

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

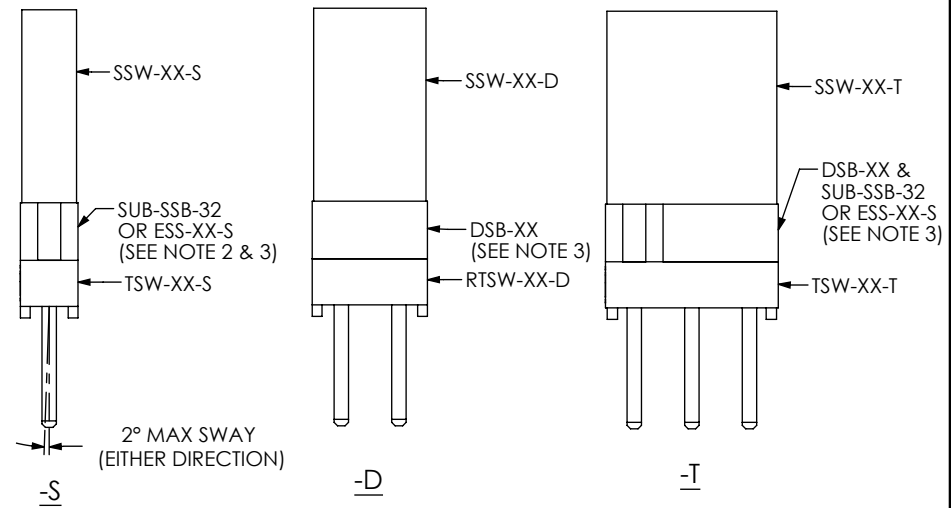
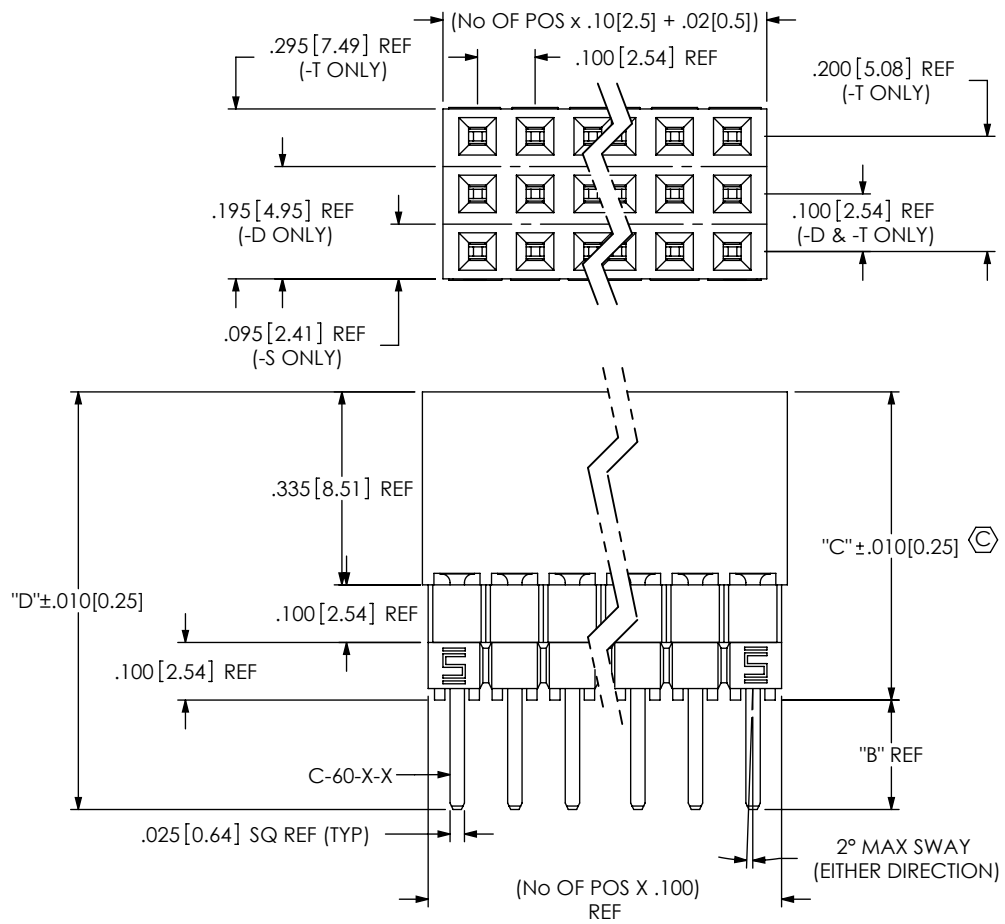


FIG 1  
 ESQ-110-XX-X-T

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE:  
 DECIMALS ANGLES  
 .XX: ±.01 [0.3] 2°  
 .XXX: ±.005 [0.13]  
 .XXXX: ±.0020 [0.051]

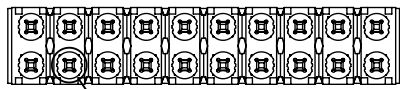
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 520 PARK EAST BLVD, NEW ALBANY, IN 47150  
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 e-Mail info@SAMTEC.com code 53322

MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 3:1  
 INSULATOR: LCP, UL 94 V0  
 COLOR: BLACK  
 CONTACT : PHOS BRONZE

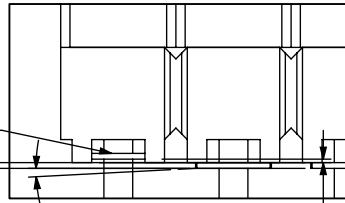
DESCRIPTION: ESQ STRIP ASM  
 DWG. NO. ESQ-1XX-XX-X-X-XXX-XX-X-XX

BY: JORDAN 7-16-85 SHEET 1 OF 4



DETAIL A  
SCALE 4:1

.005 [0.13] MAX  
MEASURE AT  
THE TAIL



DETAIL B  
SCALE 6:1

.003 [0.08] MAX  
MEASURE AT  
THE TAIL

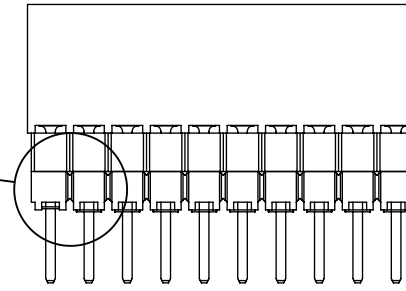
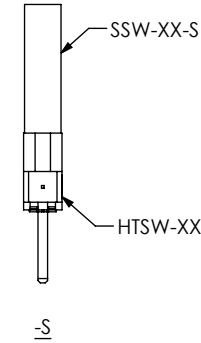


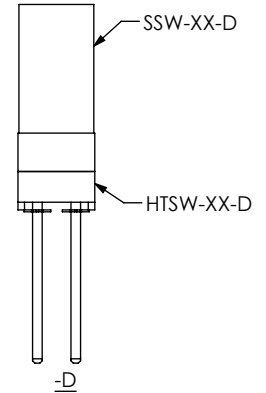
FIG 3

#-H-MW: METAL WASHER  
ESQ-110-XX-X-X-MWT  
(ONE PER POSITION)  
(-S & -D BODY SPECS ONLY)  
(SEE NOTE 5)

(SAME AS FIG 1 UNLESS OTHERWISE NOTED)



-S



-D

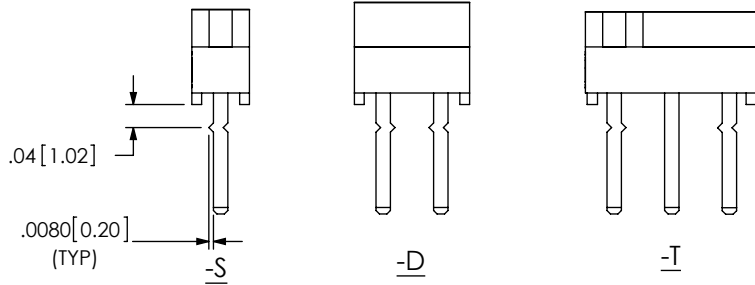
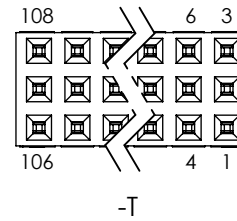
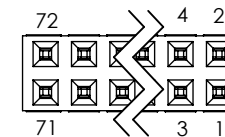


FIG 2

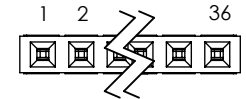
-LL: LOCKING LEAD OPTION  
LOCATED ON OR ABOUT CENTERLINE  
[N/A IN 1 OR 2 POSITION SINGLE ROW]



-I



-D



-S

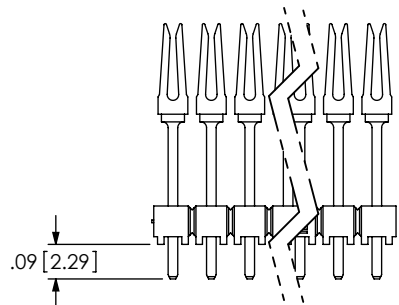
FIG 4  
XXX: POLARIZATION LOCATION  
INSERT PK-06-N INTO SPECIFIED POS  
AND BREAK OFF TAB

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

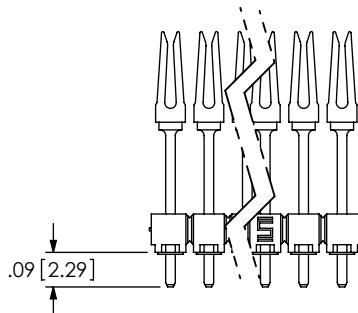
| STANDARD<br>INSERTION<br>FORCE | CONTACT  | SPACER SPECIFICATION<br>(FOR A ONE POSITION SINGLE SEE NOTE 3) |            |                           | "B"       | "C"         | "D"         | "E" |
|--------------------------------|----------|--|------------|---------------------------|-----------|-------------|-------------|-----|
|                                |          | ESQ-S  | ESQ-D      | ESQ-T                     |           |             |             |     |
|                                |          | -12  | C-15-2-X   | N/A                       |           |             |             |     |
| -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<br>INSERTION<br>FORCE      | CONTACT  | SPACER SPECIFICATION<br>(FOR A ONE POSITION SINGLE SEE NOTE 3) |            |                           | "B"       | "C"         | "D"         | "E" |
|                                |          | ESQ-S  | ESQ-D      | ESQ-T                     |           |             |             |     |
|                                |          | -37  | C-60-2-X   | N/A                       |           |             |             |     |
| -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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|  | <p>DESCRIPTION: ESQ STRIP ASM</p>  |                     |
|  | <p>DWG. NO. ESQ-1XX-XX-X-X-XXX-XX-X-XX</p>   |                     |
|  | <p>BY: WHITTAKER 9-11-98</p>   | <p>SHEET 2 OF 4</p> |

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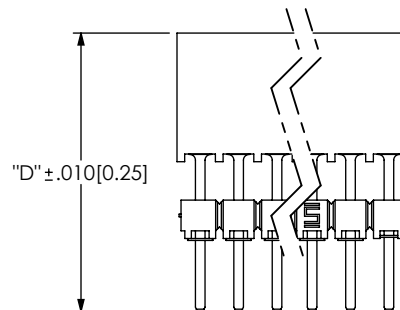


PRESS ON -MW

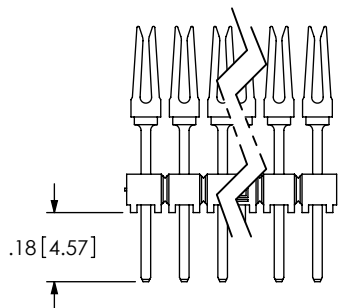


IN PROCESS  
-12, -33, -37, -58

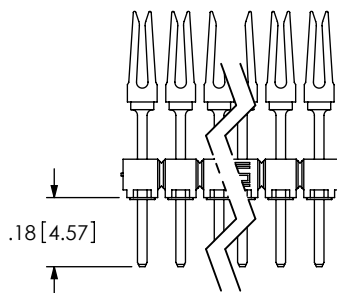
PRESS ON  
SSW BODY



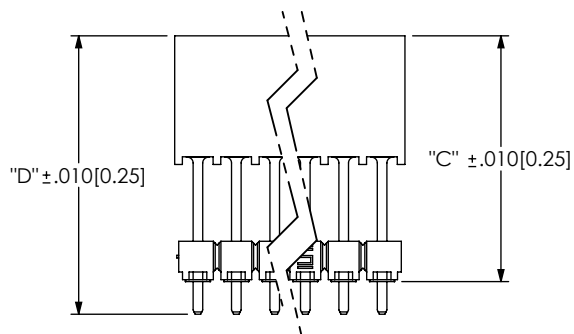
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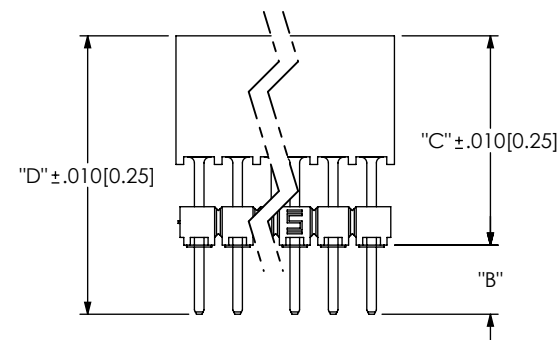
PRESS ON -MW



PRESS ON  
SSW BODY



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



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

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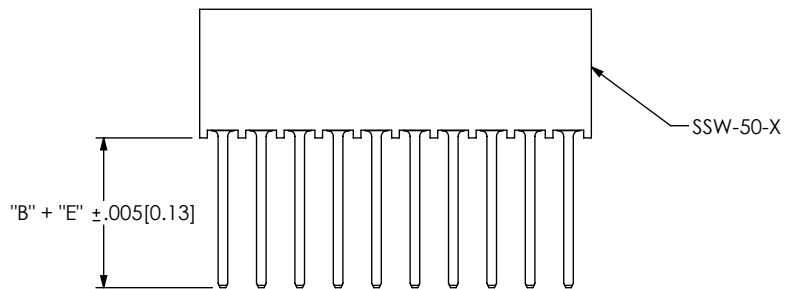
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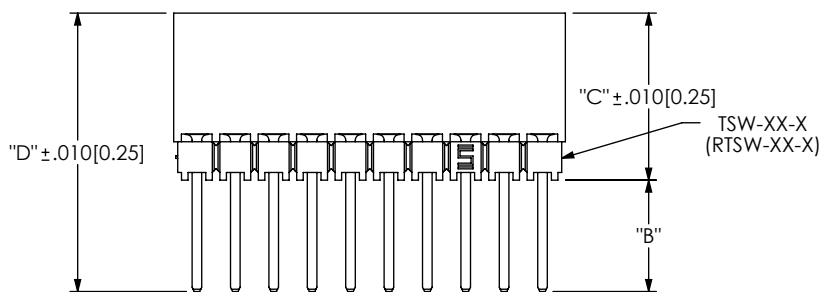
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BY: WITHTAKER 9-11-98

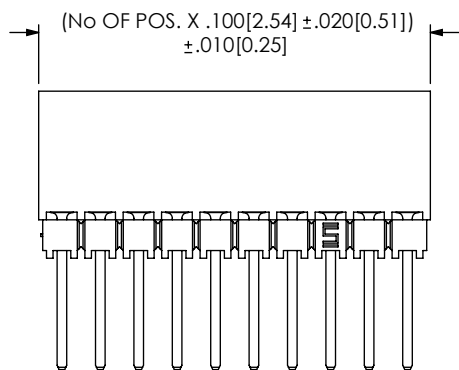
SHEET 3 OF 4



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   | -T  | PT-1-24-01-51 | TP-13    |
| -12, -37   |     | 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 PACKAGE -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.

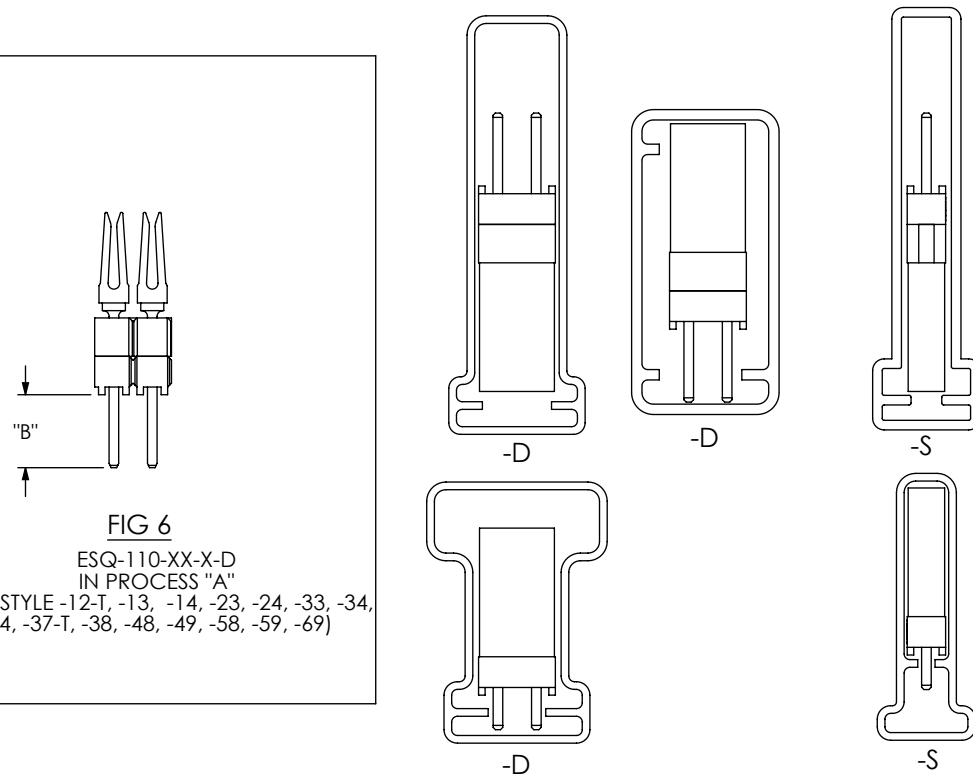


FIG 6  
ESQ-110-XX-X-D  
IN PROCESS "A"  
(LEAD STYLE -12-T, -13, -14, -23, -24, -33, -34, -44, -37-T, -38, -48, -49, -58, -59, -69)

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DESCRIPTION:

ESQ STRIP ASM

DWG. NO.

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

BY: WHITTAKER 9-11-98

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