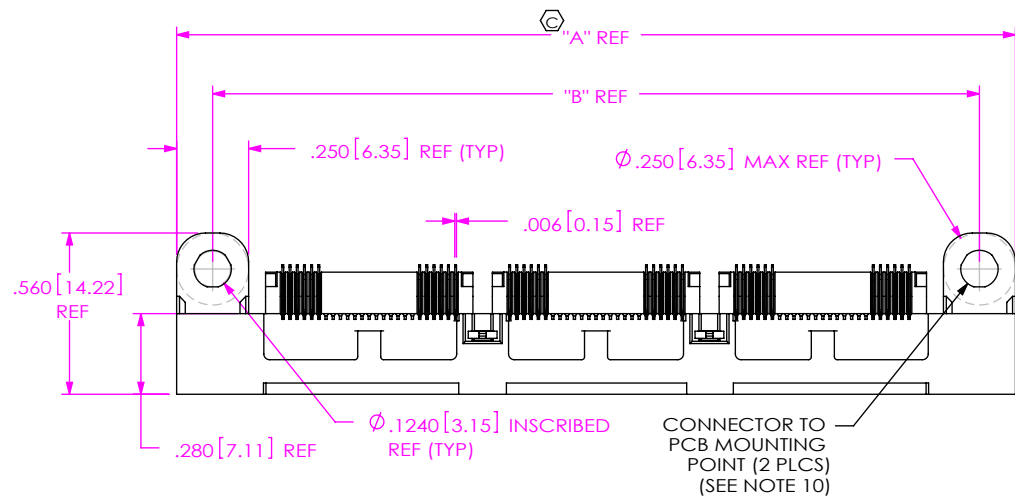


DO NOT SCALE FROM THIS PRINT

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
 (NOT AVAILABLE
 W/ LS1 OPTION)
 (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)

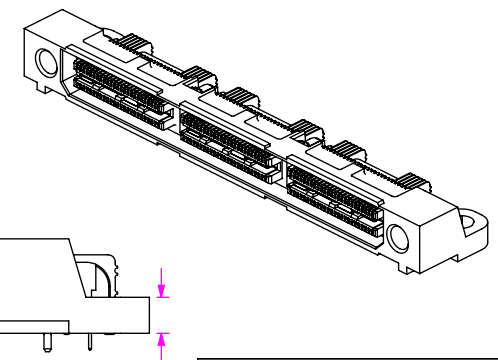
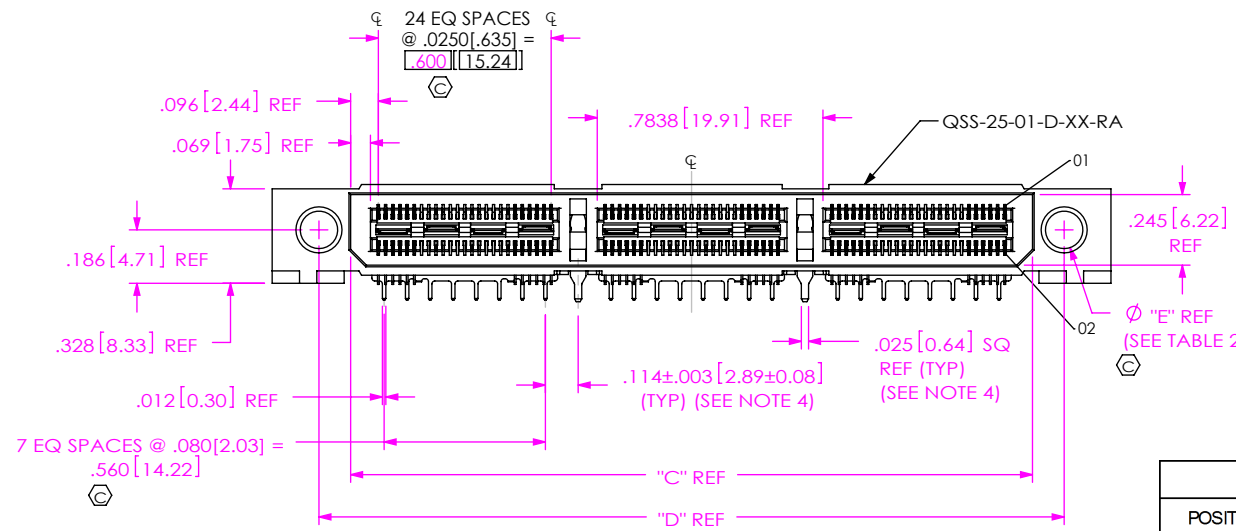


TABLE 2

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. \odot 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)

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 CONFIDENTIAL AND PROPRIETARY INFORMATION AND ALL DESIGN, MANUFACTURING, REPRODUCTION, USE, PATENT RIGHTS AND SALES RIGHTS ARE EXPRESSLY RESERVED BY SAMTEC, INC. THIS DOCUMENT SHALL NOT BE DISCLOSED, IN WHOLE OR PART, TO ANY UNAUTHORIZED PERSON OR ENTITY NOR REPRODUCED, TRANSFERRED OR INCORPORATED IN ANY OTHER PROJECT IN ANY MANNER WITHOUT THE EXPRESS 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

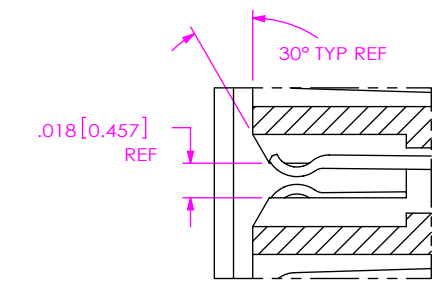
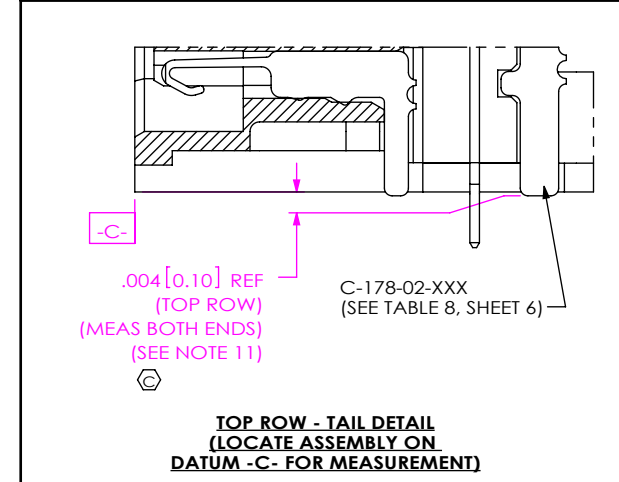
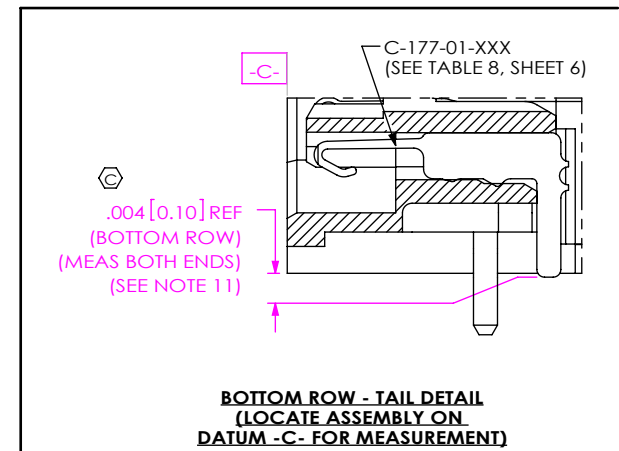
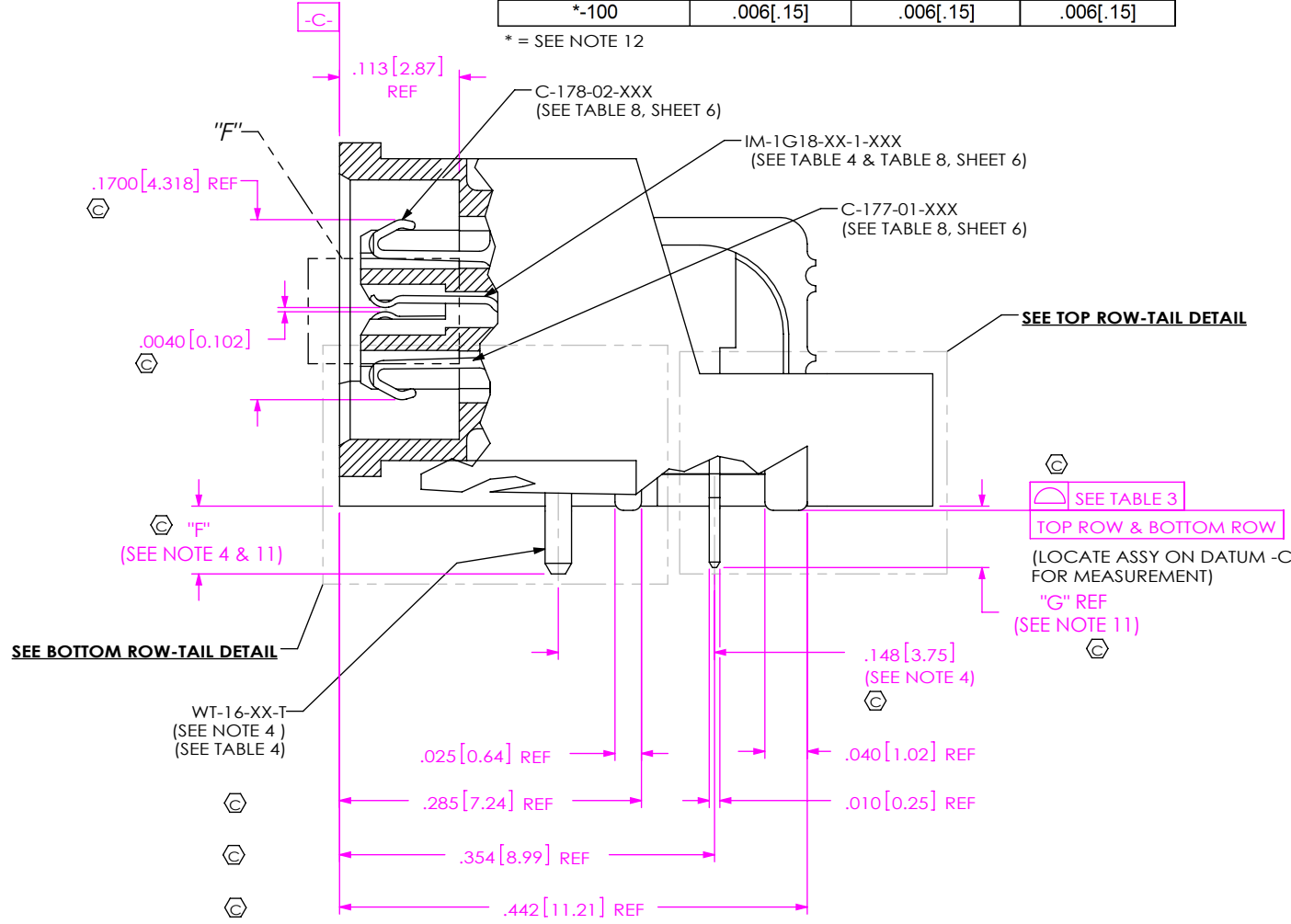
MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 1.5:1
INSULATOR: LCP, COLOR: BLACK
TERMINAL, GROUND PLANE & WELD TAB: PHOS BRONZE

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 BOTTOM ROW	STRAIGHTNESS TOP ROW
-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

PROPRIETARY NOTE
THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION AND ALL DESIGN, MANUFACTURING, REPRODUCTION, USE, PATENT RIGHTS AND SALES RIGHTS ARE EXPRESSLY RESERVED BY SAMTEC, INC. THIS DOCUMENT SHALL NOT BE DISCLOSED, IN WHOLE OR IN PART, TO ANY UNAUTHORIZED PERSON OR ENTITY NOR REPRODUCED, TRANSFERRED OR INCORPORATED IN ANY OTHER PROJECT IN ANY MANNER WITHOUT THE EXPRESS WRITTEN CONSENT OF SAMTEC, INC.

DO NOT SCALE DRAWING
SHEET SCALE: 6:1

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

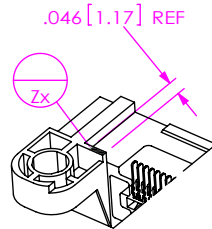
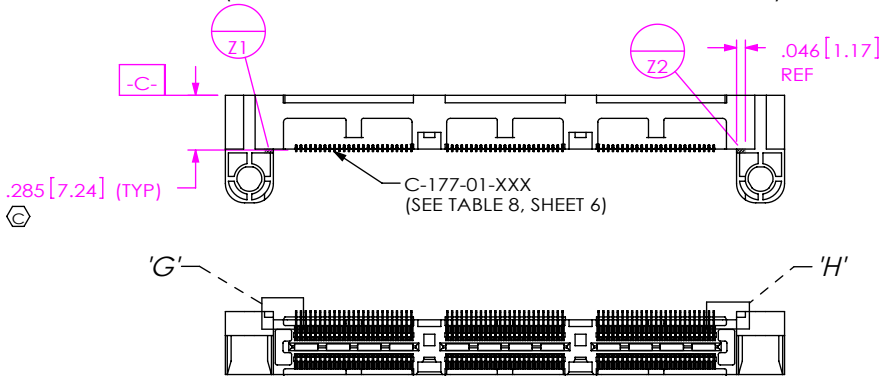
DESCRIPTION:
.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

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

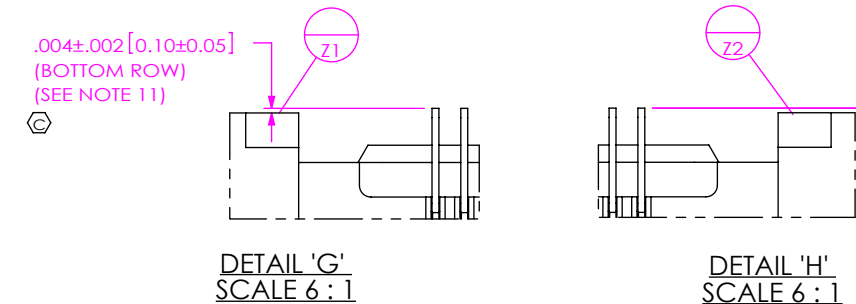
BY: KEVIN B 01/22/02 SHEET 2 OF 6

INSPECTION VIEW 1

(FILL BOTTOM ROW)
(LOCATE ASSEMBLY ON DATUM -C- FOR MEASUREMENT)

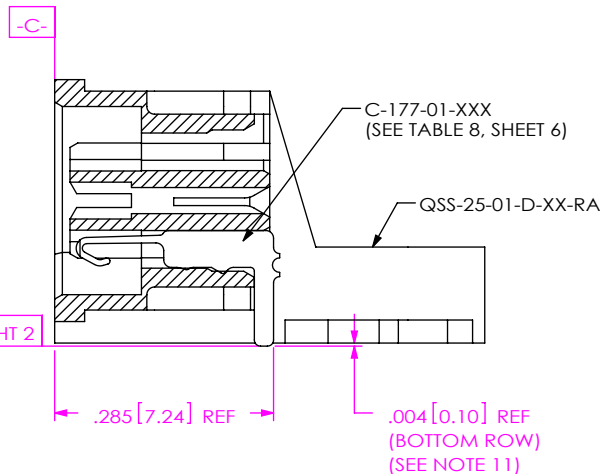


ISO VIEW OF
Z- DATUM ZONE

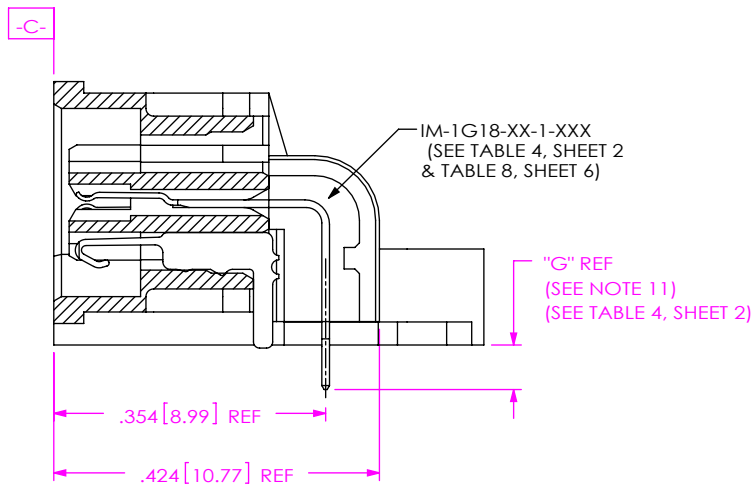


SEE TABLE 3, SHT 2
WITHIN ROW

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



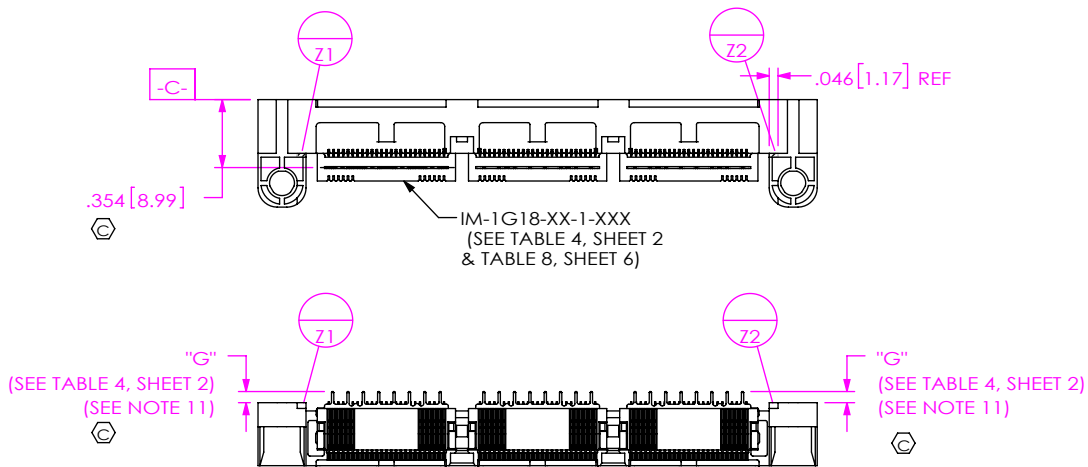
IN-PROCESS 1
(FILL BOTTOM ROW)
(SEE INSPECTION VIEW 1 FOR ORIENTATION AND CPC'S)



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

INSPECTION VIEW 2

(FILL IM-1G18)



PROPRIETARY NOTE
THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION AND ALL DESIGN, MANUFACTURING, REPRODUCTION, USE, PATENT RIGHTS AND SALES RIGHTS ARE EXPRESSLY RESERVED BY SAMTEC, INC. THIS DOCUMENT SHALL NOT BE DISCLOSED, IN WHOLE OR PART, TO ANY UNAUTHORIZED PERSON OR ENTITY NOR REPRODUCED, TRANSFERRED OR INCORPORATED IN ANY OTHER PROJECT IN ANY MANNER WITHOUT THE EXPRESS WRITTEN CONSENT OF SAMTEC, INC.

DO NOT SCALE DRAWING

SHEET SCALE: 1.5:1



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

DESCRIPTION:
.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

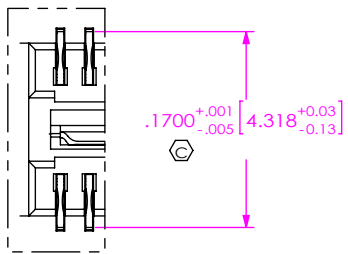
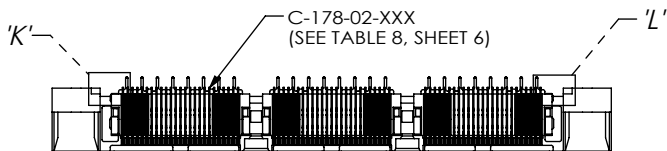
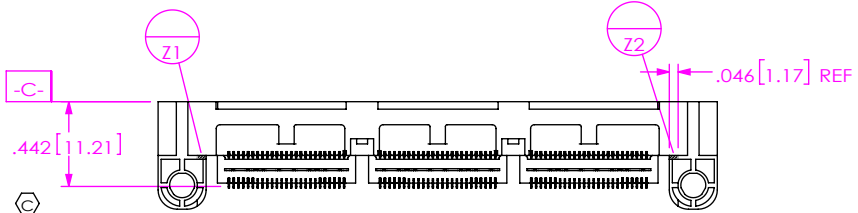
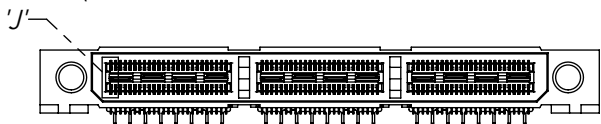
DWG. NO.
QSS-XXX-XX-XXX-D-RA-XX-XXX

BY: KEVIN B 01/22/02 SHEET 3 OF 6

INSPECTION VIEW 3

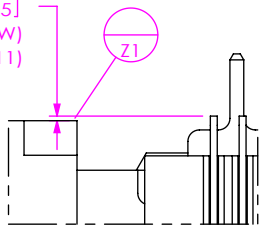
(FILL TOP ROW)

(LOCATE ASSEMBLY ON DATUM -C- FOR MEASUREMENT)

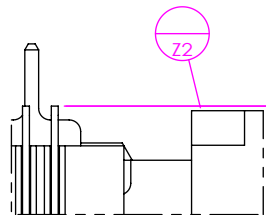


DETAIL 'J'
SCALE 6:1

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



DETAIL 'K'
SCALE 6:1



DETAIL 'L'
SCALE 6:1

SEE TABLE 3, SHT 2
WITHIN ROW

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

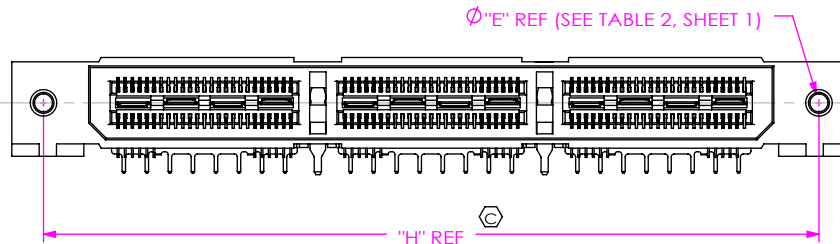
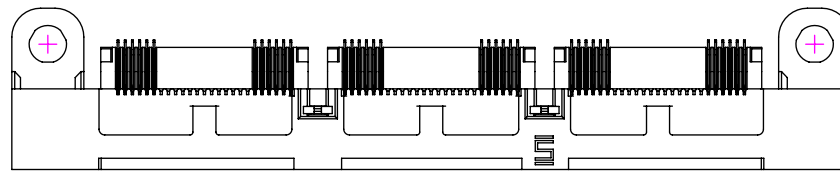
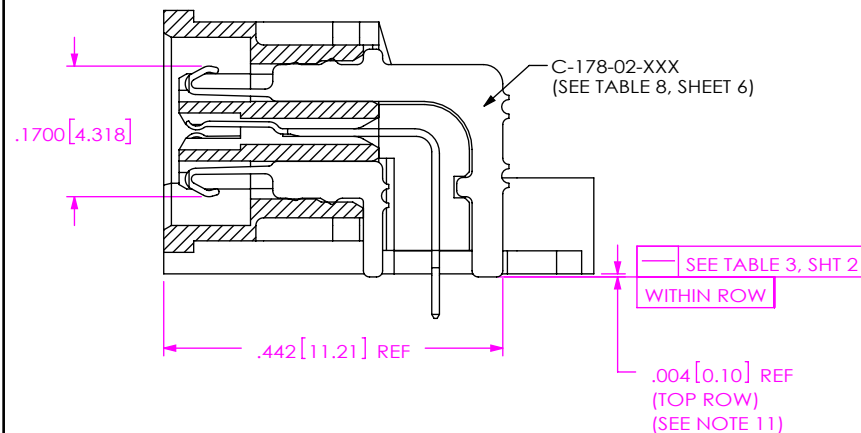


FIG 2

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)

PROPRIETARY NOTE
THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION AND ALL DESIGN, MANUFACTURING, REPRODUCTION, USE, PATENT RIGHTS AND SALES RIGHTS ARE EXPRESSLY RESERVED BY SAMTEC, INC. THIS DOCUMENT SHALL NOT BE DISCLOSED, IN WHOLE OR PART, TO ANY UNAUTHORIZED PERSON OR ENTITY NOR REPRODUCED, TRANSFERRED OR INCORPORATED IN ANY OTHER PROJECT IN ANY MANNER WITHOUT THE EXPRESS WRITTEN CONSENT OF SAMTEC, INC.

DO NOT SCALE DRAWING
SHEET SCALE: 1.5:1



520 PARK EAST BLVD. NEW ALBANY, IN 47150
PHONE: 812-944-6733 FAX: 812-948-5047
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 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)

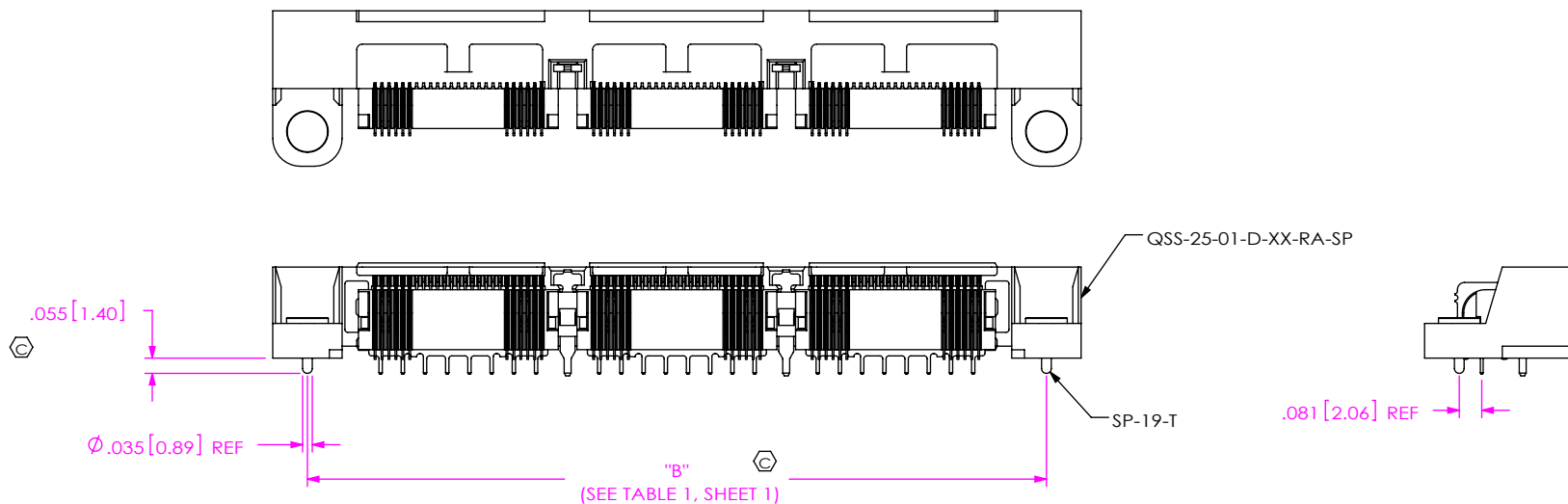


FIG 4
 -K OPTION
 QSS-075-01-XXX-D-RA-WT-K SHOWN
 (SAME AS FIG. 1, EXCEPT AS SHOWN)
 (SOME CENTER DETAILS REMOVED FOR CLARITY)

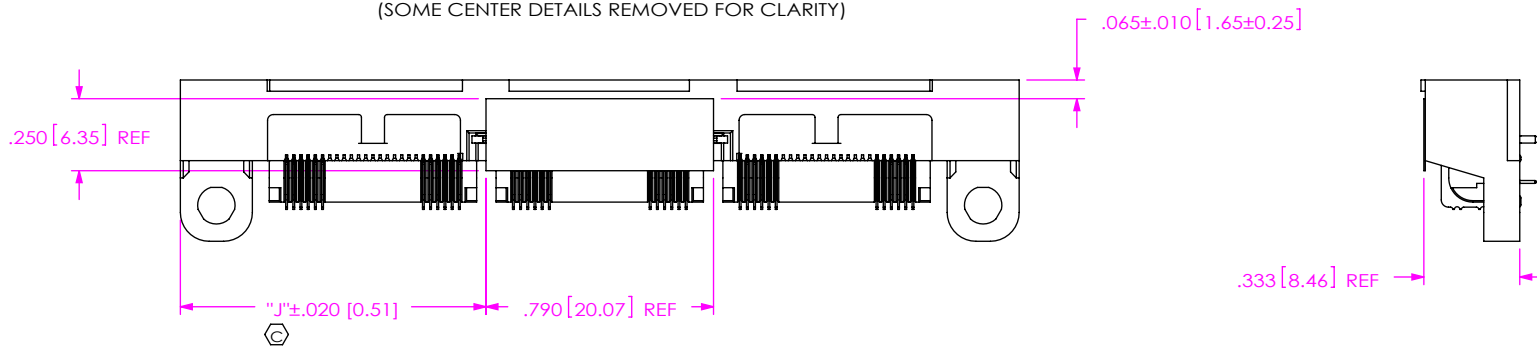


TABLE 6

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

PROPRIETARY NOTE
 * THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION AND ALL DESIGN, MANUFACTURING, REPRODUCTION, USE, PATENT RIGHTS AND SALES RIGHTS ARE EXPRESSLY RESERVED BY SAMTEC, INC. THIS DOCUMENT SHALL NOT BE DISCLOSED, IN WHOLE OR PART, TO ANY UNAUTHORIZED PERSON OR ENTITY NOR REPRODUCED, TRANSFERRED OR INCORPORATED IN ANY OTHER PROJECT IN ANY MANNER WITHOUT THE EXPRESS WRITTEN CONSENT OF SAMTEC, INC.

DO NOT SCALE DRAWING

SHEET SCALE: 1:0.666667



520 PARK EAST BLVD, NEW ALBANY, IN 47150
 PHONE: 812-944-6733 FAX: 812-948-5047
 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 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)

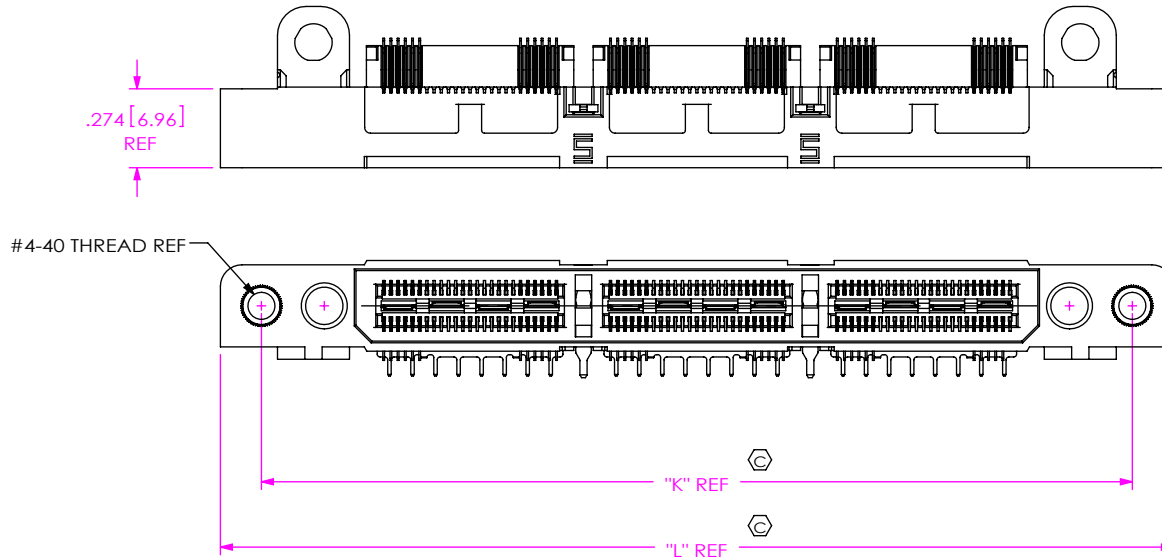


TABLE 7		
POSITION	"K"	"L"
-025	1.450 [36.82]	1.735 [44.06]
-050	2.237 [56.82]	2.522 [64.06]
-075	3.025 [76.82]	3.310 [84.06]
*-100	3.812 [96.82]	4.097 [104.06]

* = 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

PROPRIETARY NOTE

THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION AND ALL DESIGN, MANUFACTURING, REPRODUCTION, USE, PATENT RIGHTS AND SALES RIGHTS ARE EXPRESSLY RESERVED BY SAMTEC, INC. THIS DOCUMENT SHALL NOT BE DISCLOSED, IN WHOLE OR PART, TO ANY UNAUTHORIZED PERSON OR ENTITY NOR REPRODUCED, TRANSFERRED OR INCORPORATED IN ANY OTHER PROJECT IN ANY MANNER WITHOUT THE EXPRESS WRITTEN CONSENT OF SAMTEC, INC.

DO NOT SCALE DRAWING

SHEET SCALE: 1:0.666667



520 PARK EAST BLVD, NEW ALBANY, IN 47150
 PHONE: 812-944-6733 FAX: 812-948-5047
 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 6 OF 6