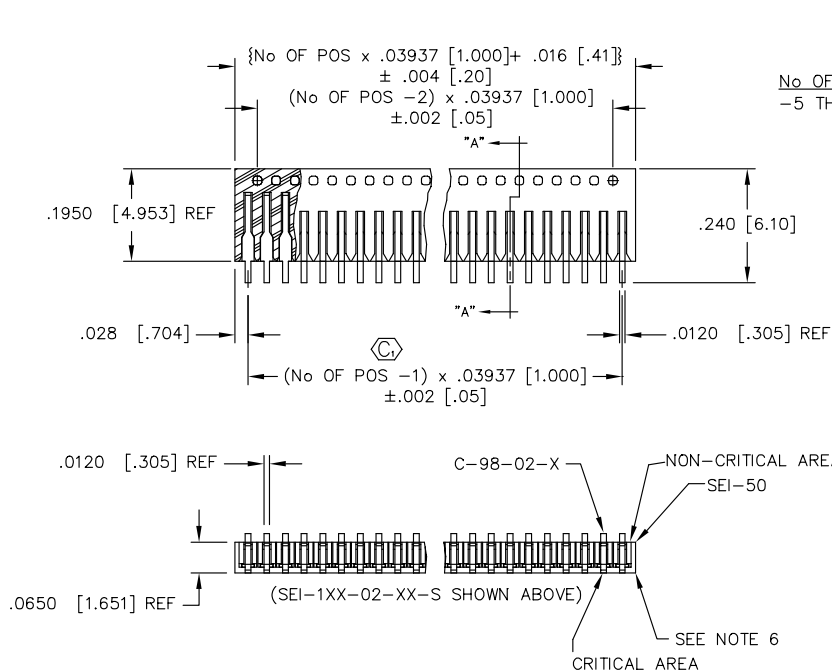


REV. U

DO NOT SCALE  
FROM THIS PRINT

| DIMENSIONS ARE IN INCHES         |                                       | UNLESS OTHERWISE NOTED | TOLERANCES ARE: |
|----------------------------------|---------------------------------------|------------------------|-----------------|
| ONE PLACE DECIMALS $\pm 1[2.5]$  | THREE PLACE DECIMALS $\pm .005[.13]$  | ANGLES $\pm 5^\circ$   |                 |
| TWO PLACE DECIMALS $\pm .01[.3]$ | FOUR PLACE DECIMALS $\pm .0020[.051]$ |                        |                 |

TITLE:  
1mm SINGLE  
ELEMENT INTERFACEDWG NO:  
SEI-1XX-02-XX-S-X-XX-XX  
SHEET 1 OF 2

SEI-1XX-02-XX-S-X-XX-XX

No OF POSITIONS  
-5 THRU -30

LEAD STYLE  
(USE C-98-02-X)

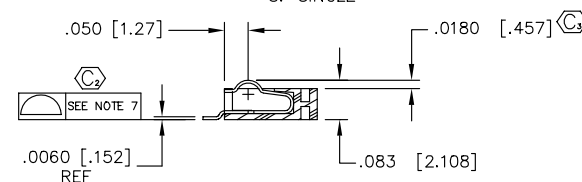
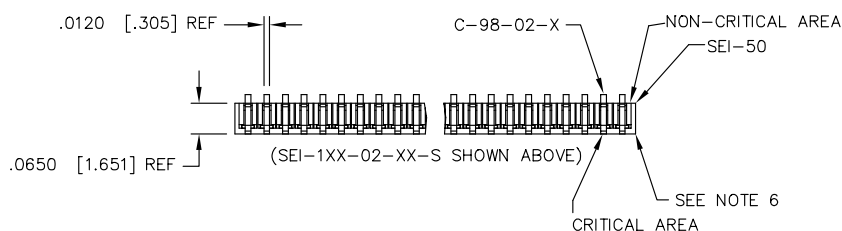
PLATING SPEC  
-GF: FLASH GOLD  
-G: LIGHT GOLD

OPTION  
-TR

ALIGNMENT PIN LOCATION  
-AT: TOP SIDE  
-AB: BOTTOM SIDE  
(5 & 10 POS ONLY. USE SM-A9-H)  
(USE SM-A9 FOR ALL OTHER ALIGNMENT OPTIONS)  
(MOLDED TO POSITIONS A.P. FOR LARGE QTY'S)

THREADED INSERT OPTION (IF BLANK, SEI-50)  
-E: THREADED INSERT, ENGLISH (USE SEI-XX-T)  
-M: THREADED INSERT, METRIC (USE SEI-XX-T)

ROW OPTION  
-S: SINGLE



SECT "A-A"  
(ROTATED 90°)  
NOTES:

1.  $\odot$  REPRESENTS A CRITICAL DIMENSION.
2. MINIMUM PUSHOUT FORCE: 6 OZ.
3. LOAD INSERTS IN DIRECTION OF ARROW. (-M INSERTED FROM TOP; -E INSERTED FROM BOTTOM)
4. PACKAGE ALL POSITIONS IN A PT-1-24-01-68 WITH TWO TP-12 PLUGS PER TUBE.
5. THREADED INSERT MUST BE ABLE TO HANDLE 20 IN-OZ'S OF TORQUE MIN (WITHOUT ROTATING OR "LOOSENING").
6. NO CUT FLASH IN CRITICAL AREAS AS SHOWN. .010" MAX CUT FLASH IN NON-CRITICAL AREAS, AS SHOWN.
7. CO-PLANARITY FOR POS. -10 THRU -25 .004" MAX. FOR POS. -26 THRU -30 .006 MAX. CO-PLANARITY IS THE PLANE FORMED BY THE BOTTOM OF THE BODY & THE BOTTOM OF THE CONTACT.
8. USE SM-A9 FOR ALL ALIGNMENT OPTIONS EXCEPT 5 & 10 POSITIONS ONLY USE SM-A9-H.
9. BODIES MAY BE USED MTP WITH OR WITHOUT ALIGNMENT PINS AT PURCHASING DISCRETION.
10. OPERATORS ORIENTATE INSULATORS IN CUTTING TOOL BODIES LOADED WITH FINS OF INSULATOR DOWN AND TOWARD OPERATOR.

PLOT SCALE 1 = .188

EXISPROD/ASSEMBLY/1MM  
SEI-ASM

**samtec**

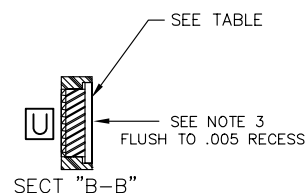
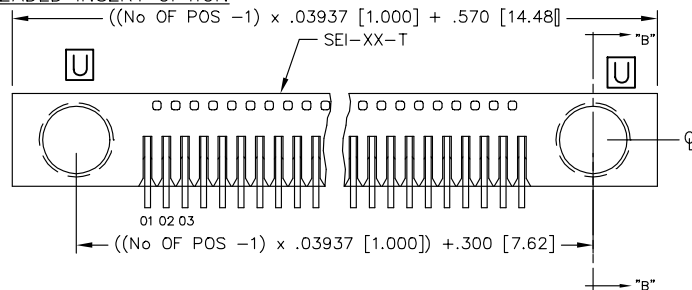
520 PARK EAST BLVD. NEW ALBANY, INDIANA 47150  
PHONE (812) 944-6733 P.O. BOX 1147  
CODE 55322

MADE BY:

D. PURVIS 12-11-96

SEI-1XX-02-XX-S-X-XX-XX  
SHEET 1 OF 2

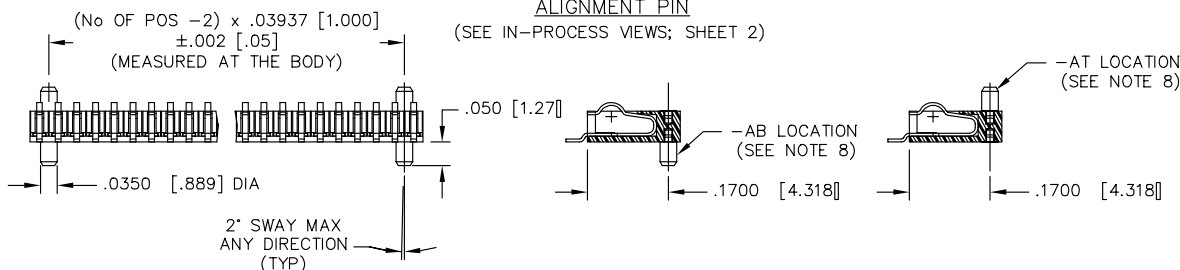
## THREADED INSERT OPTION



| OPTION | INSERT      | THREAD   |
|--------|-------------|----------|
| -E     | INSL-2-56-X | 2 x 56   |
| -M     | INSL-M2-4-N | M2.0 x 4 |

## ALIGNMENT PIN

(SEE IN-PROCESS VIEWS; SHEET 2)



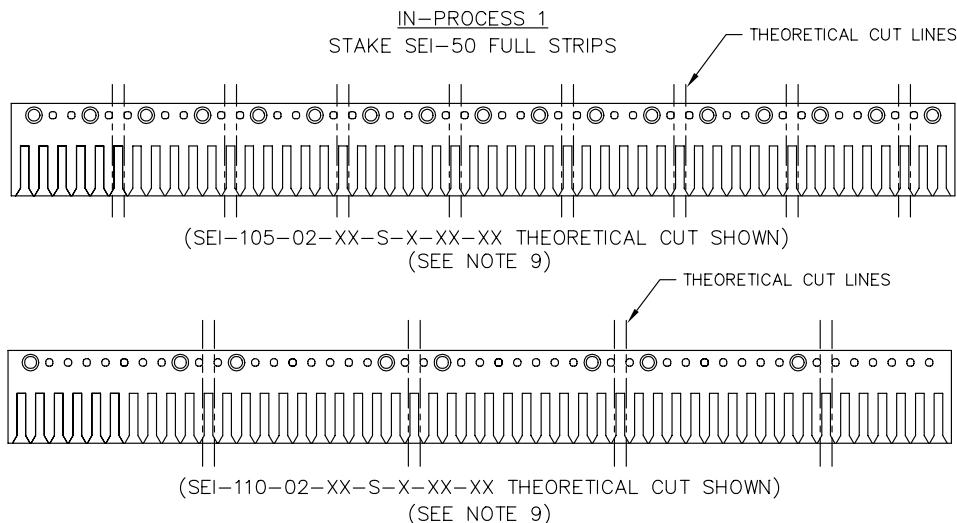
## PROPRIETARY NOTE

THIS DOCUMENT CONTAINS INFORMATION CONFIDENTIAL AND PROPRIETARY TO SAMTEC INC. AND SHALL NOT BE REPRODUCED OR TRANSMITTED TO OTHER DOCUMENTS OR DISCLOSED TO OTHERS OR USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS OBTAINED WITHOUT THE EXPRESSED WRITTEN CONSENT OF SAMTEC INC.

2" SWAY MAX  
ANY DIRECTION  
(TYP)

REV U

FIG. 1  
IN-PROCESS FOR STAKED ALIGNMENT PINS  
(105 & 110 POSITION ONLY)

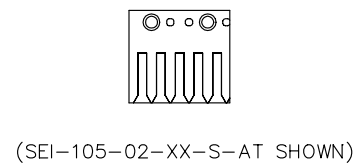


UNLESS OTHERWISE NOTED  
DIMENSIONS ARE IN INCHES  
TOLERANCES ARE:  
ONE PLACE DECIMALS  $\pm 1[2.5]$  THREE PLACE DECIMALS  $\pm .005[.13]$   
TWO PLACE DECIMALS  $\pm .01[.3]$  FOUR PLACE DECIMALS  $\pm .0020[.051]$   
ANGLES  $\pm 5^\circ$

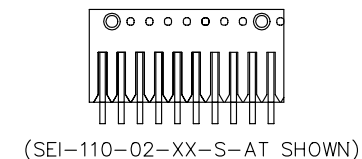
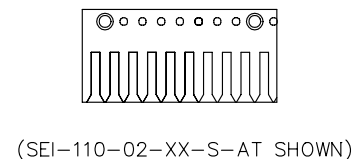
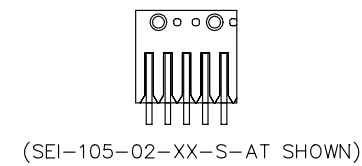
TITLE:  
1mm SINGLE  
ELEMENT INTERFACE

DWG NO:  
SEI-1XX-02-XX-S-X-XX-XX  
SHEET 2 OF 2

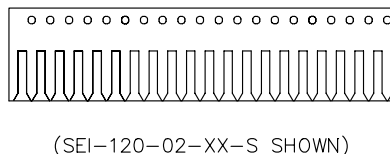
IN-PROCESS 2  
RotoCut TO POSITION



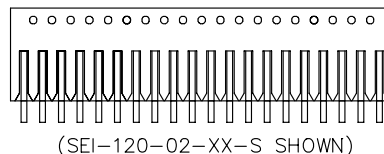
IN-PROCESS 3  
LOAD CONTACTS



IN-PROCESS 1  
RotoCut TO POSITION



IN-PROCESS 2  
LOAD CONTACTS



IN-PROCESS 3  
STAKE PER CUT STRIP

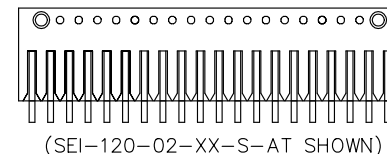
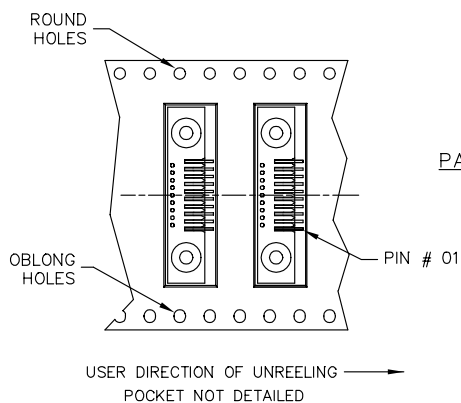
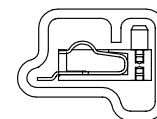


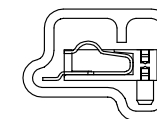
FIG. 2  
IN-PROCESS FOR STAKED ALIGNMENT PINS  
(ALL POSITIONS EXCEPT 105 & 110)



PACKAGING VIEWS



TUBE VIEW  
PT-1-24-01-68  
TP-12  
(SEI-XX-02-XX-S-X-XX-AT SHOWN)



TUBE VIEW  
PT-1-24-01-68  
TP-12  
(SEI-XX-02-XX-S-X-XX-AB SHOWN)

**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 FOR WHICH IT WAS  
OBTAINED WITHOUT THE EXPRESSED  
WRITTEN CONSENT OF SAMTEC INC.

T & R VIEW

**samtec**

520 PARK EAST BLVD. NEW ALBANY, INDIANA 47150  
PHONE (812) 944-6733 P.O. BOX 1147  
CODE 55322

MISC\MKTG  
SEI-MKT2

MADE BY:  
T.WERNE 02-01-01

SEI-1XX-02-XX-S-X-XX-XX  
SHEET 2 OF 2