

DO NOT
SCALE FROM
THIS PRINT

- NOTES:
1. MIN CONTACT PUSHOUT: 1.5 LBS
 2. FOR A 1 POSITION SINGLE ROW
ALL SPACERS ARE TO BE TSW-XX-S
 3. SPACERS SHALL BE ASSEMBLED AS SHOWN
WITH SNAP GROOVES AWAY FROM SSW BODY.
 4. MAX ALLOWABLE BOW .003 INCH/INCH AFTER ASSMBLY
 5. DO NOT USE DSB SPACER BODY FOR THIS OPTION.
 6. MAX CUT FLASH : .010

CONTACT STYLE
SQUARE TAIL: USE C-15-X-X
LOW INSERTION FORCE: C-60-X-X
(SEE TABLE 1, SHT 2)

NO. OF POSITIONS
POSITIONS 01 THRU 36
(SEE FIG1)
FOR A ONE POSITION
SINGLE ROW SEE NOTE 2

LEAD STYLE
(SEE TABLE 1, SHT 2)

PLATING SPECIFICATION

-G: 20μ" GOLD IN CONTACT AREA, 3μ" GOLD TAIL
-T: MATTE TIN CONTACT AND TAIL
-S: 30μ" SELECTIVE GOLD IN CONTACT AREA, MATTE TIN TAIL
-H: 30μ" HEAVY GOLD IN CONTACT AREA, 3μ" GOLD TAIL
-L: 10μ" SELECTIVE LIGHT GOLD IN CONTACT AREA, MATTE TIN TAIL

ESQ-1XX-XX-X-X-XXX-XX-X-XX

*SEE NOTE 6

METAL WASHER OPTION
#* -H-MW: (SEE FIG 3, SHT 2)
(N/A ON TRIPLE ROW)
(.300 [7.62] MAX TAIL)
(AVAILABLE ON POS
-02 THRU -32 ONLY)

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

POLARIZATION OPTION
INDICATES POSITION (SEE FIG 4, SHT 2)

ROW SPECIFICATION (SEE TABLE 1, SHT 2)
-S: SINGLE (USE SSW-50-S)
-D: DOUBLE (USE SSW-50-D)
-T: TRIPLE (USE SSW-50-T)

#-MW OPTION, DO NOT DESIGN IN. SAMTEC WILL
ONLY SUPPORT EXISTING BUSINESS 2/12/02

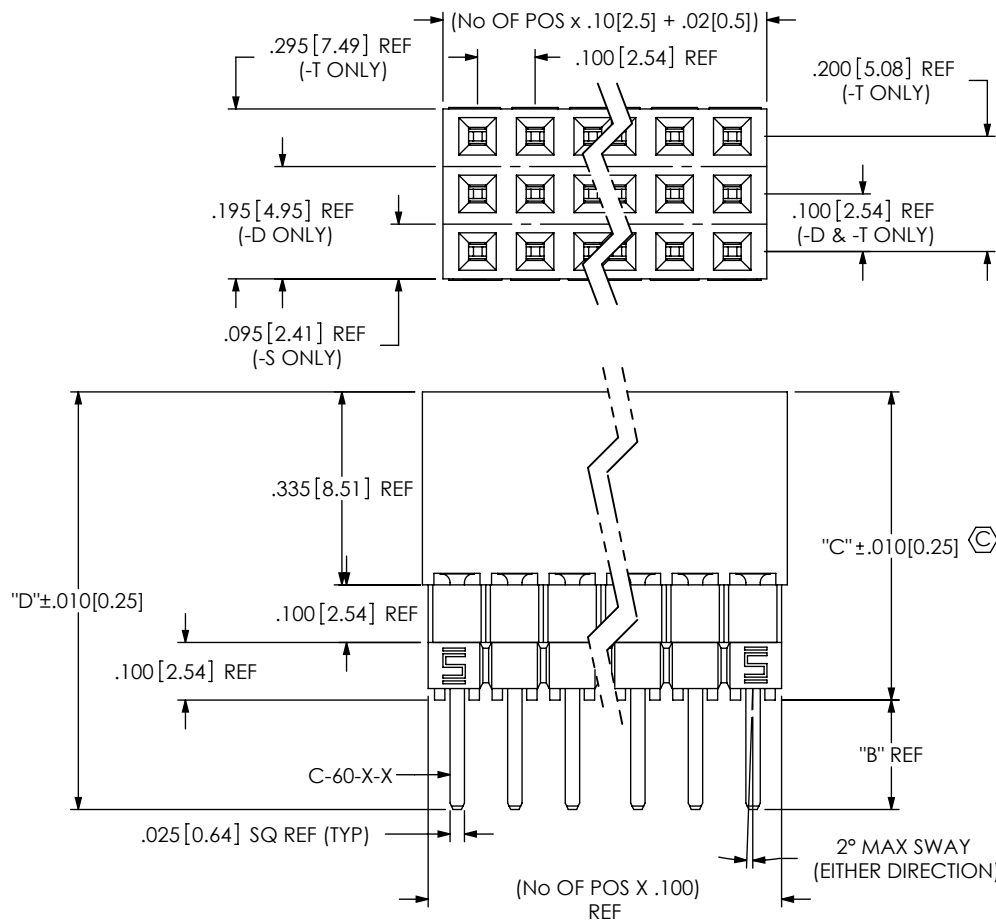
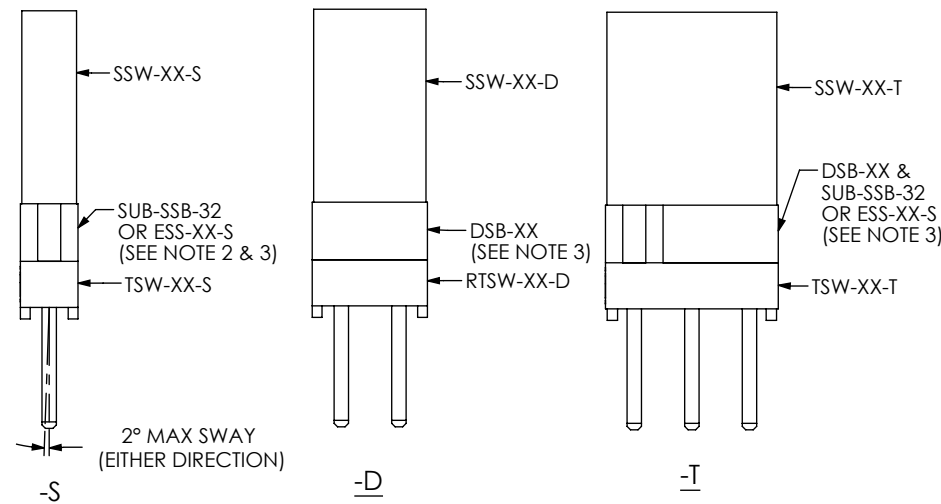


FIG 1
ESQ-110-XX-X-T

F:\DWG\MISC\MKTG\ESQ-1XX-XX-X-XXX-XX-X-XX-MKT.SLDDRW



UNLESS OTHERWISE SPECIFIED,
DIMENSIONS ARE IN INCHES.

TOLERANCES ARE:

DECIMALS ANGLES
.XX: ±.01 [0.3] 2°
.XXX: ±.005 [0.13]
.XXXX: ±.0020 [0.051]

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MATERIAL: DO NOT SCALE DRAWING
INSULATOR: LCP, UL 94 V0
COLOR: BLACK
CONTACT : PHOS BRONZE

SHEET SCALE: 3:1

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

DESCRIPTION:

ESQ STRIP ASM

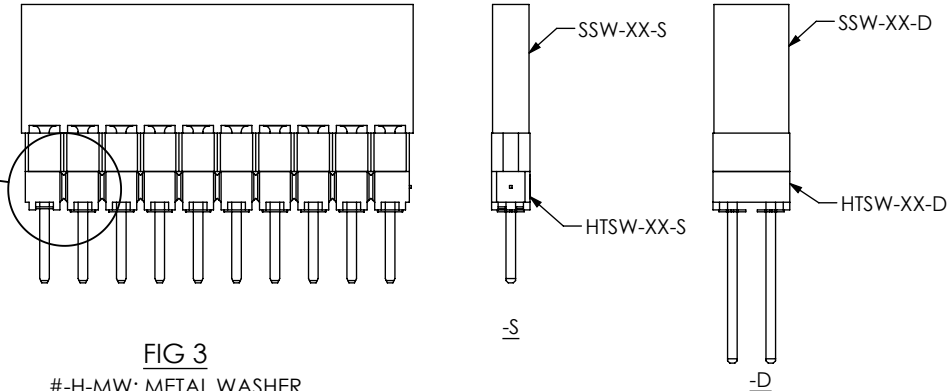
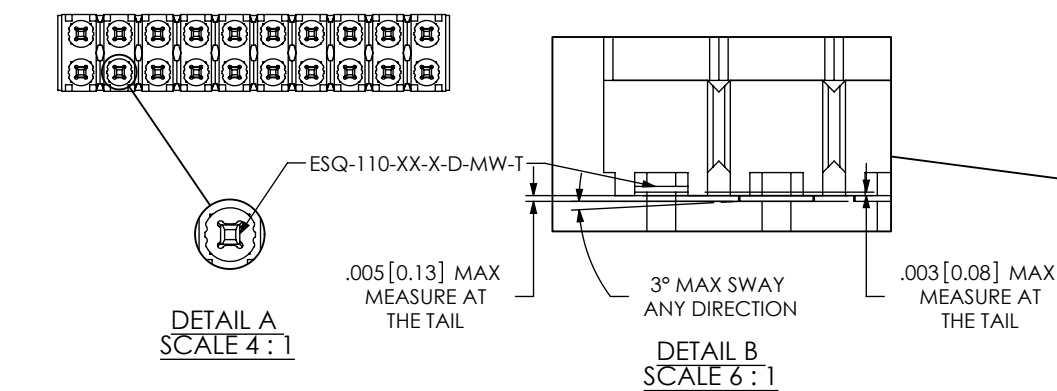
DWG. NO.

ESQ-1XX-XX-X-X-XXX-XX-X-XX

BY: JORDAN

7-16-85

SHEET 1 OF 4



(SAME AS FIG 1 UNLESS OTHERWISE NOTED)

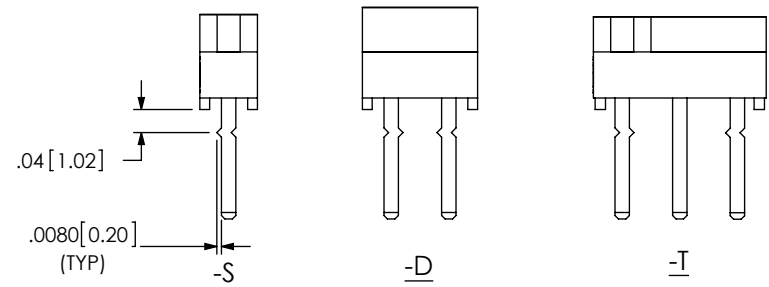


FIG 2
-LL: LOCKING LEAD OPTION
LOCATED ON OR ABOUT CENTERLINE
[N/A IN 1 OR 2 POSITION SINGLE ROW]

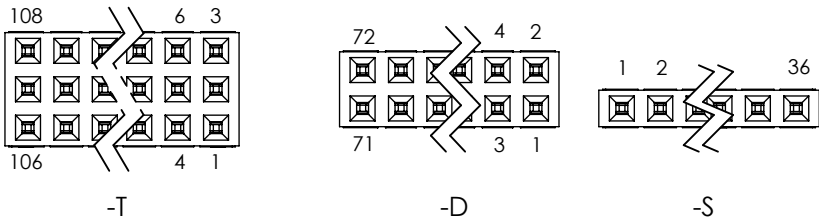


FIG 4
XXX: POLARIZATION LOCATION
INSERT PK-06-N INTO SPECIFIED POS
AND BREAK OFF TAB

TABLE 1								
STANDARD INSERTION FORCE	CONTACT	SPACER SPECIFICATION (FOR A ONE POSITION SINGLE SEE NOTE 3)			"B"	"C"	"D"	"E"
		ESQ-S	ESQ-D	ESQ-T				
-12	C-15-2-X	N/A	N/A	N/A	.09[2.29]	.435[11.05]	.525[13.33]	.100[2.54]
-13	C-15-3-X	N/A	N/A	N/A	.29[7.37]	.435[11.05]	.725[18.41]	N/A
-14	C-15-4-X	N/A	N/A	N/A	.48[12.2]	.435[11.05]	.915[23.24]	N/A
-23	C-15-3-X	(1) SUB-SSB-32	(1) DSB-XX	(1) SUB-SSB-32 (1) DSB-XX	.19[4.83]	.535[13.59]	.725[18.41]	N/A
-24	C-15-4-X	(1) SUB-SSB-32	(1) DSB-XX	(1) SUB-SSB-32 (1) DSB-XX	.38[9.65]	.535[13.59]	.915[23.24]	N/A
-33	C-15-3-X	(2) SUB-SSB-32	(2) DSB-XX	(2) SUB-SSB-32 (2) DSB-XX	.09[2.87]	.635[16.13]	.725[18.41]	N/A
-34	C-15-4-X	(2) SUB-SSB-32	(2) DSB-XX	(2) SUB-SSB-32 (2) DSB-XX	.28[7.11]	.635[16.13]	.915[23.24]	N/A
-44	C-15-4-X	(1) ESS-XX-S	(3) DSB-XX	(1) ESS-XX-S (3) DSB-XX	.18[4.57]	.735[18.67]	.915[23.24]	N/A
LOW INSERTION FORCE	CONTACT	SPACER SPECIFICATION (FOR A ONE POSITION SINGLE SEE NOTE 3)			"B"	"C"	"D"	"E"
		ESQ-S	ESQ-D	ESQ-T				
		ESQ-S	ESQ-D	ESQ-T				
-37	C-60-2-X	N/A	N/A	N/A	.09[2.87]	.435[11.05]	.525[13.33]	.100
-38	C-60-3-X	N/A	N/A	N/A	.29[7.37]	.435[11.05]	.725[18.41]	N/A
-39	C-60-4-X	N/A	N/A	N/A	.48[12.2]	.435[11.05]	.915[23.24]	N/A
-48	C-60-3-X	SUB-SSB-32	(1) DSB-XX	(1) SUB-SSB-32 (1) DSB-XX	.19[4.83]	.535[13.59]	.725[18.41]	N/A
-49	C-60-4-X	(1) SUB-SSB-32	(1) DSB-XX	(1) SUB-SSB-32 (1) DSB-XX	.38[9.65]	.535[13.59]	.915[23.24]	N/A
-58	C-60-3-X	(2) SUB-SSB-32	(2) DSB-XX	(2) SUB-SSB-32 (2) DSB-XX	.09[2.87]	.635[16.13]	.725[18.41]	N/A
-59	C-60-4-X	(2) SUB-SSB-32	(2) DSB-XX	(2) SUB-SSB-32 (2) DSB-XX	.28[7.11]	.635[16.13]	.915[23.24]	N/A
-69	C-60-4-X	(1) ESS-XX-S	(3) DSB-XX	(1) ESS-XX-S (3) DSB-XX	.18[4.57]	.735[18.67]	.915[23.24]	N/A

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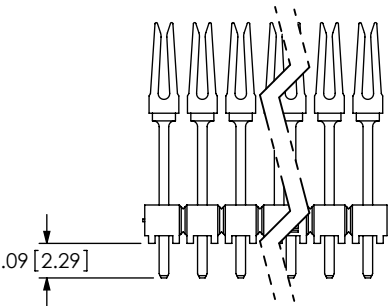
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PHONE: 812-944-6733 FAX: 812-948-5047
e-Mail: info@SAMTEC.com code 55322

DESCRIPTION: ESQ STRIP ASM

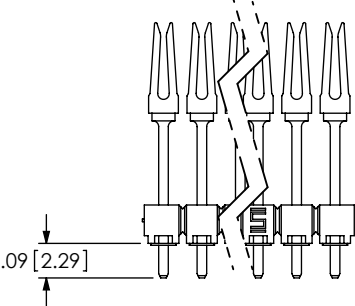
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BY: WHITTAKER 9-11-98 SHEET 2 OF 4

LOAD CONTACT

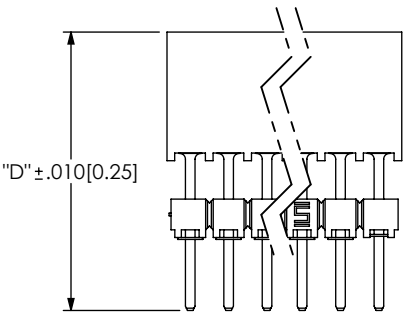


PRESS ON -MW

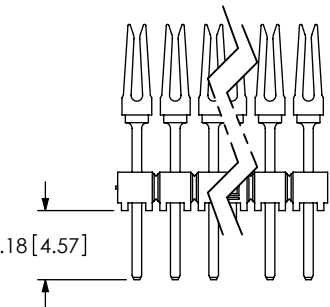


IN PROCESS
-12, -33, -37, -58

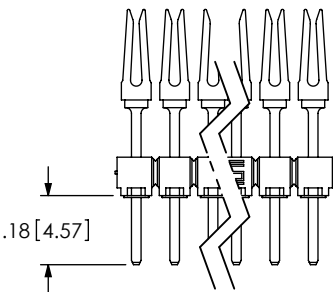
PRESS ON
SSW BODY



LOAD CONTACT

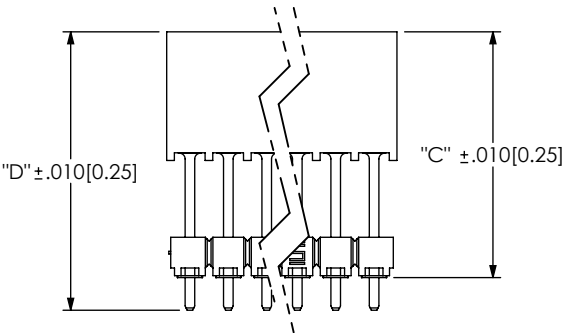


PRESS ON -MW

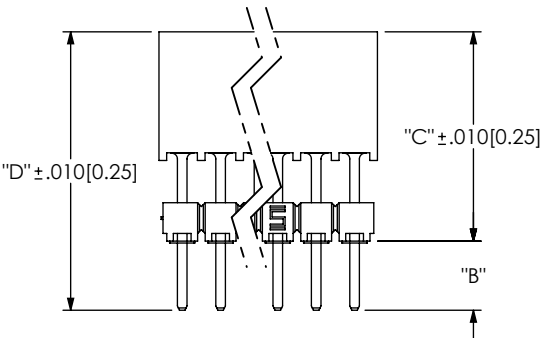


IN PROCESS
-13, -14, -23, -24, -34, -38
-39, -44, -48, -49, -59, -69

PRESS ON
SSW BODY



REPRESS STACKER BODY
AND -MW TO PROPER "C" DIM



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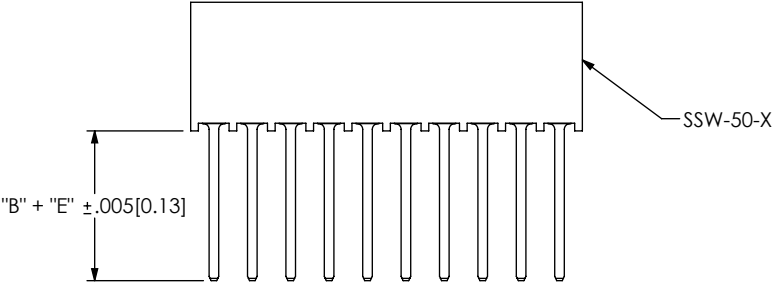
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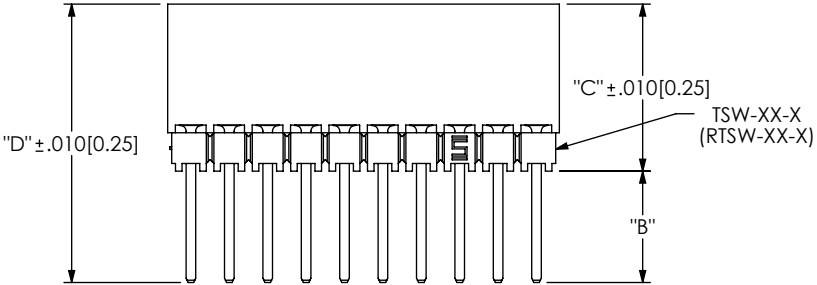
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BY: WITHTTAKER 9-11-98

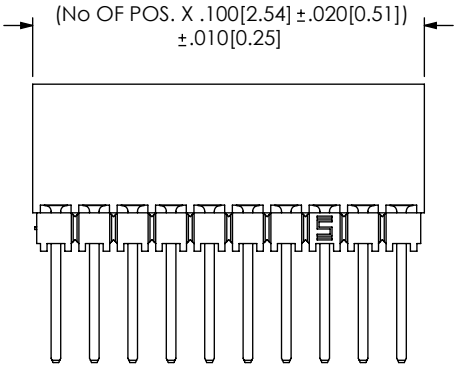
SHEET 3 OF 4



STEP 1
MACHINE FILL SSW-50-X



STEP 2
MULTI-CUT TSW-50-X TO POS (RTSW-50-D FOR DOUBLE ROW)
AND MOUNT AS SHOWN.
(IF RTSW-50-D NOT AVAILABLE, TSW-50-D MAY BE USED)



STEP 3
ROTO CUT TO POS

FIG 5
ESQ-TT0-XX-X-S
IN PROCESS "B"
(LEAD STYLE -12 & -37)
(-S & -D ONLY)

TABLE 2			
LEAD STYLE	ROW	TUBE	PLUG (2)
-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-24
-12, -37	-D	PT-1-24-03-44	TP-07
-14, -24, -34, -44, -39, -49, -59, -69		PT-1-24-02-47	TP-07
-13, -23, -33, -38, -48, -58		PT-1-24-01-51	TP-13
-12, -37	-T	PT-1-24-01-51	TP-13
-13, -14, -23, -24, -33, -34, -44, -38, -39, -48, -49, -58, -59, -69		PT-1-24-03-51	TP-13

1. FOR -12 & -37 LEAD STYLES TUBE PAC KAGE -04 THRU -36 POSITION ONLY.
2. FOR -13, -23, -33, -38, -48, & -58 LEAD STYLES TUBE PACKAGE -08 THRU -36 POSITIONS ONLY.
3. FOR -14, -24, -34, -44, -39, -49, -59, & -69 LEAD STYLES -05 THRU -36 POSITIONS ONLY.

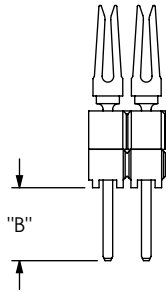
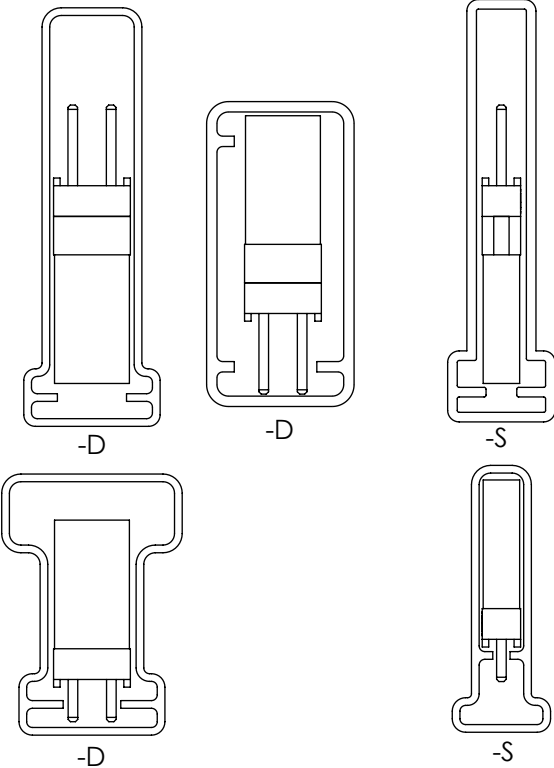


FIG 6
ESQ-110-XX-X-D
IN PROCESS "A"
(LEAD STYLE -12-T, -13, -14, -23, -24, -33, -34, -44, -37-T, -38, -48, -49, -58, -59, -69)



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		DESCRIPTION: ESQ STRIP ASM	
		DWG. NO. ESQ-1XX-XX-X-X-XXX-XX-X-XX	
		BY: WHITTAKER 9-11-98	SHEET 4 OF 4