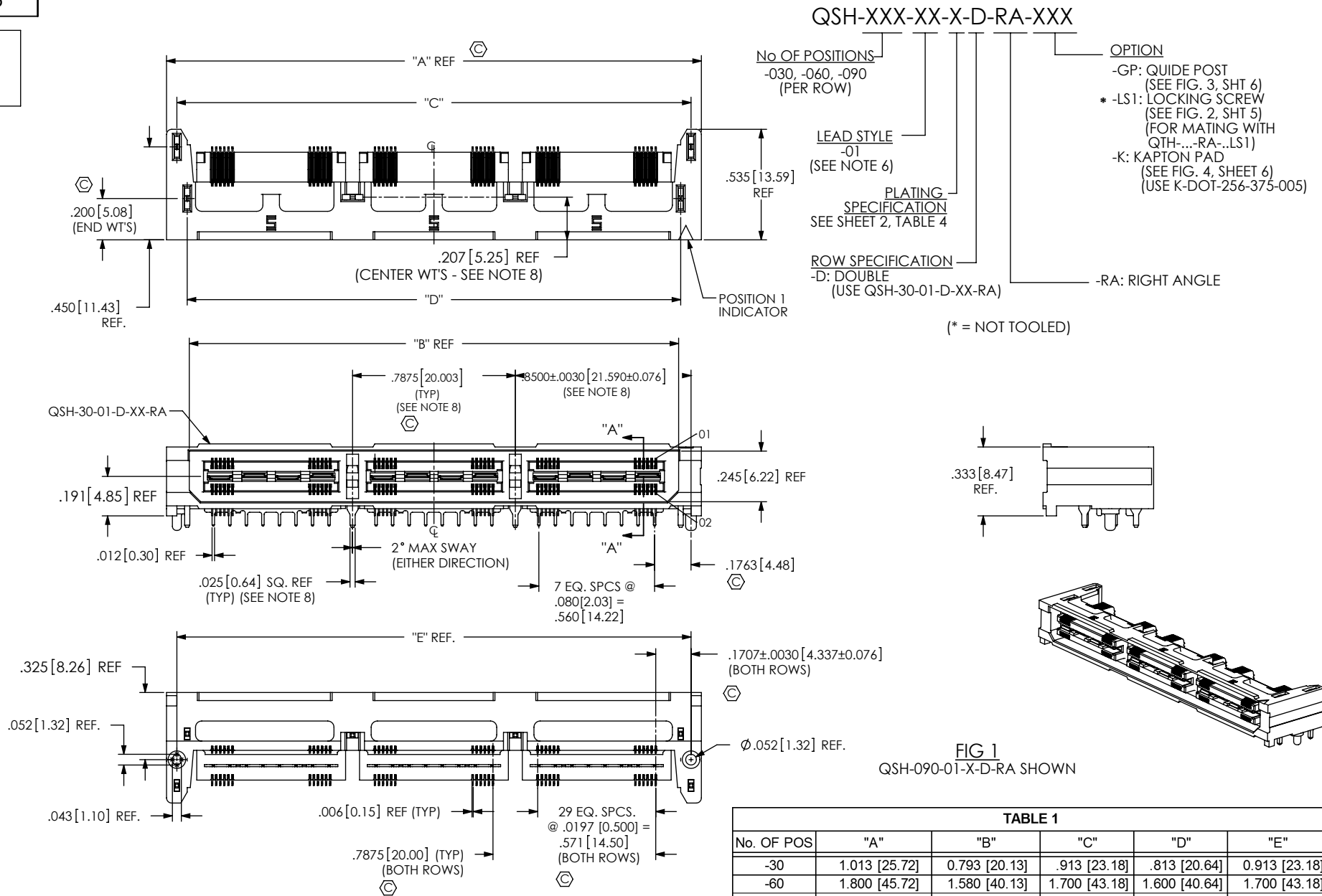


DO NOT
SCALE FROM
THIS PRINT

NOTES:

1. \odot REPRESENTS A CRITICAL DIMENSION.
2. BURR ALLOWANCE: .0010 MAX.
3. MINIMUM PUSHOUT FORCE: 6 OZ.
4. IF NEEDED, -L PLATING CAN BE SUBSTITUTED FOR -F PLATING.
5. IM-1G18-01-2-XX RETENTION TO BE 1.0 LBS. MINIMUM PRIOR TO SECOND ROW FILL.
6. DESIGNED FOR USE WITH A .062 OR .093 THICK PCB
7. ASSEMBLIES TO BE PACKAGED IN TRAYS.
8. CENTER WELD TABS ARE NOT AVAILABLE ON -030 POSITION.
9. USE -Z- DATUM ZONE ONLY FOR MEASUREMENTS.

UNLESS OTHERWISE SPECIFIED,
DIMENSIONS ARE IN INCHES.

TOLERANCES ARE:

DECIMALS

.XX: $\pm .01$ [0.3].XXX: $\pm .005$ [0.13].XXXX: $\pm .0020$ [0.051]

ANGLES

2°

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MATERIAL:

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SHEET SCALE: 2:1

INSULATOR: LCP UL94V-0, COLOR BLACK
TERMINAL, GROUND PLANE & WELD TAB: PHOS BRONZE

DESCRIPTION:

.50mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

DWG. NO.

QSH-XXX-XX-X-D-RA-XXX

BY: DUKES Z

01/31/2010

SHEET 1 OF 6

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520 PARK EAST BLVD, NEW ALBANY, IN 47150
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e-Mail: info@SAMTEC.com code 55322

TABLE 2			
No OF POSITIONS	COPLANARITY	STRAIGHTNESS ROW 1	STRAIGHTNESS ROW 1
-030 THRU -090	.004[0.10]	.004[0.10]	.004[0.10]

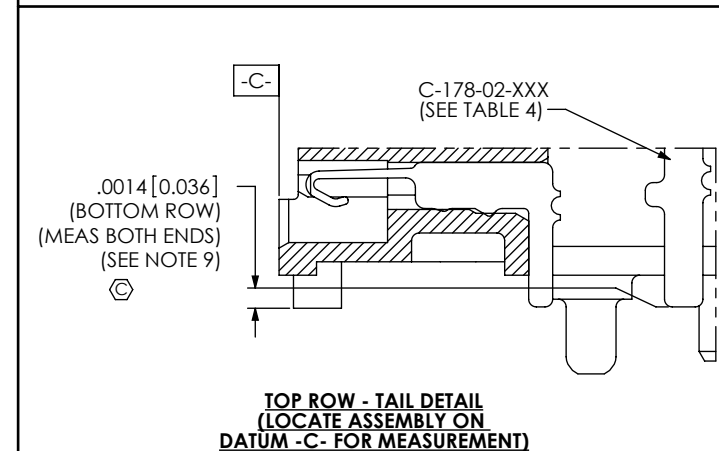
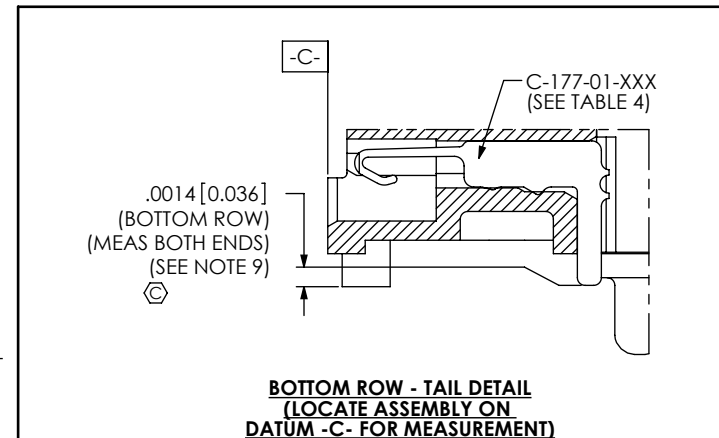
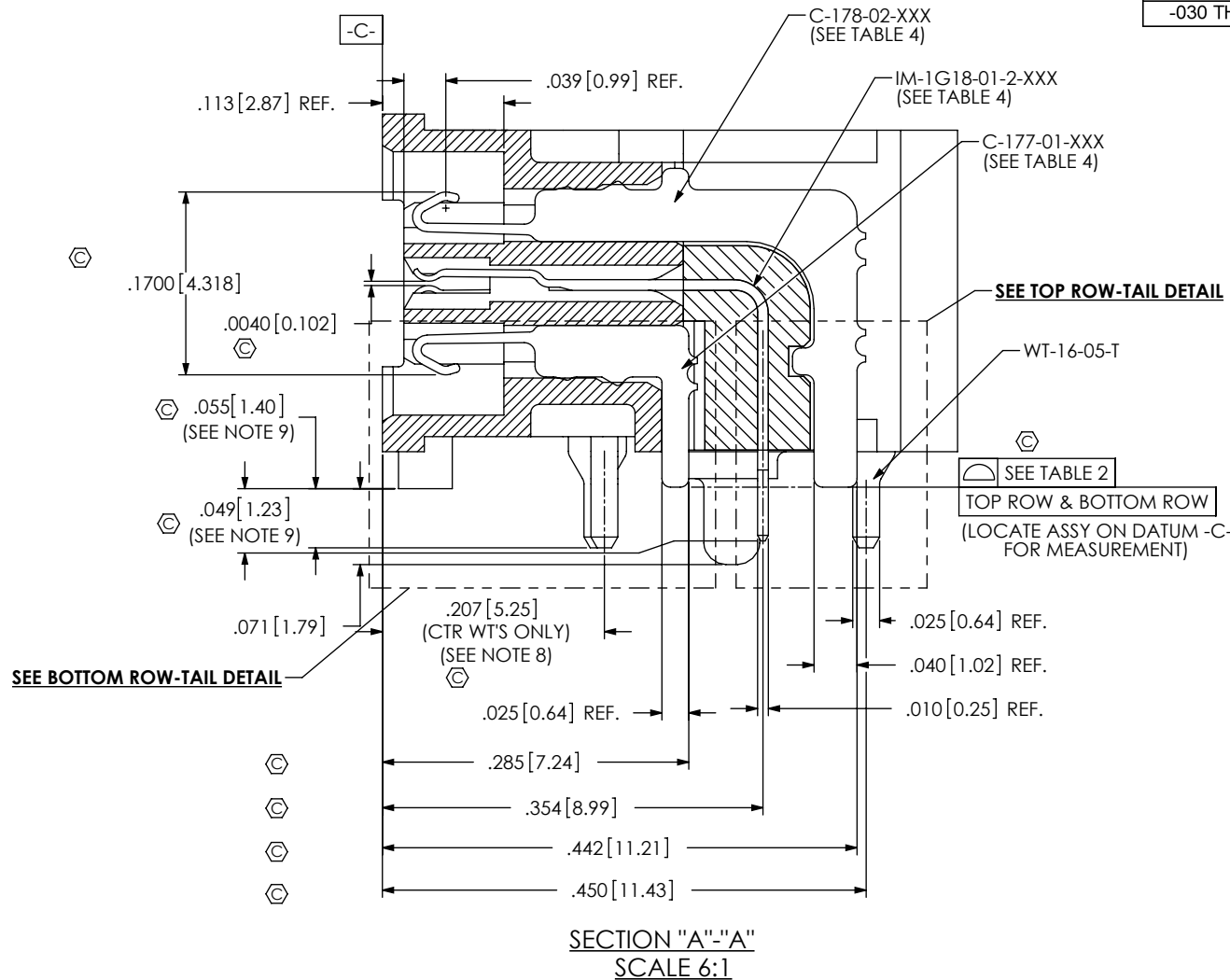


TABLE 4: PLATING SPECIFICATIONS

	C-177-01-XXX CONTACT	C-178-02-XXX CONTACT	IM-1G18-01-2-X GROUND PLANE	WT-16-05-T WELD TAB
-F	3 - 5μ" FLASH GOLD ON CONTACT, MATTE TIN TAIL	3 - 5μ" FLASH GOLD CONTACT, MATTE TIN TAIL	3μ" MIN. FLASH GOLD CONTACT, MATTE TIN TAIL	MATTE TIN
-L	10μ" MIN. LIGHT GOLD CONTACT, MATTE TIN TAIL	10μ" MIN. LIGHT GOLD CONTACT, MATTE TIN TAIL	10μ" MIN. LIGHT GOLD CONTACT, MATTE TIN TAIL	MATTE TIN

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DESCRIPTION:

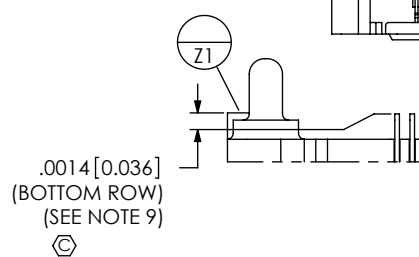
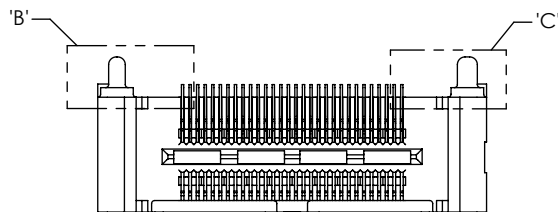
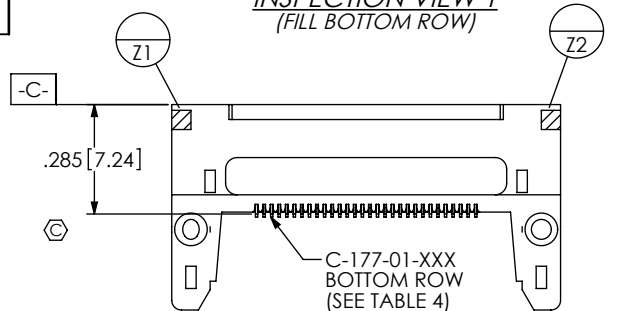
.50mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

DWG. NO.

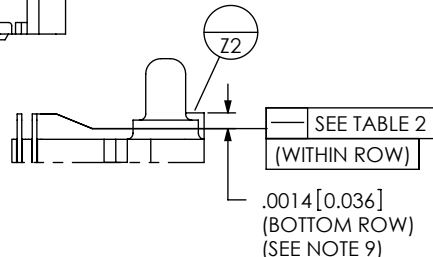
QSH-XXX-XX-X-D-RA-XXX

BY: DUKES Z 01/31/2010 SHEET 2 OF 6

INSPECTION VIEW 1
(FILL BOTTOM ROW)

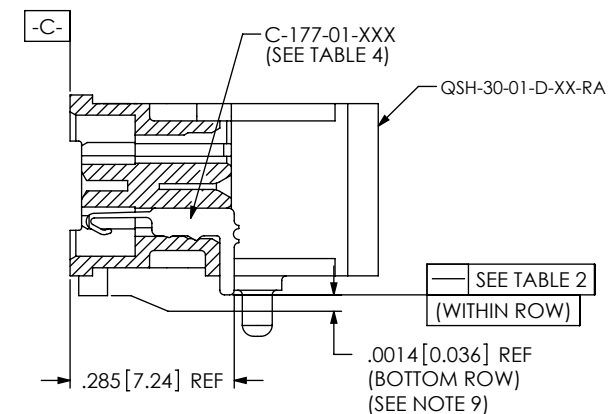
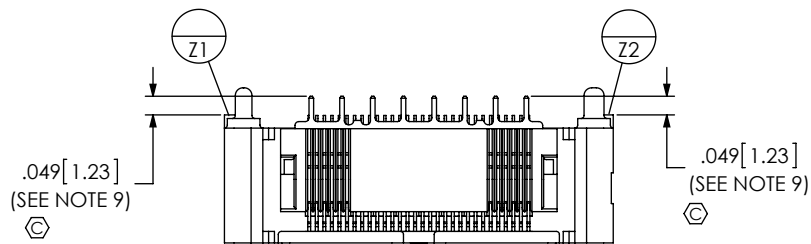
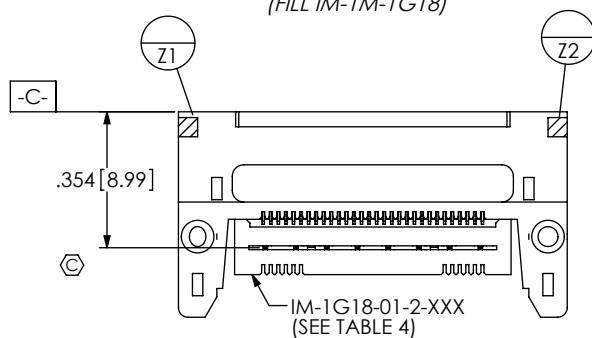


DETAIL 'B'
SCALE 4 : 1

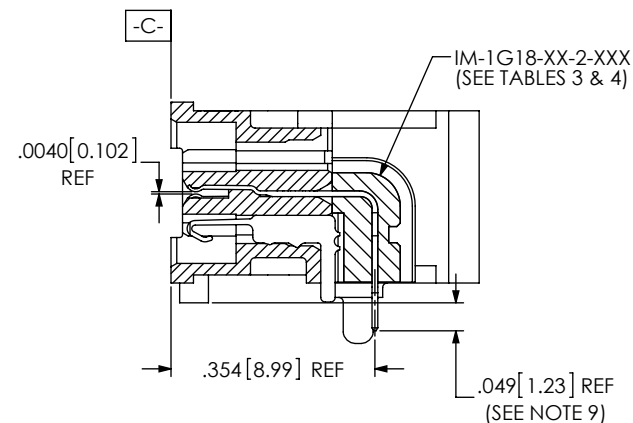


DETAIL 'C'
SCALE 4 : 1

INSPECTION VIEW 2
(FILL IM-1M-1G18)



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



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

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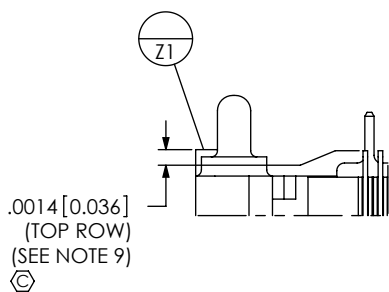
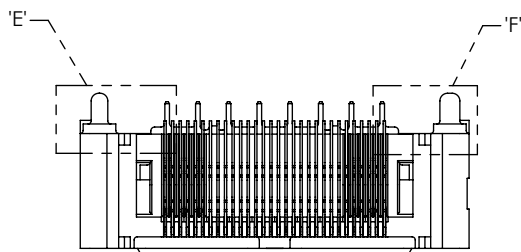
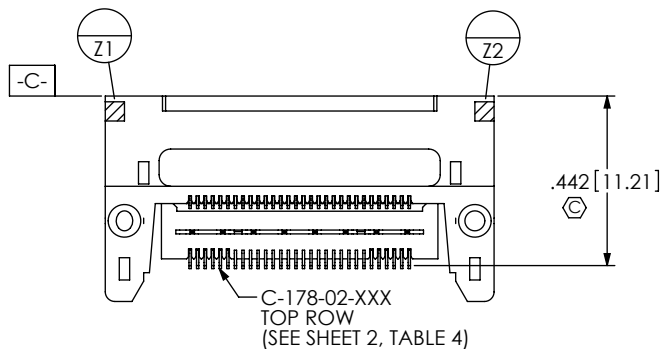
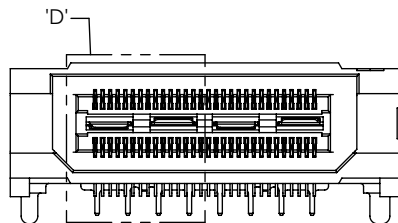
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e-Mail: info@SAMTEC.com code 55322

DESCRIPTION:
.50mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

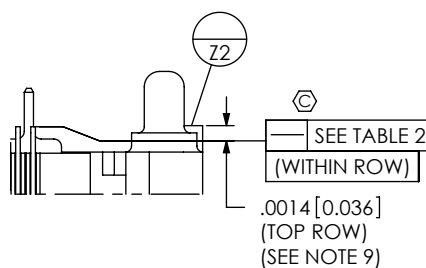
DWG. NO.
QSH-XXX-XX-X-D-RA-XXX

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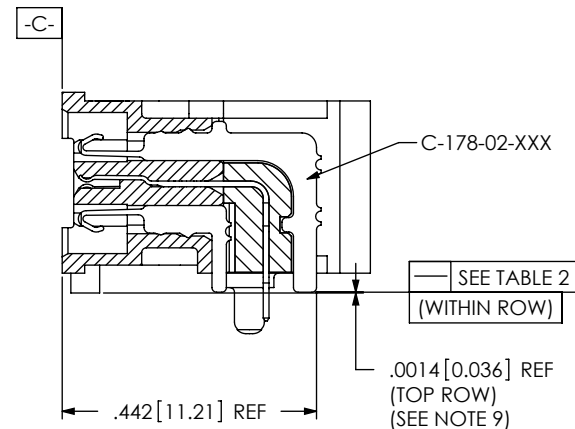
INSPECTION VIEW 3
(FILL TOP ROW)



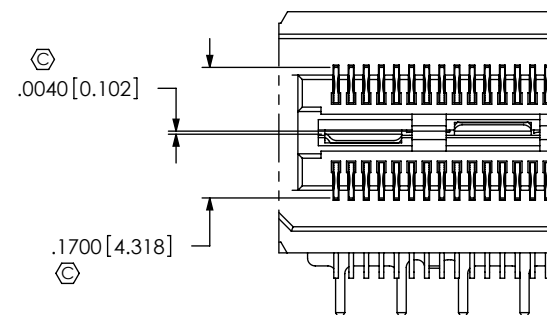
DETAIL 'E'
SCALE 4 : 1



DETAIL 'F'
SCALE 4 : 1



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



DETAIL 'D'
SCALE 4 : 1

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DWG. NO.
QSH-XXX-XX-X-D-RA-XXX

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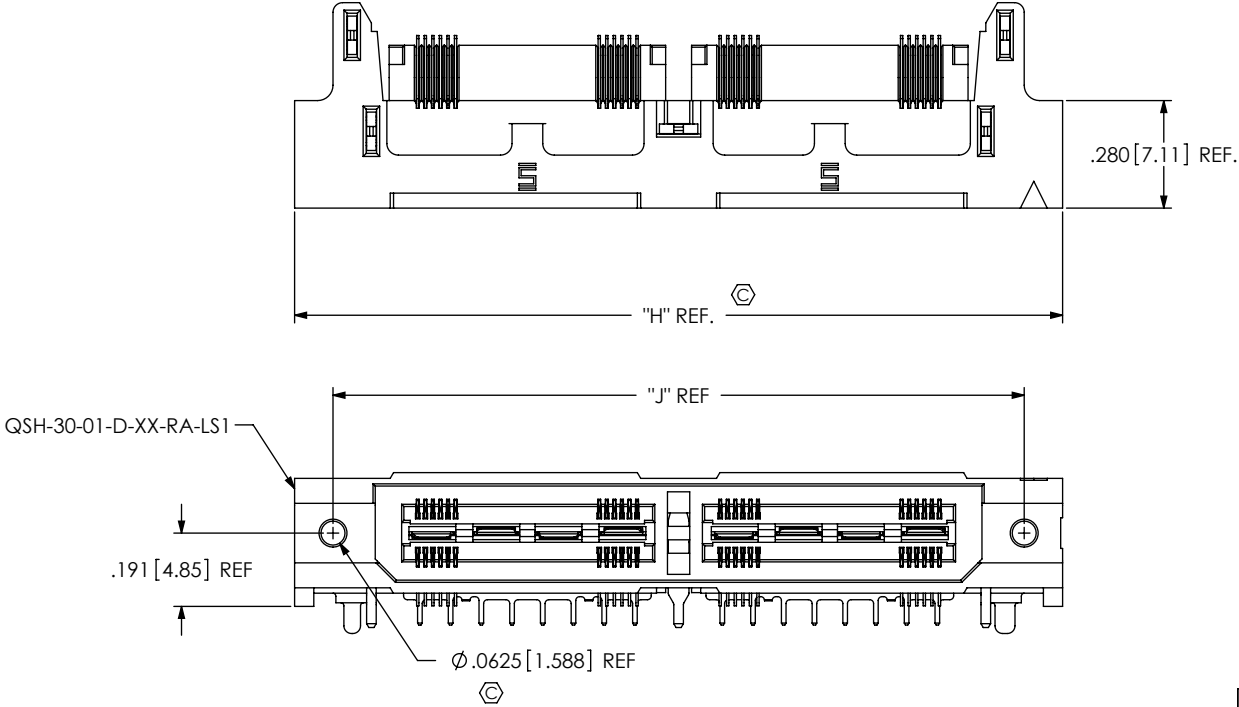


FIG 2
QSH-060-01-X-D-RA-LS1 SHOWN
(SAME AS FIG. 1, EXCEPT AS SHOWN)
(NOT TOOLED)

TABLE 5		
NO OF POS	"H"	"J"
-30	1.213 [30.80]	1.013 [25.72]
-60	2.000 [50.80]	1.800 [45.72]
-90	2.788 [70.80]	2.588 [65.72]

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DWG. NO.
QSH-XXX-XX-X-D-RA-XXX

BY: DUKES Z 01/31/2010 SHEET 5 OF 6

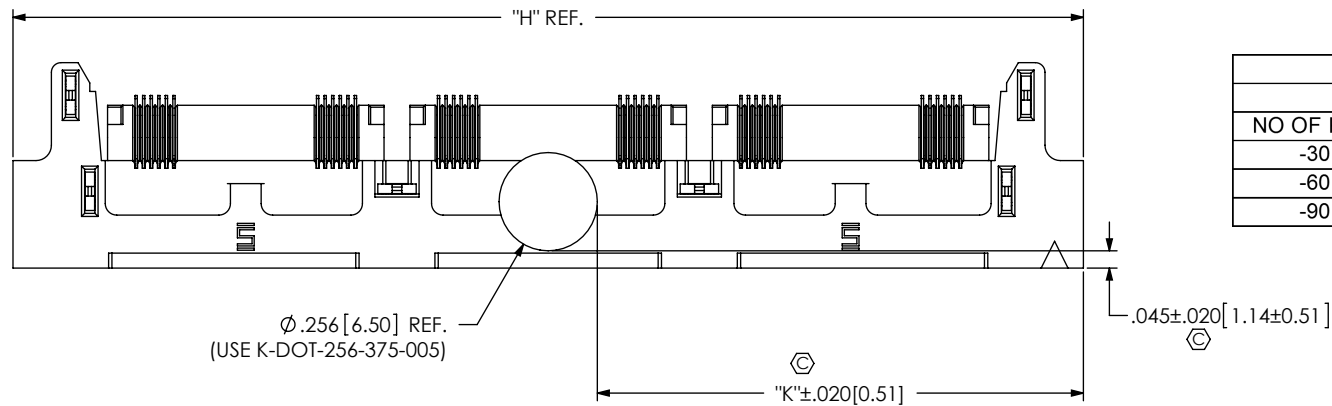
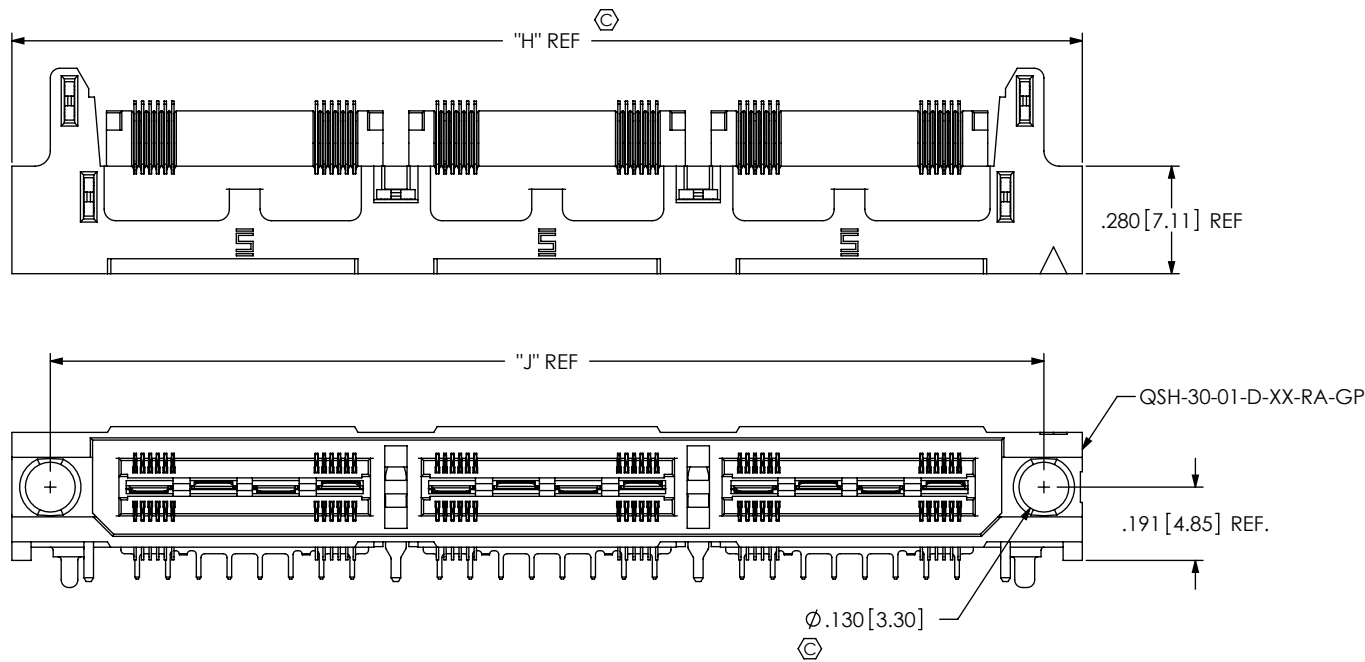


TABLE 6				
NO OF POS	"K"			
	-GP		NON -GP	
-30	.478	[12.14]	.378	[9.60]
-60	.872	[22.15]	.772	[19.61]
-90	1.266	[32.16]	1.166	[29.62]

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SHEET SCALE: 1:0.666667

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DWG. NO.

QSH-XXX-XX-X-D-RA-XXX

BY: DUKES Z 01/31/2010 SHEET 6 OF 6