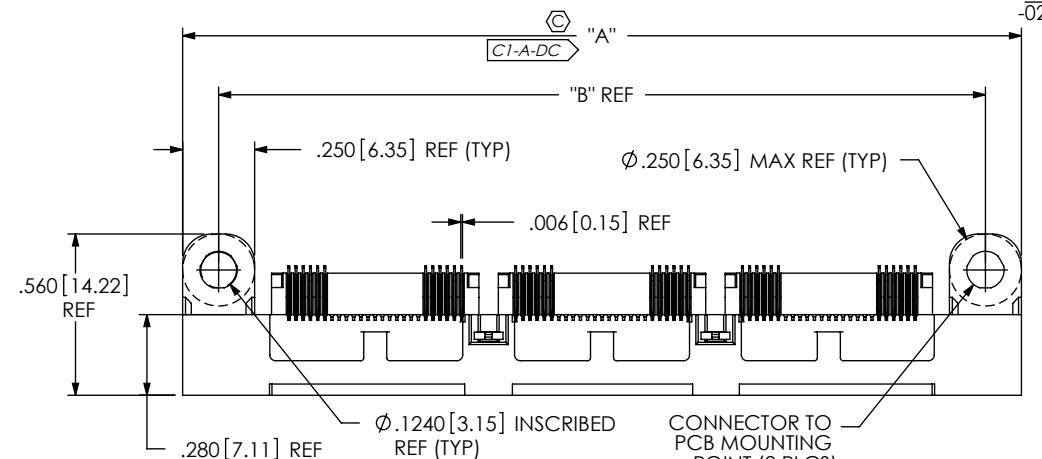


DO NOT
SCALE FROM
THIS PRINTNO. OF POSITIONS
-025, -050, -075, *-100
(PER ROW)
(SEE NOTE 4)
*(SEE NOTE 12)LEAD STYLE
-01: .062 BOARD
-02: .093 BOARDPLATING SPECIFICATION
SEE TABLE 8, SHEET 6ROW SPECIFICATION
-D: DOUBLE
(USE QSS-25-01-D-XX-RA)

-RA: RIGHT ANGLE

OPTION
 -LS1: LOCKING SCREW
 (SEE FIG. 2, SHT 4)
 (FOR MATING WITH
 QTS...RA...LS1)
 -MTI: THREADED INSERT
 (SEE FIG. 5, SHT 6)
 -SP: SOLDER PIN
 (NOT AVAILABLE
 W/LS1 OPTION)
 (USE SP-19-T)
 (SEE FIG. 3, SHT 5)
 -K: KAPTON PAD
 (SEE FIG. 4, SHT 5)
 (USE K-500-300)
 -WT: WELD TAB
 (SEE NOTE 4)
 (USE WT-16-XX-T)

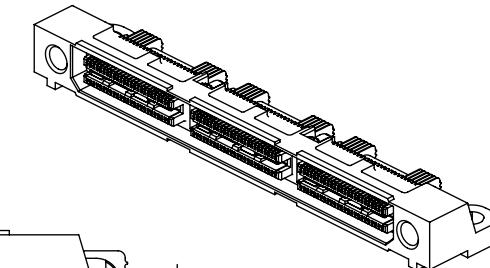
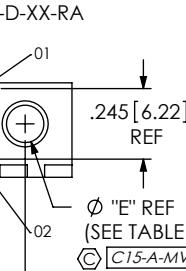
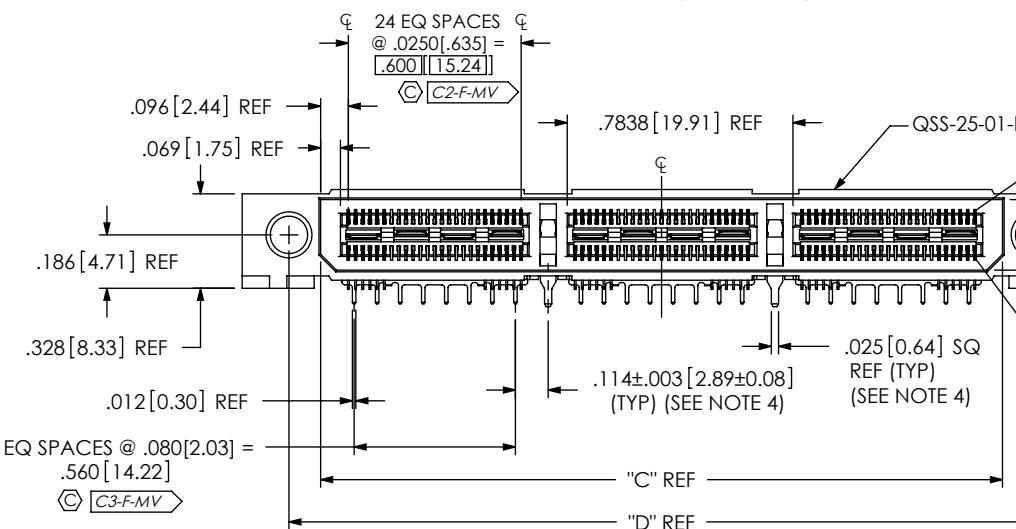


TABLE 2	
MOUNTING OPTION	"E" HOLE DIA
STANDARD	.130 [3.30]
-LS1	.0625 [1.588]

POSITION	"A"	"B"	"C"	"D"
-025	1.338 [33.97]	1.088 [27.62]	0.793 [20.13]	1.013 [25.72]
-050	2.125 [53.98]	1.875 [47.63]	1.580 [40.13]	1.800 [45.72]
-075	2.913 [73.98]	2.663 [67.63]	2.368 [60.13]	2.588 [65.72]
*-100	3.700 [93.98]	3.450 [87.63]	3.155 [80.14]	3.375 [85.73]

* SEE NOTE 12

NOTES:

1. \triangle REPRESENTS A CRITICAL DIMENSION.
2. BURR ALLOWANCE: .0010 MAX.
3. MINIMUM PUSHOUT FORCE: 6 OZ.
4. WELD TABS (WT-16-XX-T) NOT AVAILABLE ON -025 POSITION. WT OPTION MUST BE SELECTED FOR -050, -075 & -100 POSITIONS.
5. IF NEEDED, -L PLATING CAN BE SUBSTITUTED FOR -F PLATING.
6. IM-1G18-XX-1-XX RETENTION TO BE 1.0 LBS. MINIMUM PRIOR TO SECOND ROW FILL.
7. DESIGNED FOR USE WITH A .062 OR .093 THICK PCB
8. ASSEMBLIES TO BE PACKAGED IN TRAYS.
9. NOTE DELETED
10. TORQUE TO BE 10.0 IN-OZ USING 4-40 UNC SCREW.
11. USE -Z DATUM ZONE ONLY FOR MEASUREMENTS.
12. AVAILABLE FOR EXISTING CUSTOMERS ONLY.

FIG 1
QSS-075-01-XXX-D-RA-WT SHOWN
(SOME CENTER DETAILS REMOVED FOR CLARITY)

CPC FREQUENCY THIS SHEET		UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE: DECIMALS ANGLES .XX: ±.01 [3] 2° .XXX: ±.005 [13] .XXXX: ±.0020 [.051]
A	C1, C15	MATERIAL: DO NOT SCALE DRAWING INSULATOR: LCP, COLOR: BLACK TERMINAL, GROUND PLANE & WELD TAB: PHOS BRONZE
B		
C		
D		F:\DWG\MISC\MKT\QSS-XXX-XX-XXX-D-RA-XX-XXX-MKT.SLDDRW

Samtec
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 e-Mail: info@SAMTEC.com code 55322
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 DWG. NO. QSS-XXX-XX-XXX-D-RA-XX-XXX
 BY: KEVIN B 01/22/02 SHEET 1 OF 6

TABLE 3

NO OF POSITIONS	COPLANARITY	STRAIGHTNESS	STRAIGHTNESS
		ROW 1	ROW 2
-025 THRU -075	.004[.10]	.004[.10]	.004[.10]
*-100	.006[.15]	.006[.15]	.006[.15]

* = SEE NOTE 12

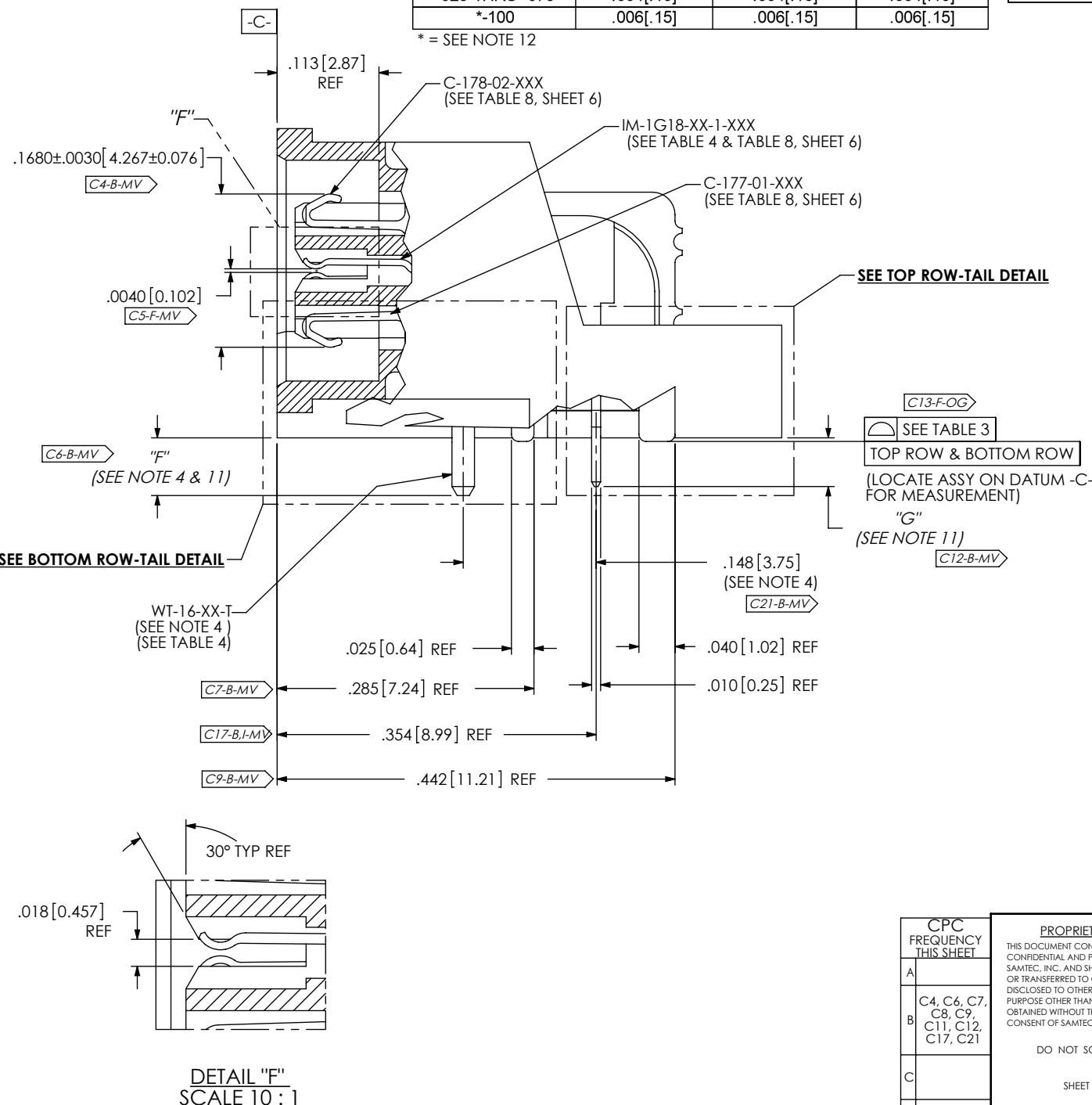
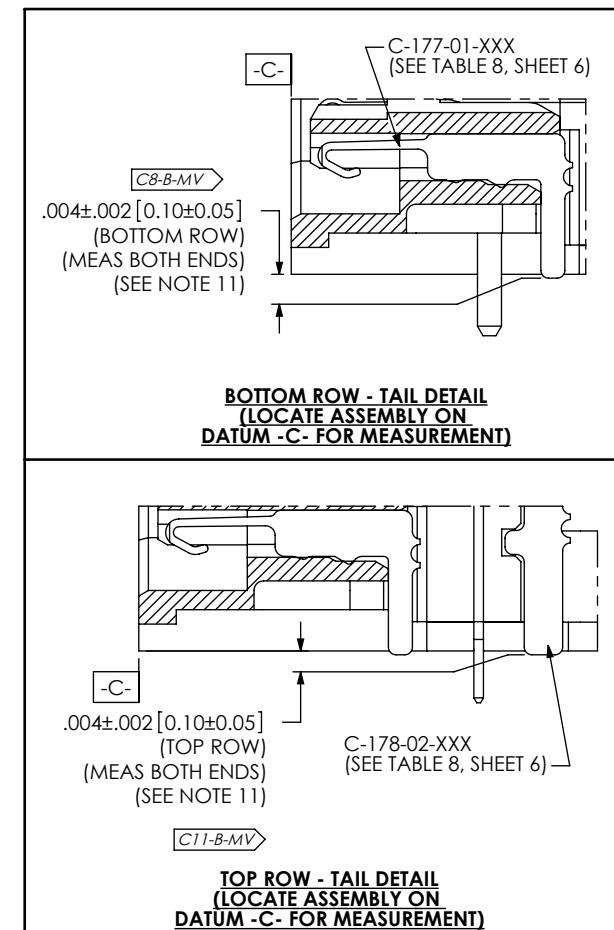


TABLE 4

LEADSTYLE	"F"	"G"	IM-1G18-XX-1-XXX	WT-16-XX-T
-01	0.064 [1.63]	0.058 [1.47]	IM-1G18-01-1-XXX	WT-16-02-T
-02	0.125 [3.18]	0.125 [3.18]	IM-1G18-02-1-XXX	WT-16-04-T

CPC
FREQUENCY
THIS SHEET

A

C4, C6, C7,
C8, C9,
C11, C12,
C17, C21

B

C

D

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SHEET SCALE: 6:1

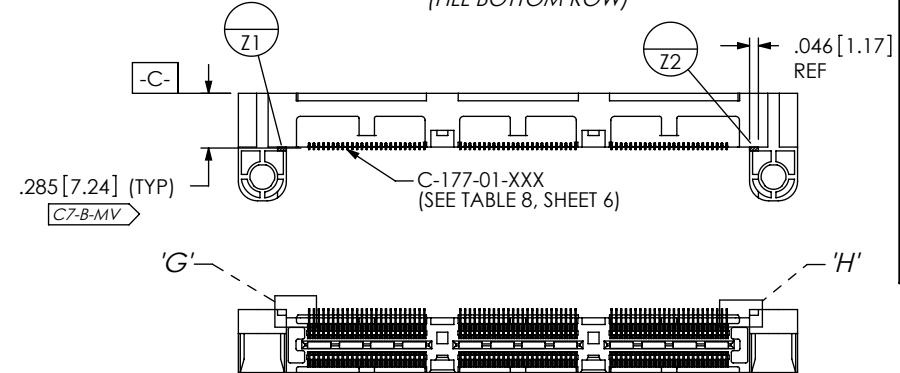
samtec520 PARK EAST BLVD, NEW ALBANY, IN 47150
PHONE: 812-944-6733 FAX: 812-948-5047
e-Mail: info@SAMTEC.com code 55322DESCRIPTION:
.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

DWG. NO.

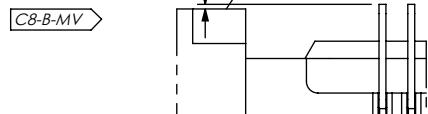
QSS-XXX-XX-XXX-D-RA-XX-XXX

BY: KEVIN B 01/22/02 SHEET 2 OF 6

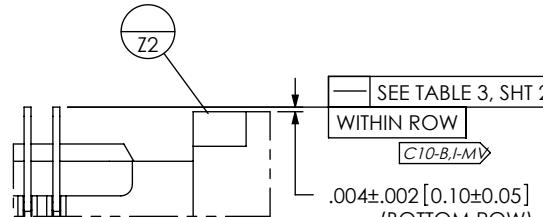
REVISION AN

INSPECTION VIEW 1
(FILL BOTTOM ROW)

.004±.002 [0.10±0.05]
(BOTTOM ROW)
(SEE NOTE 11)

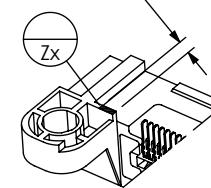


DETAIL 'G'
SCALE 6 : 1



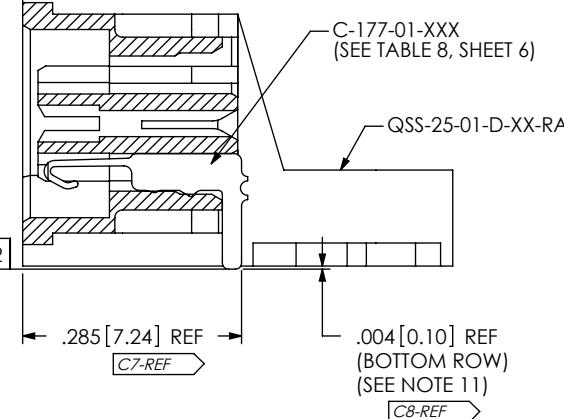
DETAIL 'H'
SCALE 6 : 1

.046 [1.17] REF



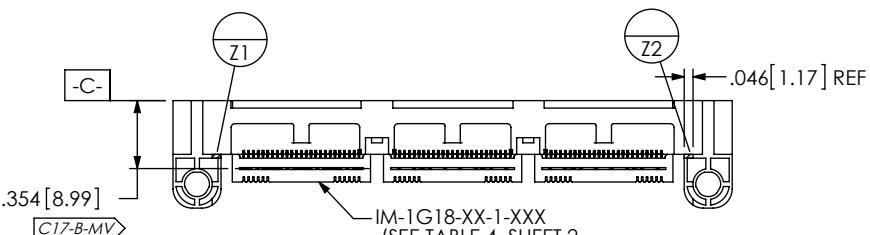
ISO VIEW OF -Z- DATUM ZONE

-C-



IN-PROCESS 1

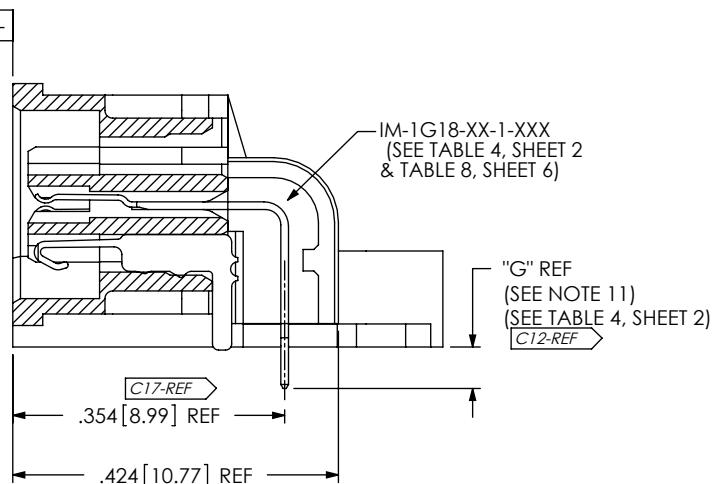
(FILL BOTTOM ROW)
(SEE INSPECTION VIEW 1 FOR ORIENTATION AND CPC'S)

INSPECTION VIEW 2
(FILL IM-1G18)

"G"
(SEE TABLE 4, SHEET 2)
(SEE NOTE 11)
C12-B-MV

IM-1G18-XX-1-XXX
(SEE TABLE 4, SHEET 2
& TABLE 8, SHEET 6)

"G"
(SEE TABLE 4, SHEET 2)
(SEE NOTE 11)
C12-B-MV



IN-PROCESS 2

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

CPC
FREQUENCY
THIS SHEET

A	
B	C7, C8, C10, C12, C17
C	
D	

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SHEET SCALE: 1:5:1

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e-Mail: info@SAMTEC.com code 55322

DESCRIPTION:

.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

DWG. NO.

QSS-XXX-XX-XXX-D-RA-XX-XXX

BY:

KEVIN B 01/22/02

SHEET 3 OF 6

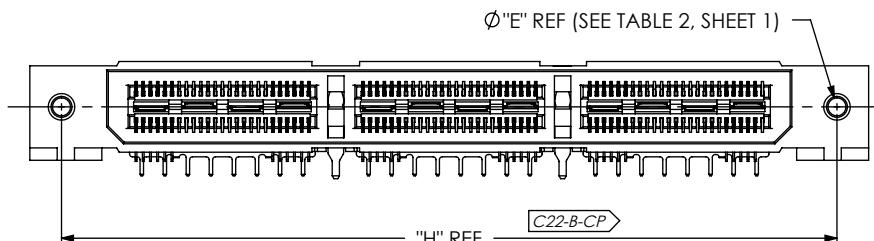
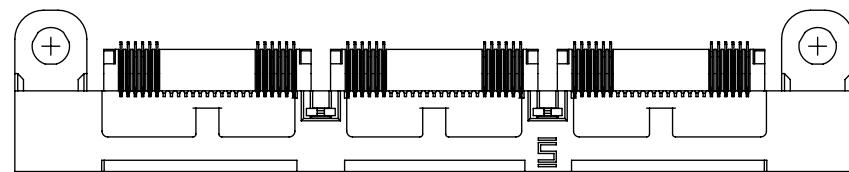
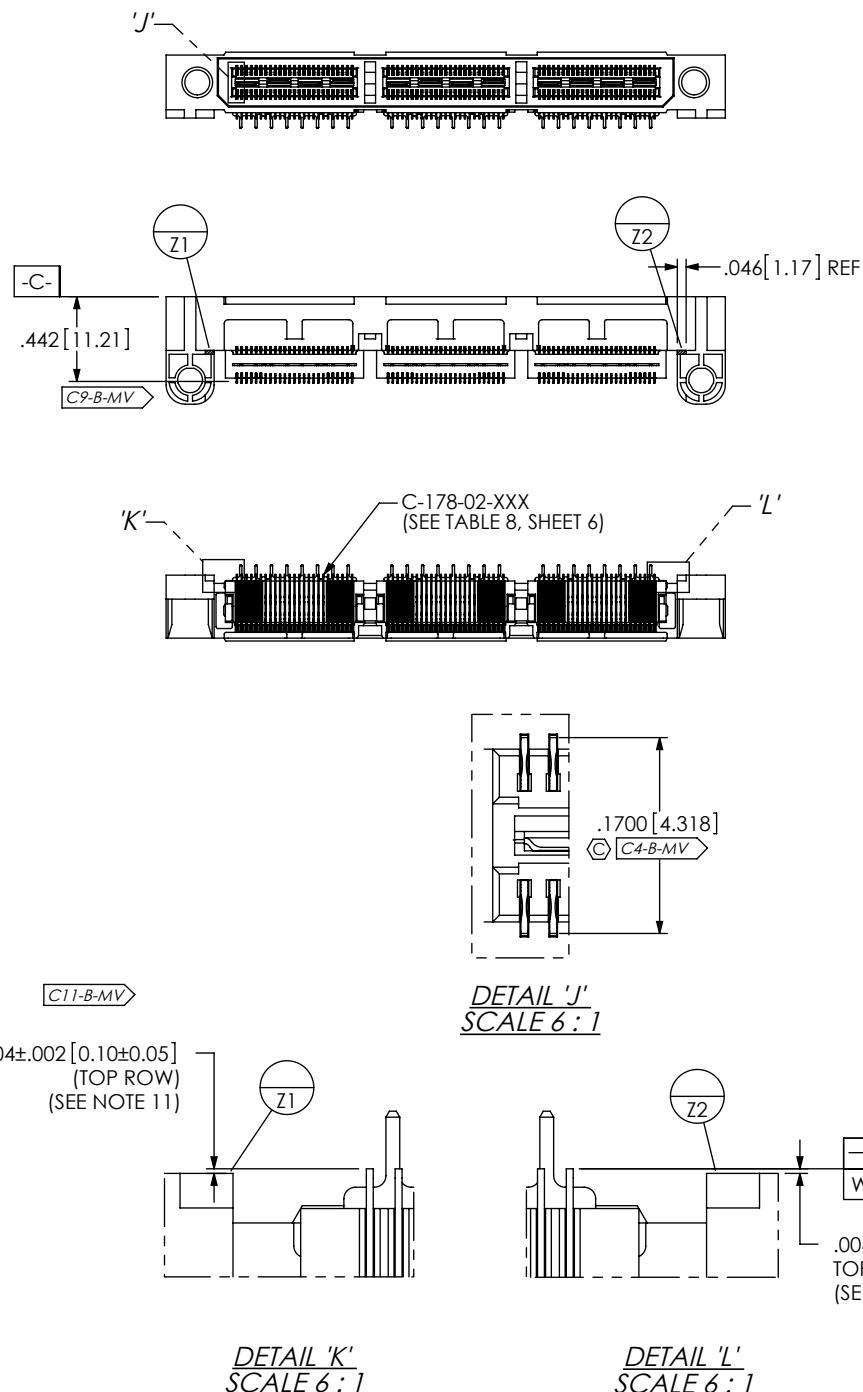
INSPECTION VIEW 3
(FILL TOP ROW)

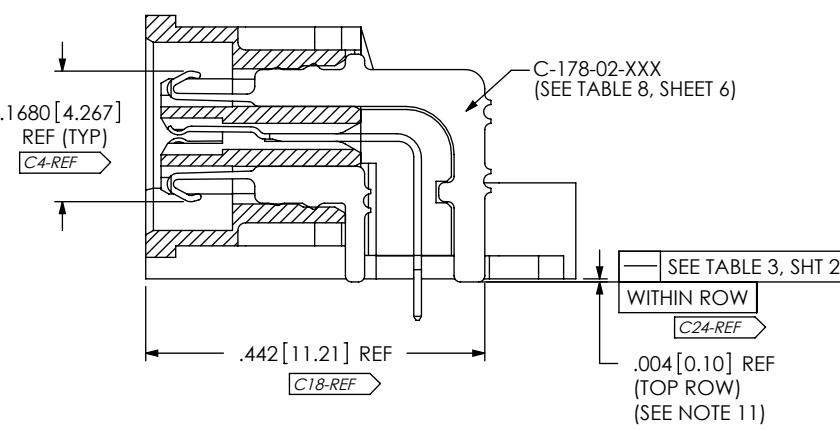
TABLE 5

POSITION	"H"
-025	1.118 [28.38]
-050	1.905 [48.39]
-075	2.693 [68.39]
*-100	3.480 [88.39]

* = SEE NOTE 12

FIG 2

QSS-075-01-XXX-D-RA-WT-LS1 SHOWN
(SAME AS FIG. 1, EXCEPT AS SHOWN)
(SOME CENTER DETAILS REMOVED FOR CLARITY)



IN-PROCESS 3

(FILL TOP ROW)

(SEE INSPECTION VIEW 3 FOR ORIENTATION AND CPC'S)

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C	SHEET SCALE: 1:5:1	DWG. NO.
D		QSS-XXX-XX-XXX-D-RA-XX-XXX
		BY: KEVIN B 01/22/02
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e-Mail: info@SAMTEC.com code 55322

DESCRIPTION: .635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

DWG. NO.

QSS-XXX-XX-XXX-D-RA-XX-XXX

BY: KEVIN B 01/22/02

FIG 3
 QSS-075-01-XXX-D-RA-WT-SP SHOWN
 (SAME AS FIG. 1, EXCEPT AS SHOWN)
 (NOT AVAILABLE WITH LS1 OPTION)
 (SOME CENTER DETAILS REMOVED FOR CLARITY)

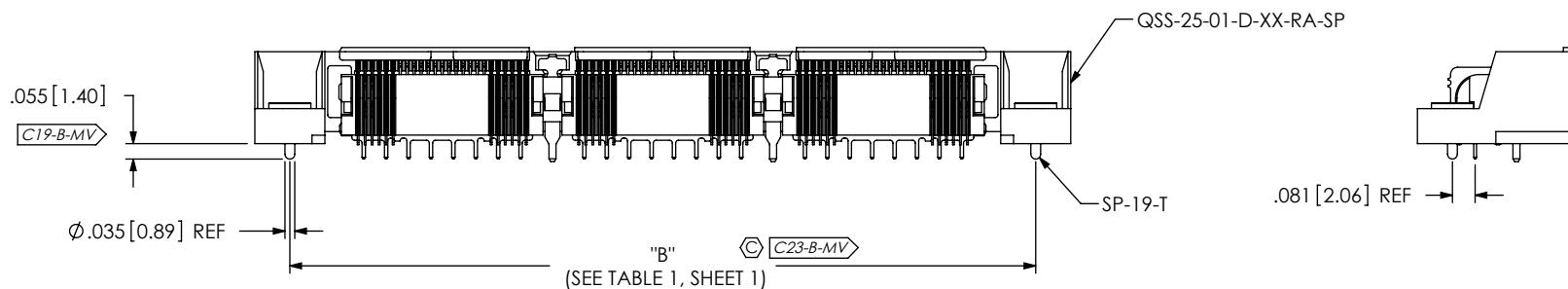
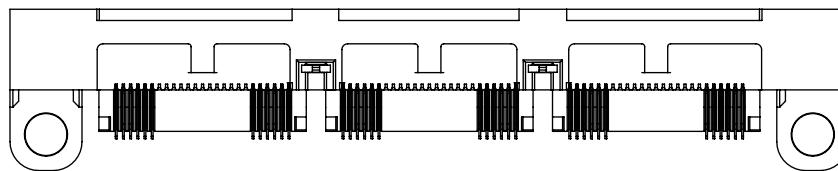


FIG 4
 -K OPTION
 QSS-075-01-XXX-D-RA-WT-K SHOWN
 (SAME AS FIG. 1, EXCEPT AS SHOWN)
 (SOME CENTER DETAILS REMOVED FOR CLARITY)

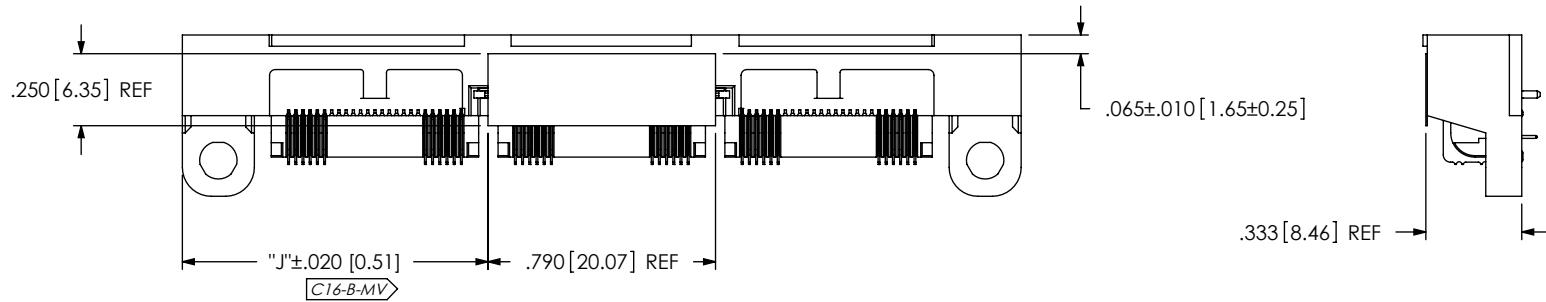


TABLE 6		
No OF POS	"J"	"J" - MTI OPTION
-25	0.274 [6.95]	0.472 [12.00]
-50	0.668 [16.95]	0.866 [22.00]
-75	1.061 [26.96]	1.260 [32.00]
*-100	1.455 [36.96]	1.654 [42.00]

* = SEE NOTE 12

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B C16, C19, C23	DO NOT SCALE DRAWING SHEET SCALE: 1:0.666667	DESCRIPTION: .635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP
C		DWG. NO. QSS-XXX-XX-XXX-D-RA-XX-XXX
D		BY: KEVIN B 01/22/02 SHEET 5 OF 6

FIG 5

QSS-075-01-XXX-D-RA-WT-MTI SHOWN
(SAME AS FIG. 1, EXCEPT AS SHOWN)
(SOME CENTER DETAILS REMOVED FOR CLARITY)

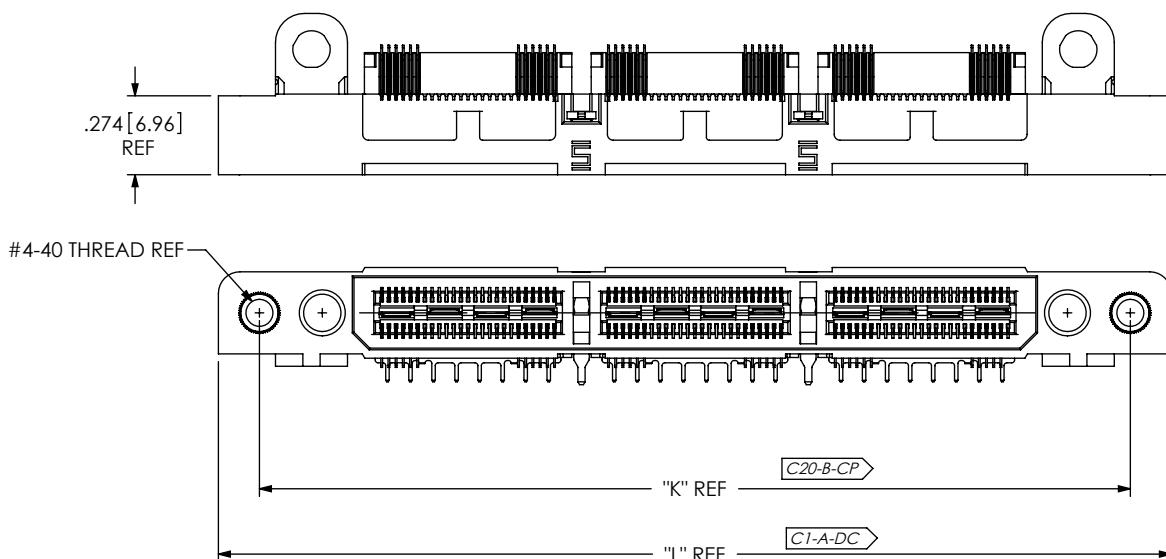


TABLE 7

POSITION	"K"	"L"
-025	1.450 [36.82]	1.735 [44.06]
-050	2.237 [56.82]	2.522 [64.06]
-075	3.025 [76.82]	3.310 [84.06]
*-100	3.812 [96.82]	4.097 [104.06]

* = SEE NOTE 12

TABLE 8: PLATING SPECIFICATIONS

	CONTACT 1	CONTACT 2	GROUND PLANE
-F	C-177-01-F: 3μ" FLASH GOLD CONTACT, MATTE TIN TAIL	C-178-02-F: 3μ" FLASH GOLD CONTACT, MATTE TIN TAIL	IM-1G18-XX-F: 3μ" FLASH GOLD CONTACT, MATTE TIN TAIL
-L	C-177-01-L: 10μ" LIGHT GOLD CONTACT, MATTE TIN TAIL	C-178-02-L: 10μ" LIGHT GOLD CONTACT, MATTE TIN TAIL	IM-1G18-XX-L: 10μ" LIGHT GOLD CONTACT, MATTE TIN TAIL
-H	C-177-01-H: 30μ" HEAVY GOLD CONTACT, 3μ" FLASH GOLD TAIL	C-178-02-H: 30μ" HEAVY GOLD CONTACT, 3μ" FLASH GOLD TAIL	IM-1G18-XX-L: 10μ" LIGHT GOLD CONTACT, MATTE TIN TAIL
-STL	C-177-01-STL: 30μ" SELECTIVE GOLD CONTACT, TIN/LEAD (90/10 +/-5%) TAIL	C-178-02-STL: 30μ" SELECTIVE GOLD CONTACT, TIN/LEAD (90/10 +/-5%) TAIL	IM-1G18-XX-STL: 30μ" SELECTIVE GOLD CONTACT, TIN/LEAD (90/10 +/-5%) TAIL
-FTL	C-177-01-FTL: 3μ" FLASH GOLD CONTACT, TIN/LEAD (90/10 +/-5%) TAIL	C-178-02-FTL: 3μ" FLASH GOLD CONTACT, TIN/LEAD (90/10 +/-5%) TAIL	IM-1G18-XX-FTL: 3μ" FLASH GOLD CONTACT, TIN/LEAD (90/10 +/-5%) TAIL

CRITICAL DIMENSION INSPECTION INSTRUCTION TABLE

ASSEMBLY OPERATION	IN-PROCESS INSPECTION
FILL C-177-XX-XXX	C1, C7, C8, C10
FILL IM-1G18-XX-1-XXX	C12, C17
FILL C-178-XX-XXX	C4, C5, C11, C24
FILL WT-16-XX-XX	C6, C21
-LS1	C1, C22
-MTI	C1, C20
-SP	C1, C19, C23
-K	C1, C16

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C	SHEET SCALE: 1:0.666667	QSS-XXX-XX-XXX-D-RA-XX-XXX
D		BY: KEVIN B 01/22/02 SHEET 6 OF 6

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