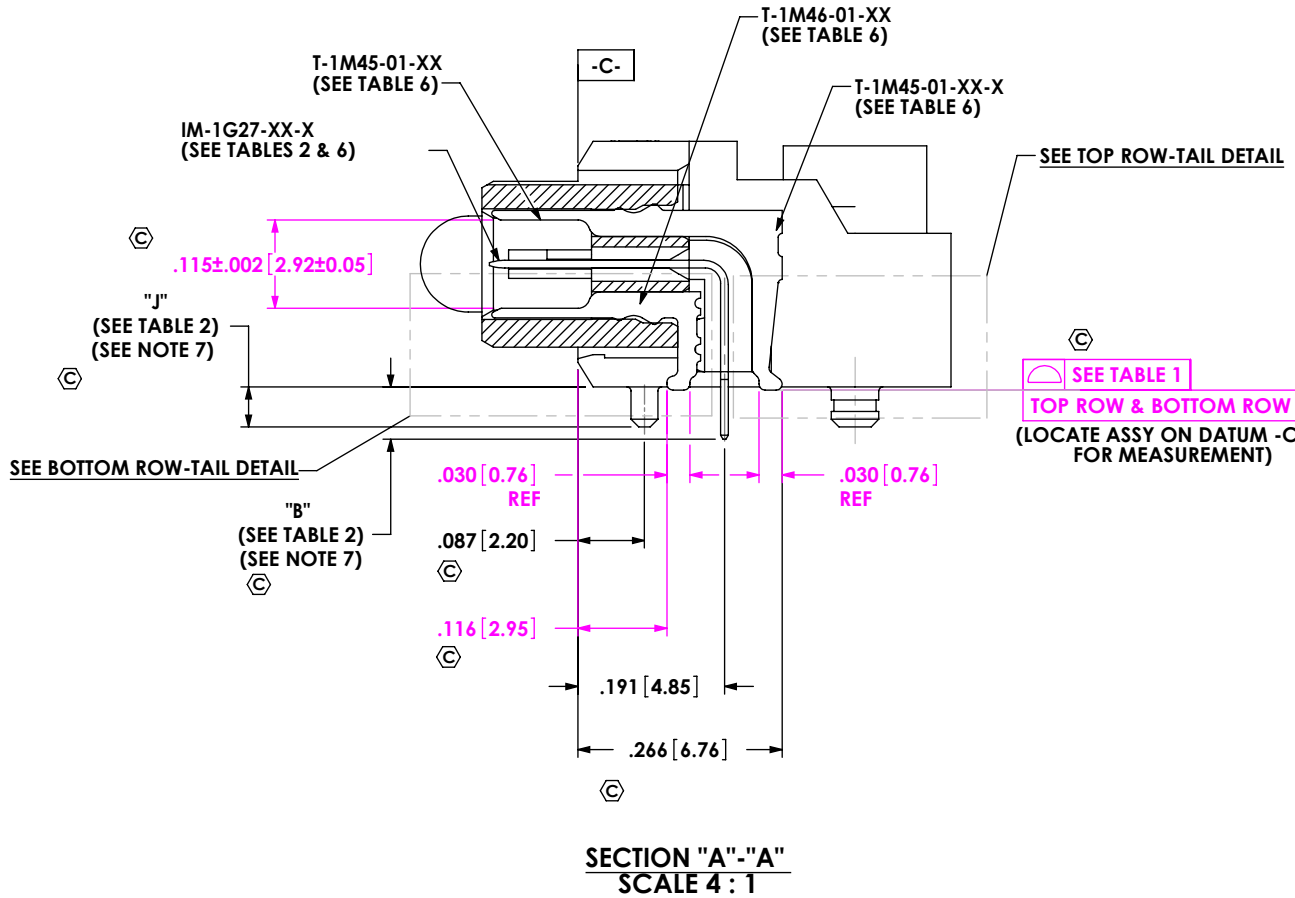
520 PARK EAST BLVD, NEW ALBANY, IN 47150
PHONE: 812-944-6733 FAX: 812-948-5047
e-Mail info@SAMTEC.com code 55322

DESCRIPTION: .635mm DUAL ROW RIGHT ANGLE PLUG ASSEMBLY

DWG. NO.

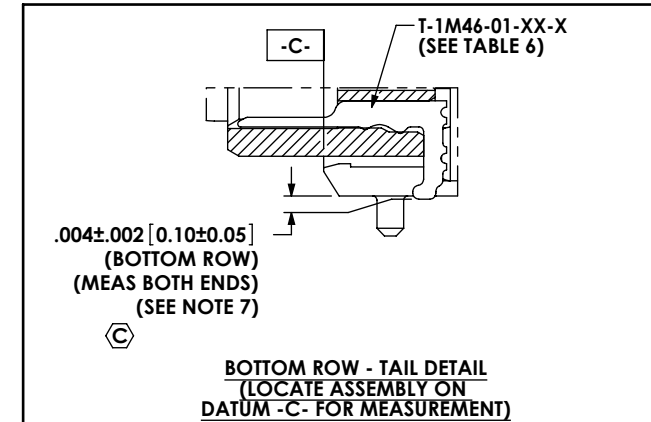
QMS-XXX-XX-XX-D-RA-XX-XXX-XX

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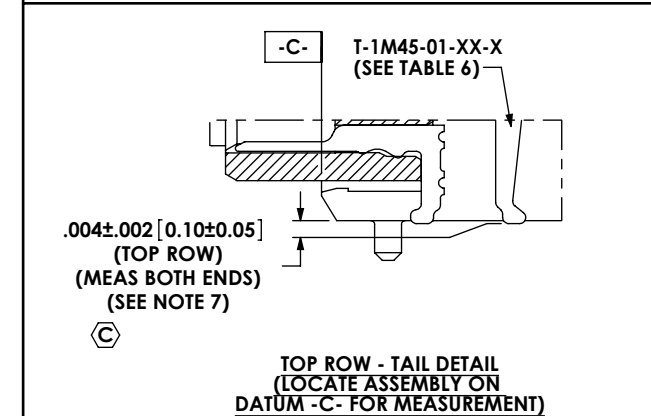


DETAIL 'B'

DETAIL 'D'
SCALE 4:1



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



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

TABLE 1

No OF POSITIONS	COPLANARITY	STRAIGHTNESS ROW 1	STRAIGHTNESS ROW 2
-026 THRU -052	.004[.10]	.004[.10]	.004[.10]
-078 THRU -104	.006[.15]	.006[.15]	.006[.15]

TABLE 2

LEAD STYLE	"A"	"B"	"C"	"J"	"K"	WT-28-XX-T	IM-1G27-XX-L	T-1R37-XX-T	WT-41-XX-X-T
-01	.060 [1.52]	.068 [1.73]	.055 [1.40]	.052 [1.32]	.052 [1.32]	WT-28-01-T	IM-1G27-01-L	T-1R37-01-T	WT-41-01-X-T
-02	.091 [2.31]	.099 [2.51]	.086 [2.18]	.083 [2.11]	.083 [2.11]	WT-28-02-T	IM-1G27-02-L	T-1R37-02-T	WT-41-02-X-T

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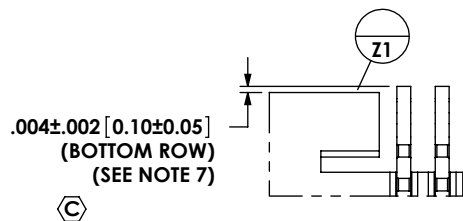
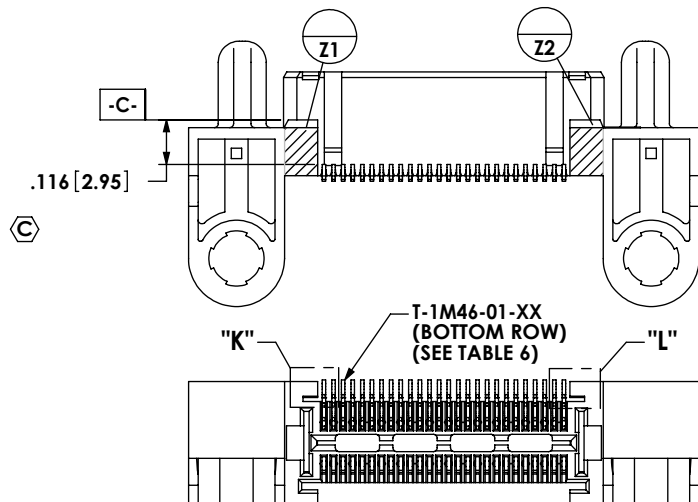
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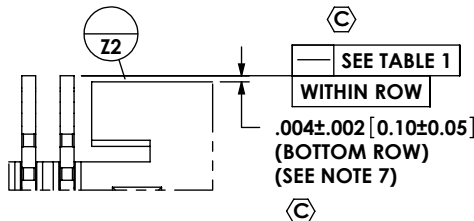
BY: KNOWLDEN 8/25/2006

SHEET 2 OF 6

INSPECTION VIEW 1
(FILL BOTTOM ROW)

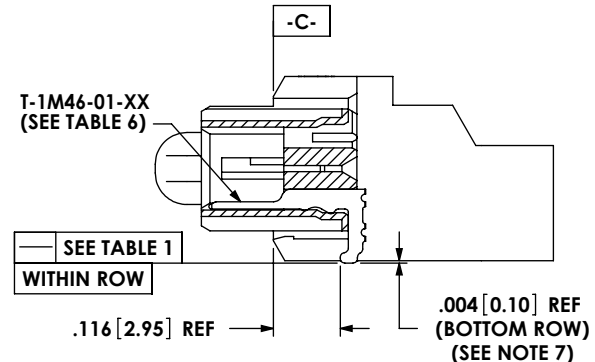
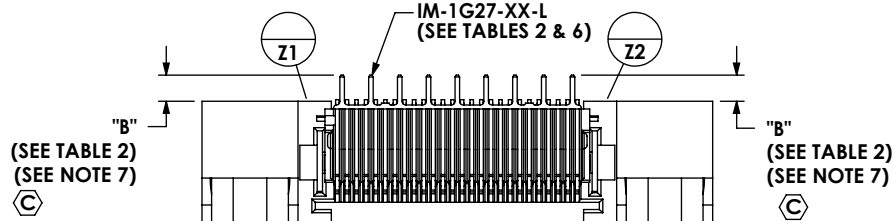
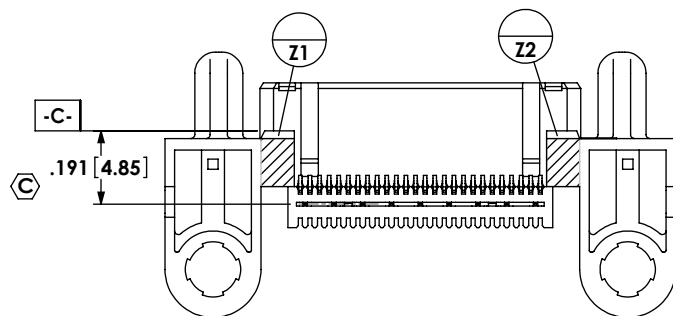


DETAIL "K"
SCALE 8 : 1

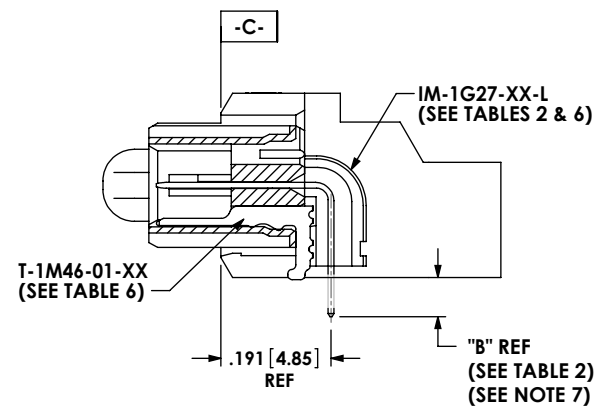


DETAIL "L"
SCALE 8 : 1

INSPECTION VIEW 2
(FILL IM-1G27)



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



IN-PROCESS 2
(FILL IM-1G27)
(SEE INSPECTION VIEW 2 FOR ORIENTATION AND CPC'S)

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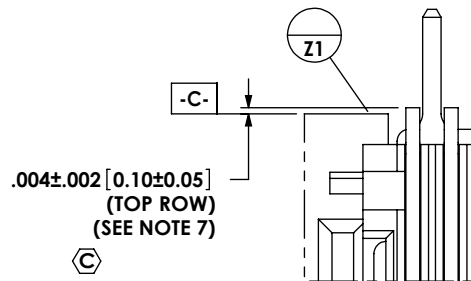
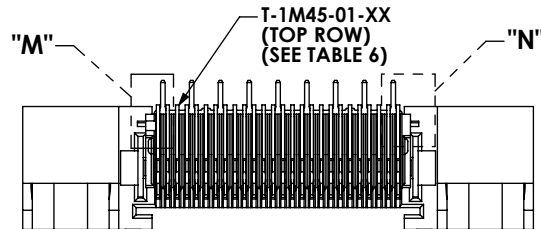
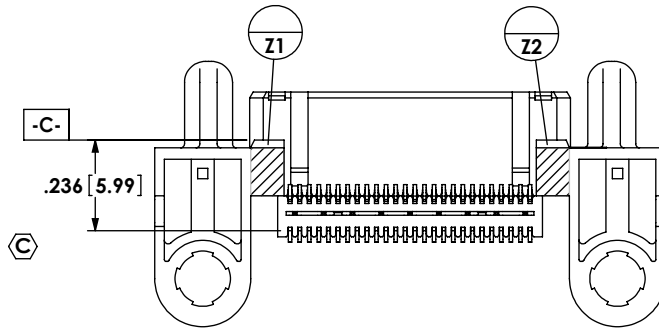
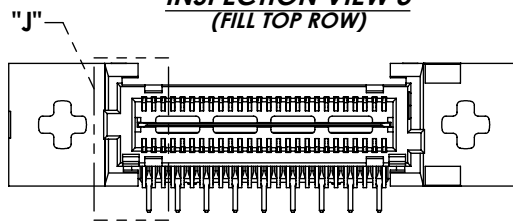
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e-Mail info@SAMTEC.com code 55322

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.635mm DUAL ROW RIGHT ANGLE PLUG ASSEMBLY

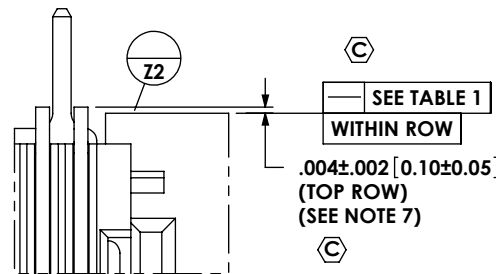
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QMS-XXX-XX-XX-D-RA-XX-XXX-XX

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INSPECTION VIEW 3
(FILL TOP ROW)



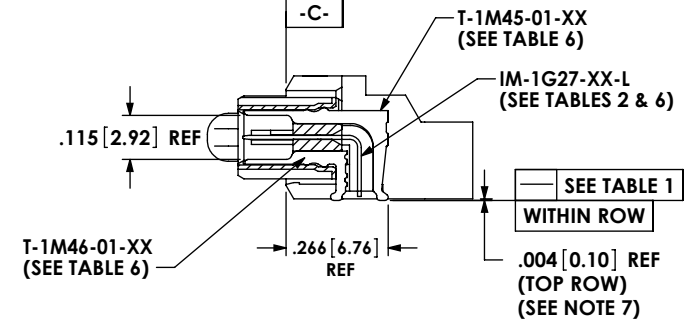
DETAIL "M"
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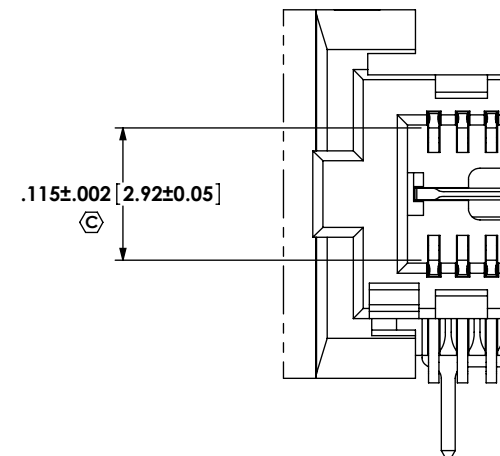
DETAIL "N"
SCALE 8 : 1

TABLE 6: PLATING SPECIFICATIONS

	CONTACT	CONTACT	GROUND PLANE	PCX CONTACTS
-SL	T-1M45-01-SL: 10μ" GOLD CONTACT, MATTE TIN TAIL	T-1M46-01-SL: 10μ" GOLD CONTACT, MATTE TIN TAIL	IM-1G27-XX-L: 10μ" GOLD CONTACT, MATTE TIN TAIL	T-1S69-XX-SL: 10μ" GOLD CONTACT, MATTE TIN TAIL
-S	T-1M45-01-S: 30μ" GOLD CONTACT, MATTE TIN TAIL	T-1M46-01-S: 30μ" GOLD CONTACT, MATTE TIN TAIL	IM-1G27-XX-L: 10μ" GOLD CONTACT, MATTE TIN TAIL	T-1S69-XX-S: 30μ" GOLD CONTACT, MATTE TIN TAIL
-L	T-1M45-01-L: 10μ" GOLD CONTACT, 3μ" GOLD TAIL	T-1M46-01-L: 10μ" GOLD CONTACT, 3μ" GOLD TAIL	IM-1G27-XX-L: 10μ" GOLD CONTACT, MATTE TIN TAIL	T-1S69-XX-SL: 10μ" GOLD CONTACT, MATTE TIN TAIL
-H	T-1M45-01-H: 30μ" GOLD CONTACT, 3μ" GOLD TAIL	T-1M46-01-H: 30μ" GOLD CONTACT, 3μ" GOLD TAIL	IM-1G27-XX-L: 10μ" GOLD CONTACT, MATTE TIN TAIL	T-1S69-XX-S: 30μ" GOLD CONTACT, MATTE TIN TAIL



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



DETAIL "J"
SCALE 6:1

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.635mm DUAL ROW RIGHT ANGLE PLUG ASSEMBLY

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

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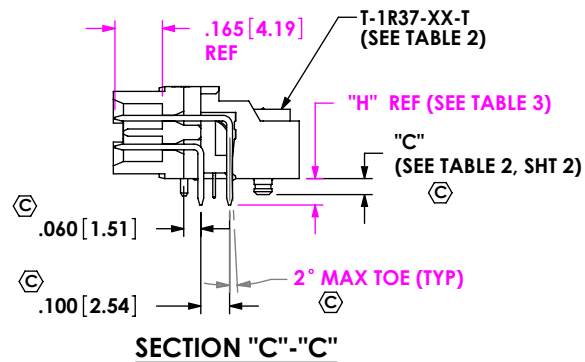
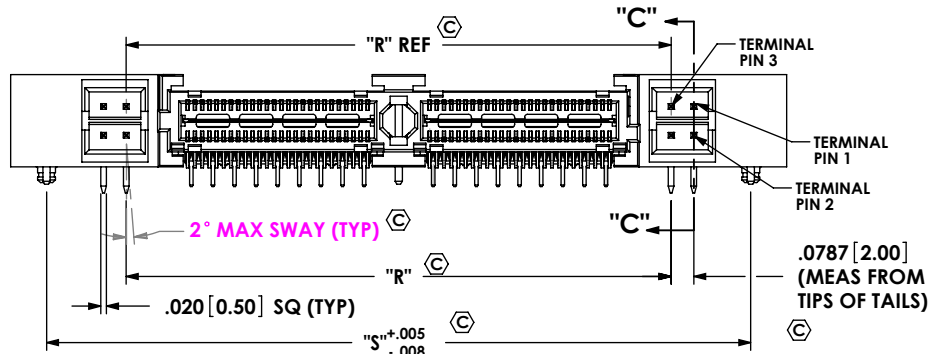
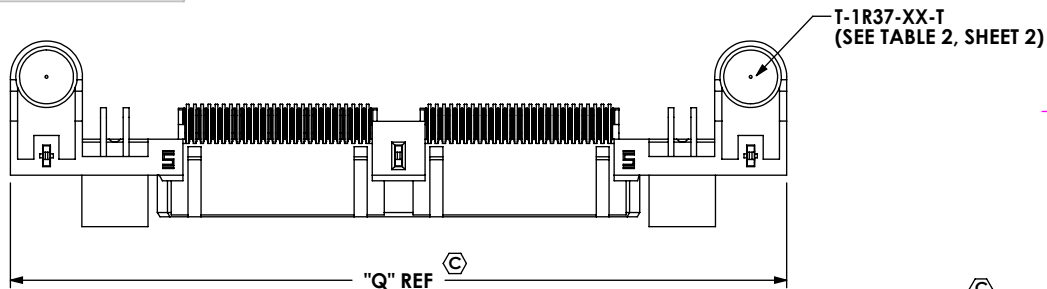
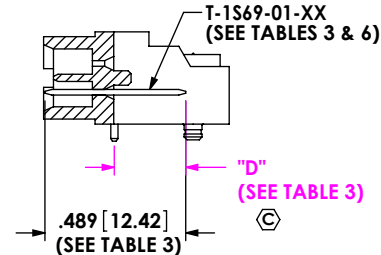
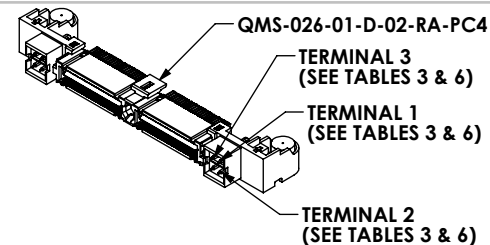
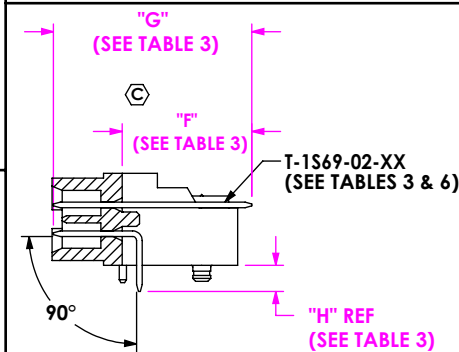


FIG 2
(QMS-052-XX-XX-D-RA-PC4 SHOWN)
(SAME AS FIG 1, DIFFERENT AS SHOWN)

TABLE 3							
LEAD STYLE	TERMINAL 1	TERMINAL 2	"D"	"E"	"F"	"G"	"H"
-01	T-1S69-01-XX	T-1S69-02-XX	.250 [6.35]	.489 [12.42]	.480 [12.19]	.689 [17.50]	.091 [2.31]
-02	T-1S69-03-XX	T-1S69-04-XX	.281 [7.14]	.520 [13.21]	.481 [12.22]	.720 [18.29]	.122 [3.10]



IN-PROCESS 4



IN-PROCESS 5

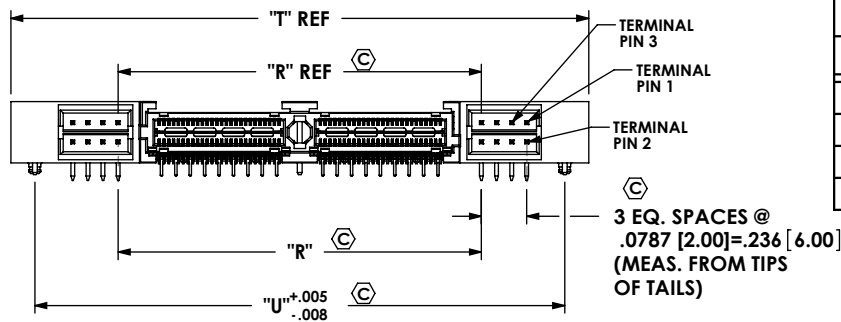
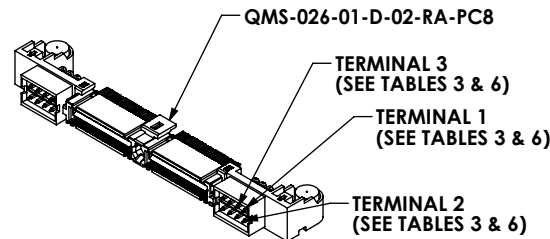
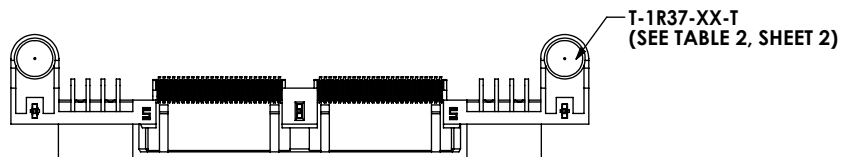


FIG 3
(QMS-052-XX-XX-D-RA-PC8 SHOWN)
(SAME AS FIG 2, DIFFERENT AS SHOWN)

TABLE 7							
POSITION	"Q"	"R"	"S"	"T"	"U"	"V"	"W"
-026	1.855 [47.12]	1.052 [26.72]	1.605 [40.77]	2.170 [55.12]	1.920 [48.77]	1.050 [26.67]	1.080 [27.43]
-052	2.695 [68.45]	1.892 [48.06]	2.445 [62.10]	3.010 [76.45]	2.760 [70.10]	1.890 [48.01]	1.920 [48.77]
-078	3.535 [89.79]	2.732 [69.39]	3.285 [83.44]	3.850 [97.79]	3.600 [91.44]	2.730 [69.34]	2.760 [70.10]
-104	4.375 [111.13]	3.572 [90.73]	4.125 [104.78]	4.690 [119.13]	4.440 [112.78]	3.570 [90.68]	3.600 [91.44]

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DESCRIPTION:
.635mm DUAL ROW RIGHT ANGLE PLUG ASSEMBLY

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

BY: KNOWLDEN 8/25/2006 SHEET 5 OF 6

REVISION W

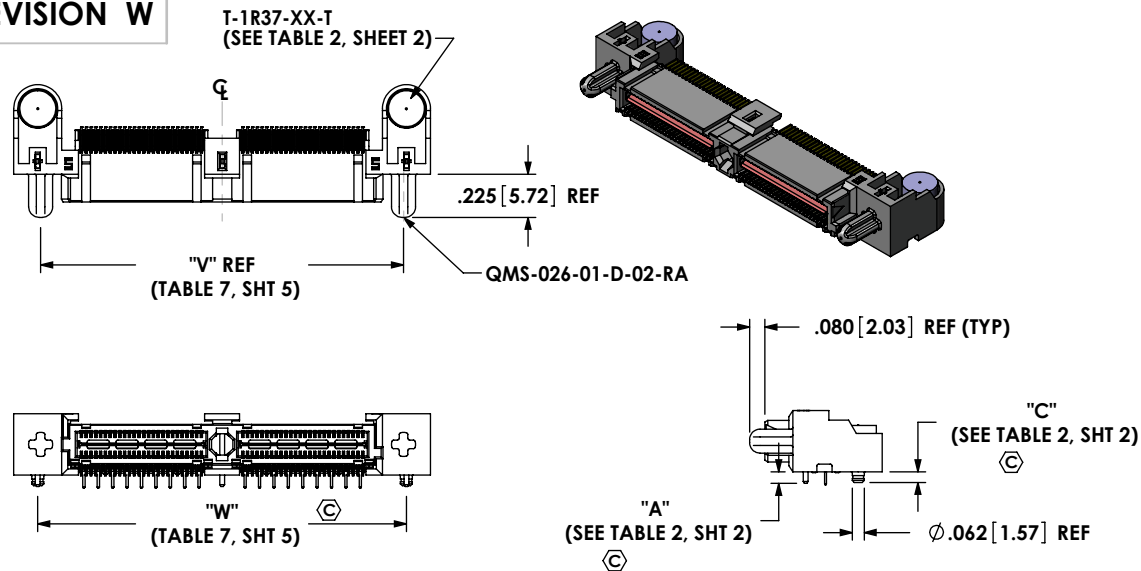
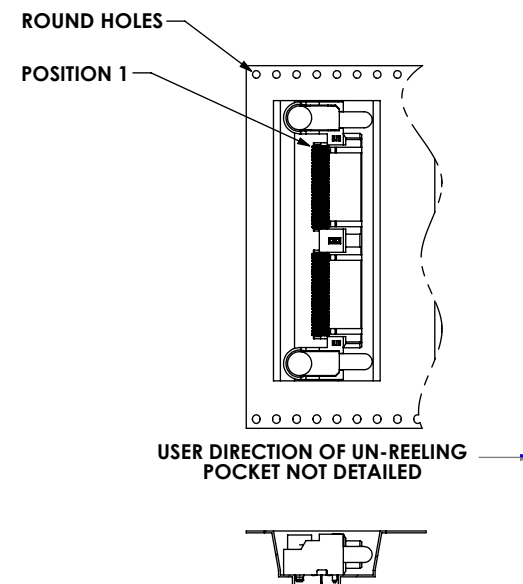


FIG 4
(QMS-052-01-XX-D-RA SHOWN)
(SAME AS FIG 1, DIFFERENT AS SHOWN)
AVAILABLE AS ASO ONLY

PACKAGING VIEW -TR: TAPE & REEL OPTION (QMS-052-01-XX-D-RA-MG-TR SHOWN)



-K: KAPTON PAD QMS-026-01-XX-D-RA-MG-K SHOWN (USE K-850-650) (FOR 1 AND 3 BANKS ONLY)

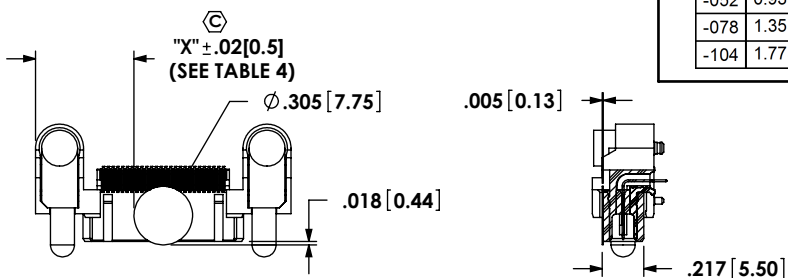
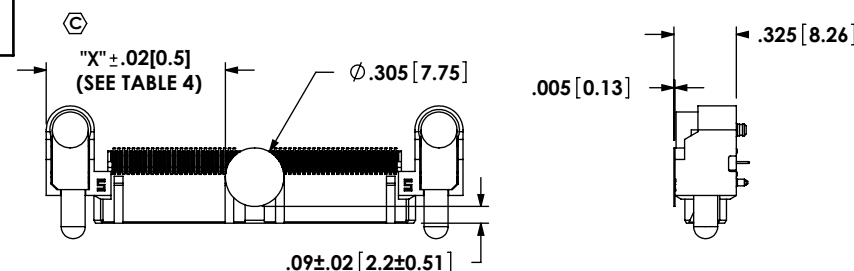


TABLE 4				
	STANDARD & -MG	-PC4	-PC8	
POS.	"X"			
-026	0.513 [13.03]	0.776 [19.71]	0.934 [23.71]	
-052	0.933 [23.70]	1.196 [30.38]	1.354 [34.38]	
-078	1.353 [34.37]	1.616 [41.05]	1.774 [45.05]	
-104	1.773 [45.03]	2.036 [51.71]	2.194 [55.71]	

-K: KAPTON PAD QMS-052-01-XX-D-RA-MG-K SHOWN (USE K-850-650) (FOR 2 AND 4 BANKS ONLY)



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

BY: KNOWLDEN 8/25/2006 SHEET 6 OF 6