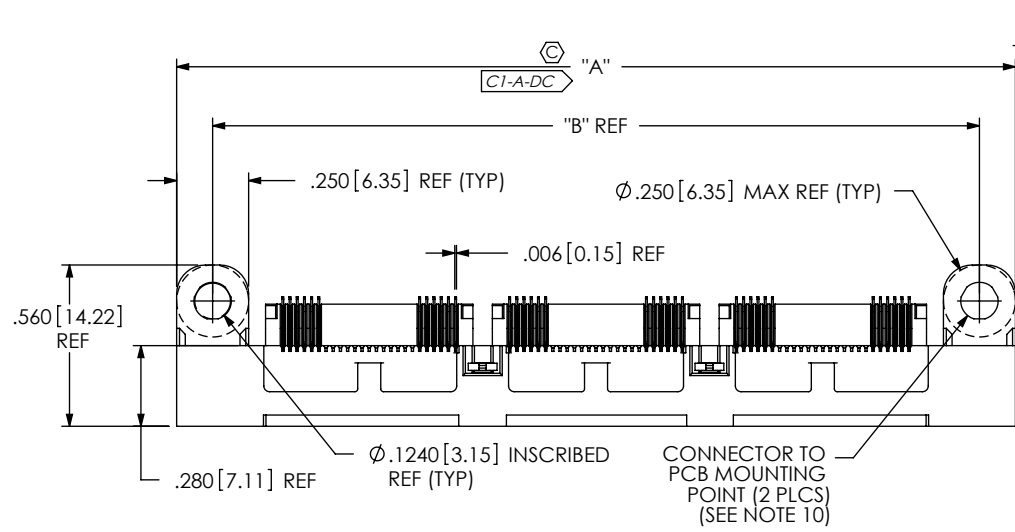


DO NOT SCALE FROM THIS PRINT

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



No OF POSITIONS
-025, -050, -075, *-100
(PER ROW)
(SEE NOTE 4)
*(SEE NOTE 12)

LEAD STYLE
-01: .062 BOARD
-02: .093 BOARD

PLATING SPECIFICATION
SEE TABLE 8, SHEET 6

ROW 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)

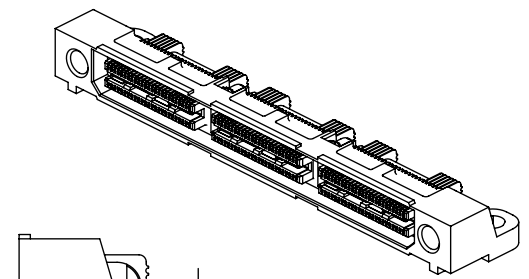
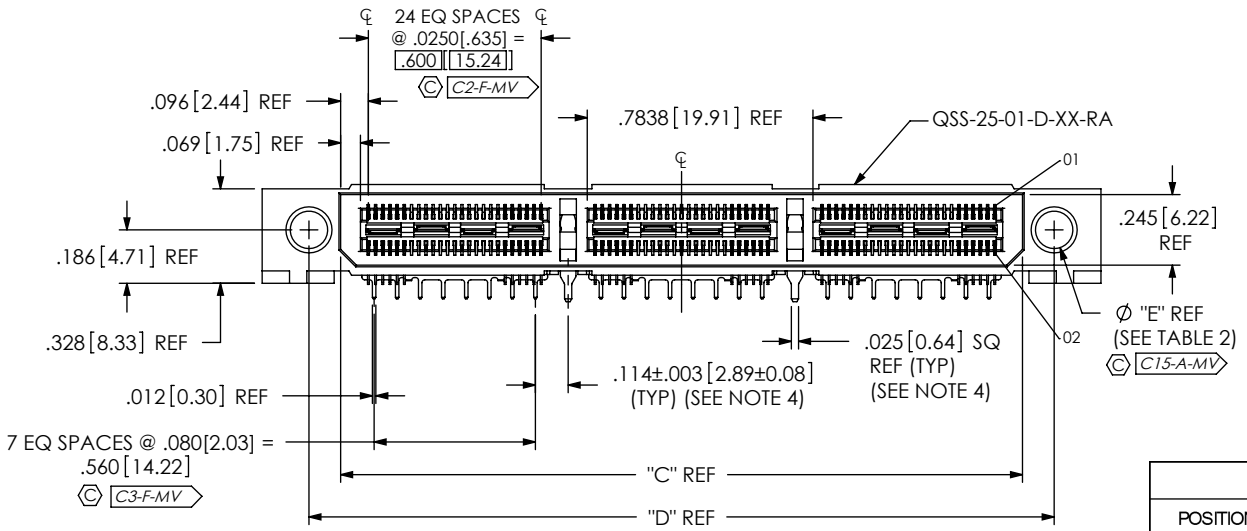


TABLE 2

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

TABLE 1

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. [CX-XX] 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.

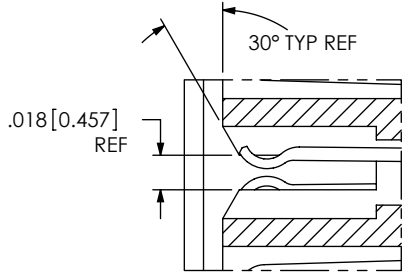
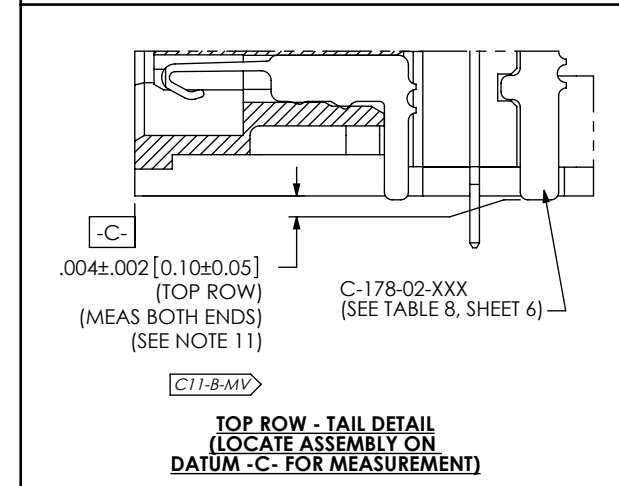
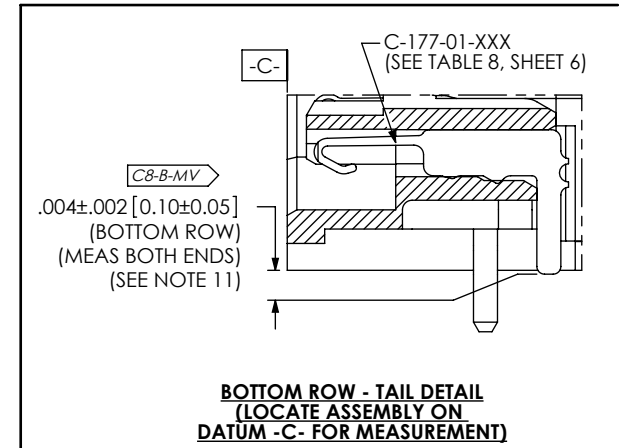
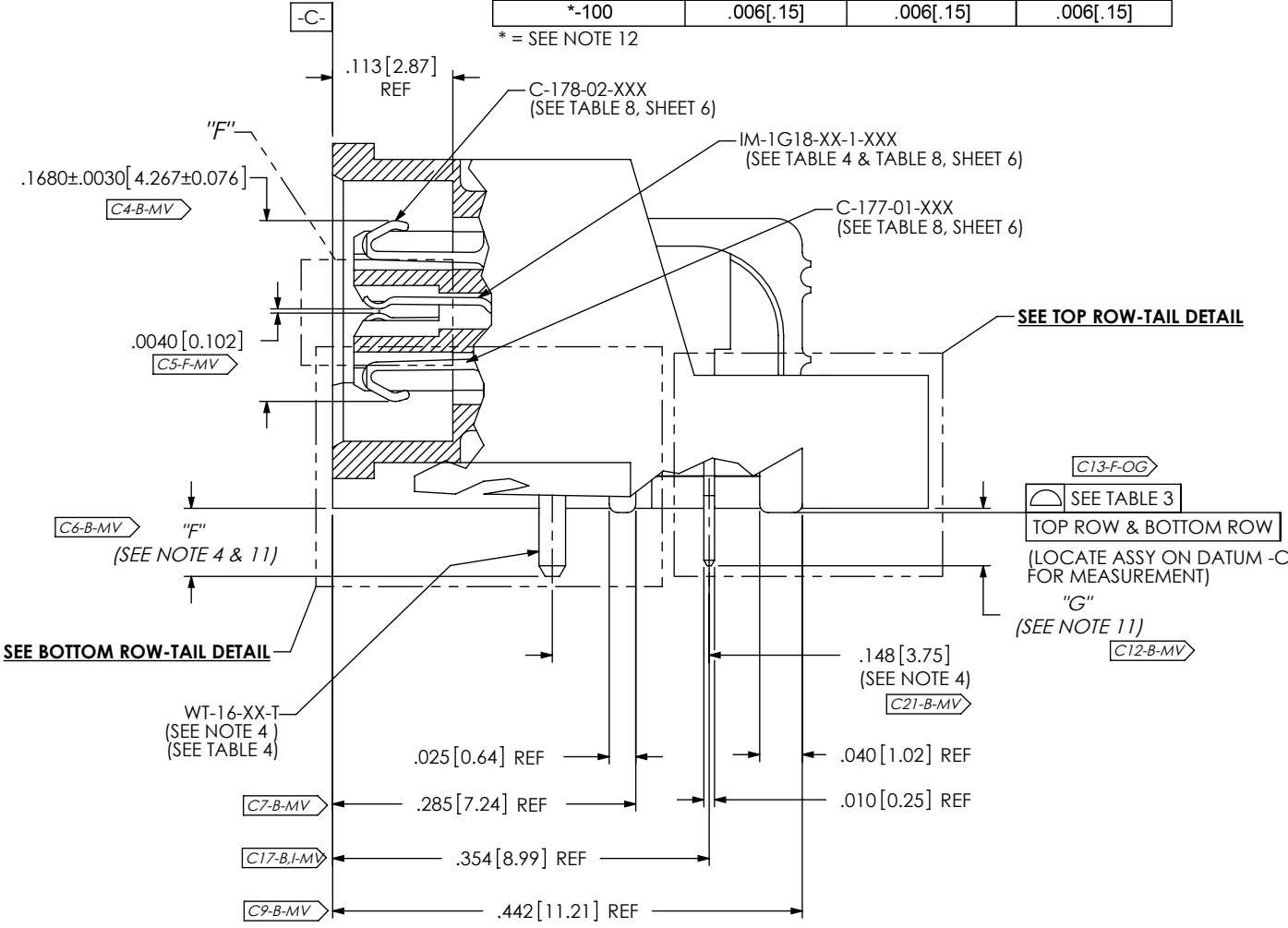
FIG 1
QSS-075-01-XXX-D-RA-WT SHOWN
(SOME CENTER DETAILS REMOVED FOR CLARITY)

CPC FREQUENCY THIS SHEET	A	C1, C15	UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE: DECIMALS ANGLES .XX: ±.01 [.3] 2° .XXX: ±.005 [.13] .XXXX: ±.0020 [.051]	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 WHICH IT WAS OBTAINED WITHOUT THE EXPRESSED WRITTEN CONSENT OF SAMTEC, INC.	 520 PARK EAST BLVD, NEW ALBANY, IN 47150 PHONE: 812-944-6733 FAX: 812-948-5047 e-Mail: info@SAMTEC.com code 55322	
	B					MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 1.5:1
	C					INSULATOR: LCP, COLOR: BLACK
	D					TERMINAL, GROUND PLANE & WELD TAB: PHOS BRONZE
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 1 OF 6			

TABLE 3			
No OF POSITIONS	COPLANARITY	STRAIGHTNESS ROW 1	STRAIGHTNESS 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



DETAIL "F" SCALE 10:1

CPC FREQUENCY THIS SHEET
A
B C4, C6, C7, C8, C9, C11, C12, C17, C21
C
D

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SHEET SCALE: 6:1

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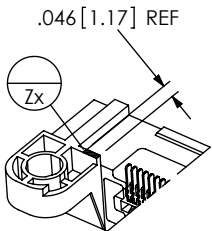
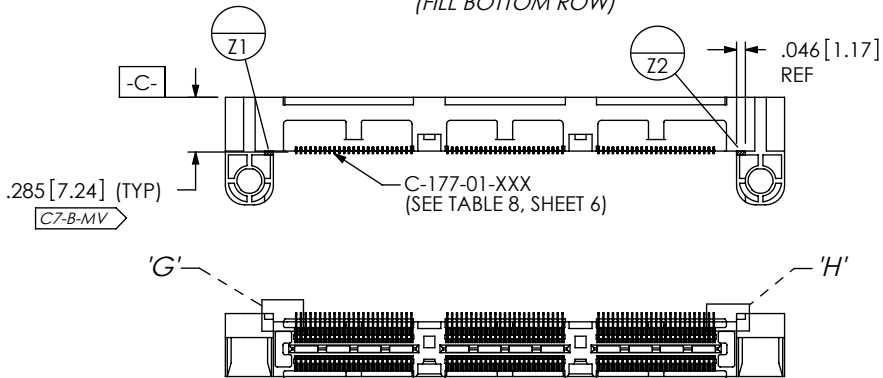
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 e-Mail info@SAMTEC.com code 55322

DESCRIPTION:
 .635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

DWG. NO.
QSS-XXX-XX-XXX-D-RA-XX-XXX

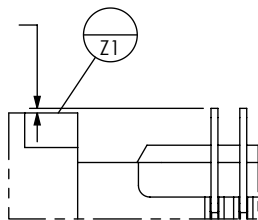
BY: KEVIN B 01/22/02 SHEET 2 OF 6

INSPECTION VIEW 1
(FILL BOTTOM ROW)

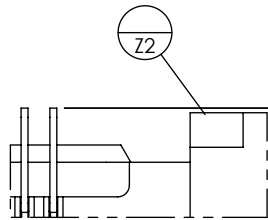


ISO VIEW OF
-Z- DATUM ZONE

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



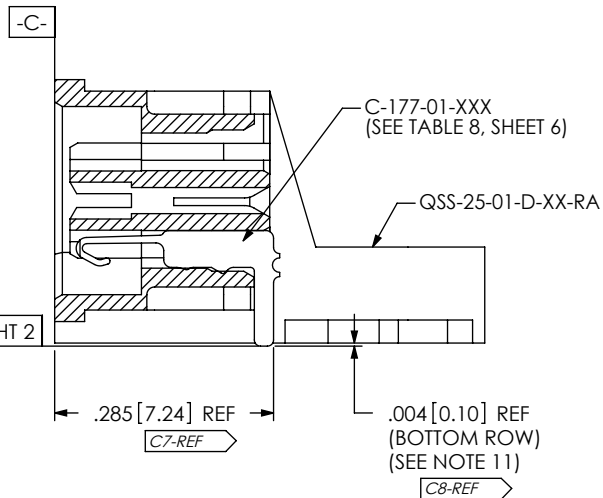
DETAIL 'G'
SCALE 6:1



DETAIL 'H'
SCALE 6:1

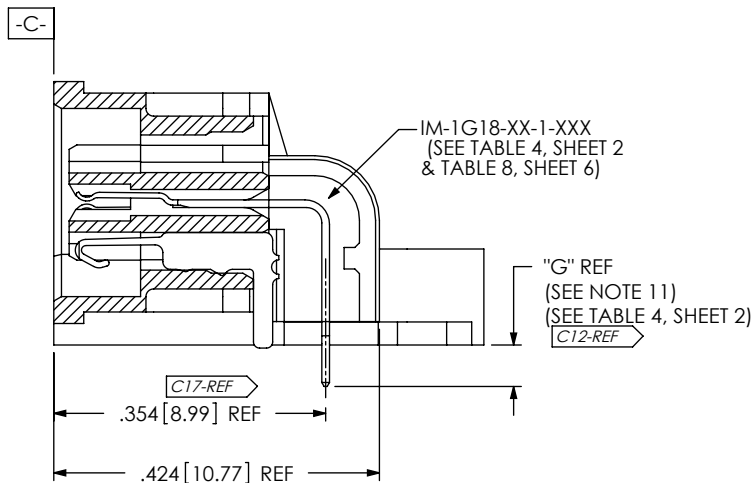
SEE TABLE 3, SHT 2
WITHIN ROW

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



IN-PROCESS 1
(FILL BOTTOM ROW)

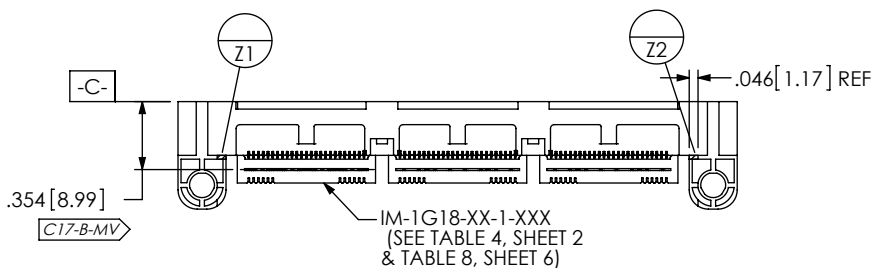
(SEE INSPECTION VIEW 1 FOR ORIENTATION AND CPC'S)



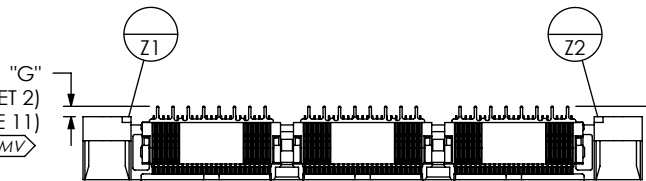
IN-PROCESS 2
(FILL IM-1G18)

(SEE INSPECTION VIEW 2 FOR ORIENTATION AND CPC'S)

INSPECTION VIEW 2
(FILL IM-1G18)



"G"
(SEE TABLE 4, SHEET 2)
(SEE NOTE 11)



"G"
(SEE TABLE 4, SHEET 2)
(SEE NOTE 11)

CPC FREQUENCY THIS SHEET	
A	
B	C7, C8, C10, C12, C17
C	
D	

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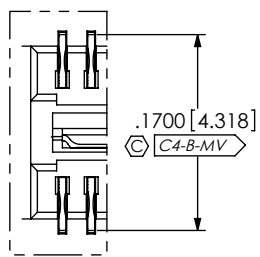
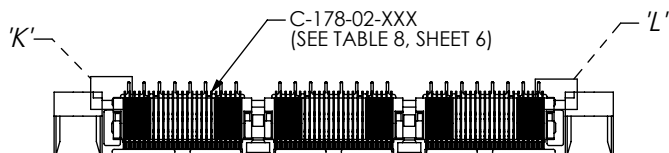
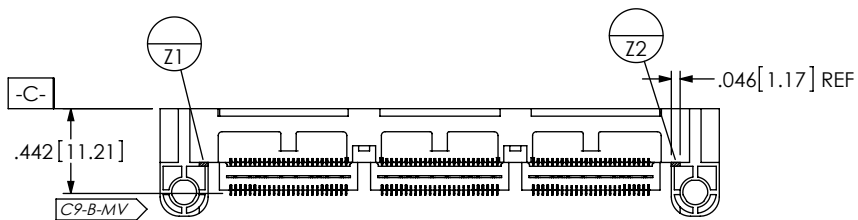
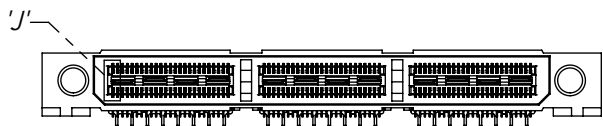
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SHEET SCALE: 1.5:1



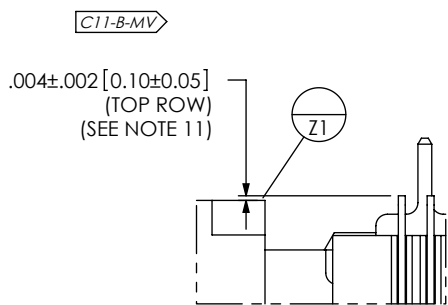
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DESCRIPTION:
.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP
DWG. NO.
QSS-XXX-XX-XXX-D-RA-XX-XXX
BY: KEVIN B 01/22/02 SHEET 3 OF 6

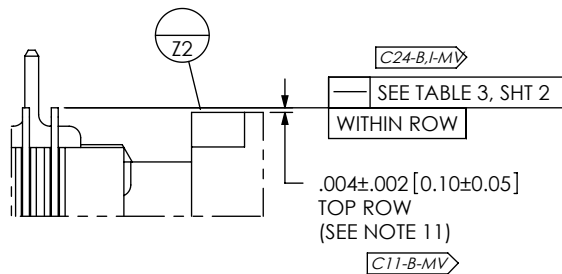
INSPECTION VIEW 3
(FILL TOP ROW)



DETAIL 'J'
SCALE 6:1



DETAIL 'K'
SCALE 6:1



DETAIL 'L'
SCALE 6:1

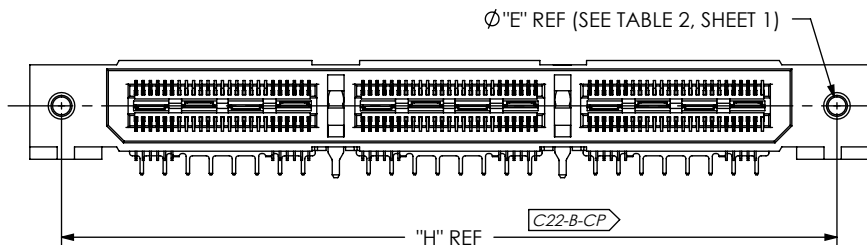
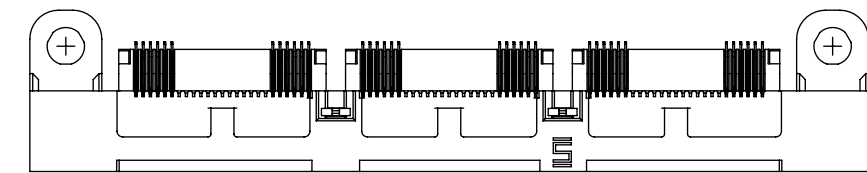
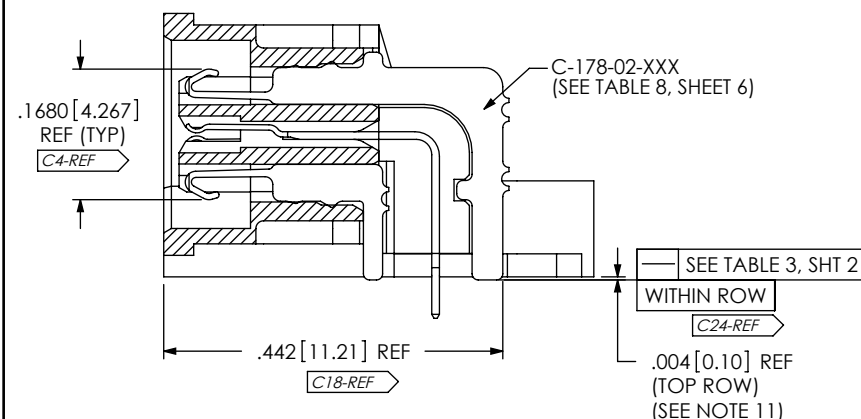


FIG 2

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

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



IN-PROCESS 3
(FILL TOP ROW)

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

CPC FREQUENCY THIS SHEET	
A	
B	C4, C9, C10, C11, C22, C24
C	
D	

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.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

DWG. NO.
QSS-XXX-XX-XXX-D-RA-XX-XXX

BY: KEVIN B 01/22/02 SHEET 4 OF 6

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)

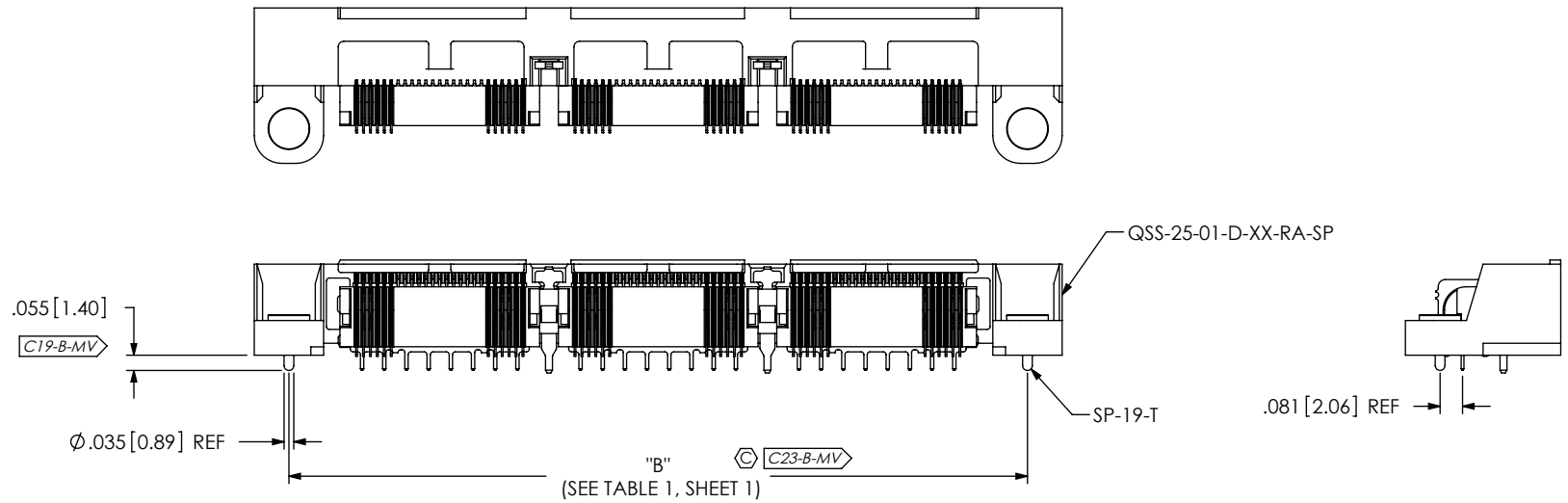


FIG 4
 -K OPTION
 QSS-075-01-XXX-D-RA-WT-K SHOWN
 (SAME AS FIG. 1, EXCEPT AS SHOWN)
 (SOME CENTER DETAILS REMOVED FOR CLARITY)

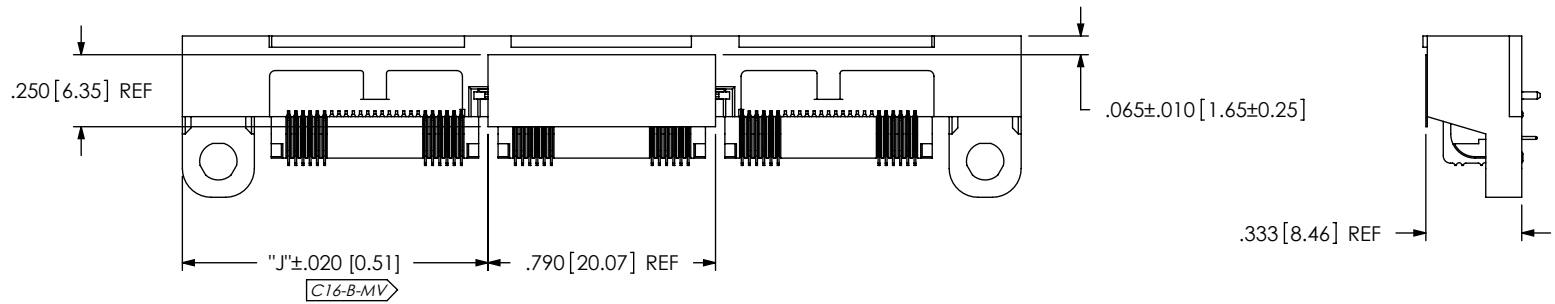


TABLE 6

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

CPC FREQUENCY THIS SHEET	
A	
B	C16, C19, C23
C	
D	

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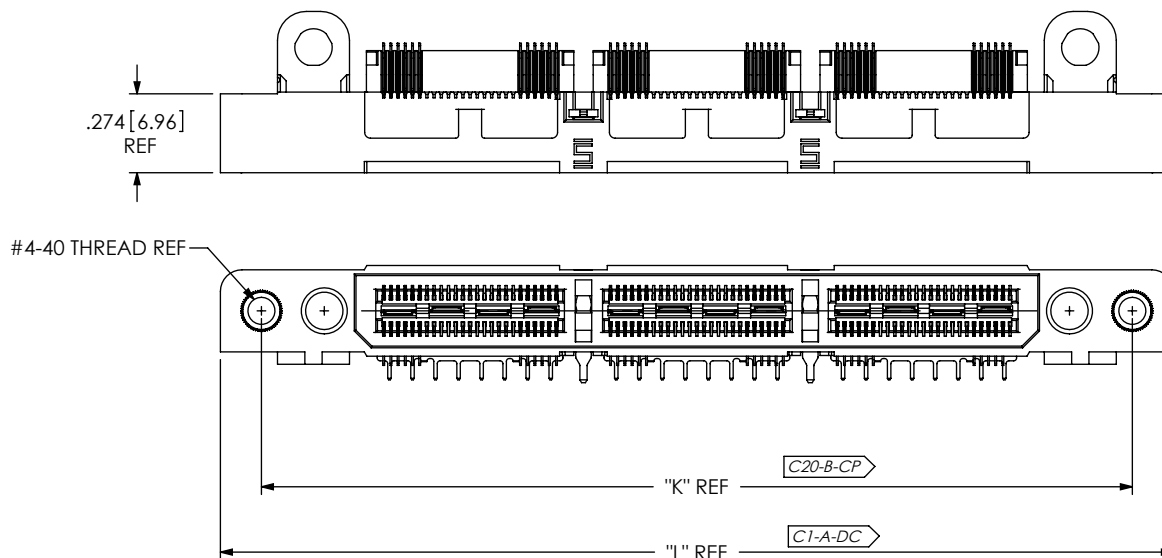
DWG. NO.

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

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)



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

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

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

CPC FREQUENCY THIS SHEET	
A	C1
B	C20
C	
D	

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