

DO NOT SCALE FROM THIS PRINT

- NOTES:
1. MINIMUM CONTACT PUSHOUT: 1.5 LBS.
  2. FOR A 1 POSITION SINGLE ROW ALL SPACERS ARE TO BE TSW-XX-S.
  3. NOTE DELETED.
  4. MAXIMUM ALLOWABLE BOW .003[0.08] INCH/INCH AFTER ASSMBLY
  5. DO NOT USE DSB SPACER BODY FOR THIS OPTION.
  6. MAXIMUM CUT FLASH : .010[0.25]; MAXIMUM CUT FLASH ON TAIL SIDE: .020[0.51] NOT TO EXTEND BELOW STANDOFFS

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

\*SEE NOTE 6

**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 FIG 1)  
 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

**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

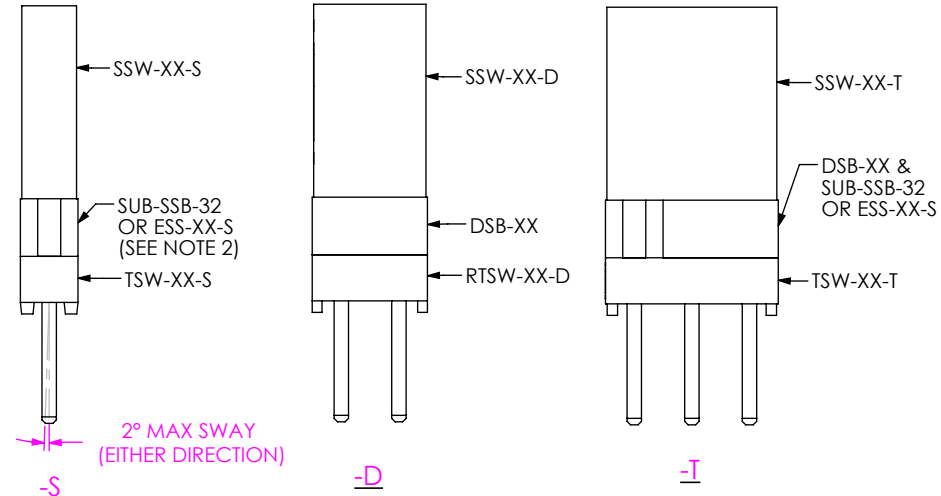
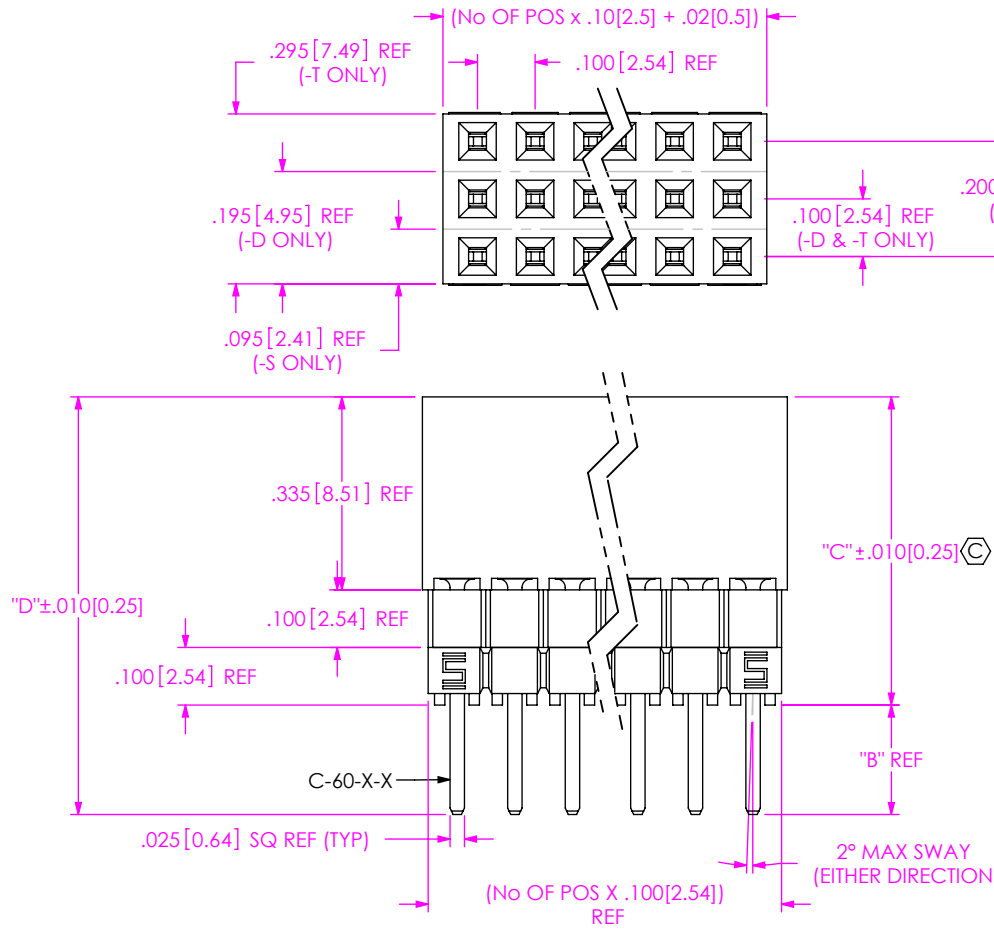


FIG 1  
 ESQ-110-XX-X-T

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

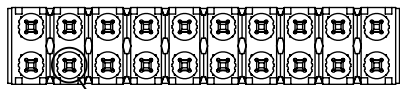
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MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 3:1  
 INSULATOR: LCP, UL 94 V0  
 COLOR: BLACK  
 CONTACT : PHOS BRONZE



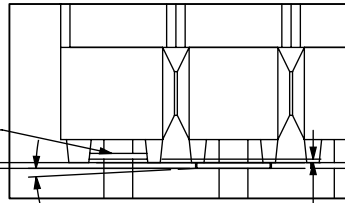
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DESCRIPTION:	ESQ STRIP ASM
DWG. NO.	ESQ-1XX-XX-X-X-XXX-XX-X-XX
BY: JORDAN	7-16-85 SHEET 1 OF 4



ESQ-110-XX-X-D-MW-T  
 .005 [0.13] MAX MEASURE AT THE TAIL

DETAIL A  
 SCALE 4 : 1



3° MAX SWAY ANY DIRECTION  
 .003 [0.08] MAX MEASURE AT THE TAIL

DETAIL B  
 SCALE 6 : 1

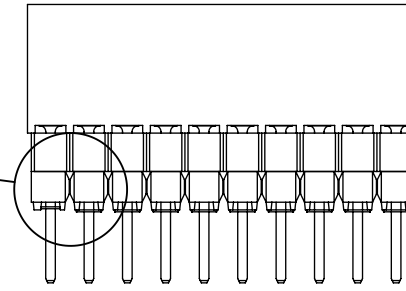


FIG 3  
 #-H-MW: METAL WASHER  
 ESQ-110-XX-X-MWT  
 (ONE PER POSITION)  
 (-S & -D BODY SPECS ONLY)  
 (SEE NOTE 5)  
 (SAME AS FIG 1 UNLESS OTHERWISE NOTED)

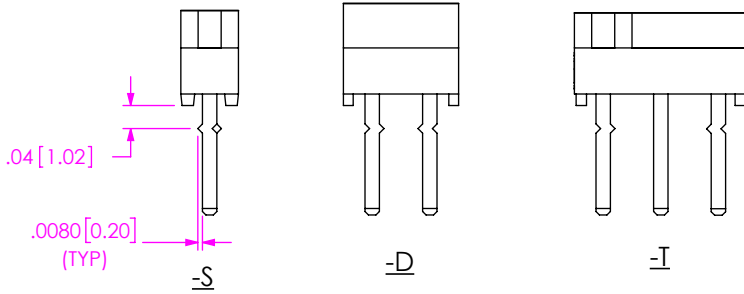
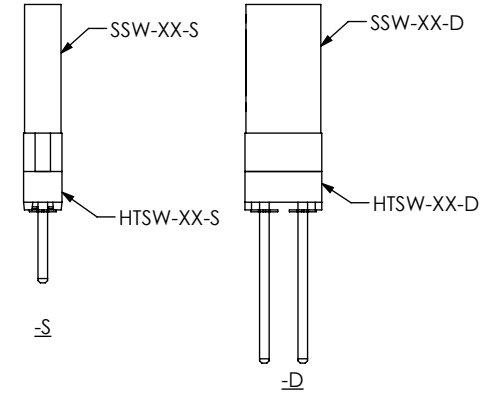


FIG 2  
 -LL: LOCKING LEAD OPTION  
 LOCATED ON OR ABOUT CENTERLINE  
 [N/A IN 1 OR 2 POSITION SINGLE ROW]

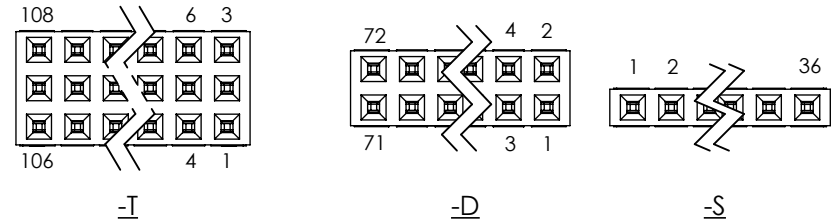


FIG 4  
 XXX: POLARIZATION LOCATION  
 INSERT PK-06-N INTO SPECIFIED POS  
 AND BREAK OFF TAB

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

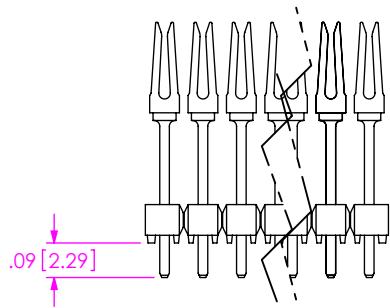
STANDARD INSERTION FORCE	CONTACT	SPACER SPECIFICATION (FOR A ONE POSITION SINGLE SEE NOTE 3)			"B"	"C"	"D"	"E"
		ESQ-S	ESQ-D	ESQ-T				
		-12	C-15-2-X	N/A				
-13	C-15-3-X	N/A	N/A	N/A	.29[7.37]	.435[11.05]	.725[18.41]	N/A
-14	C-15-4-X	N/A	N/A	N/A	.48[12.2]	.435[11.05]	.915[23.24]	N/A
-23	C-15-3-X	(1) 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 INSERTION FORCE	CONTACT	SPACER SPECIFICATION (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	(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
-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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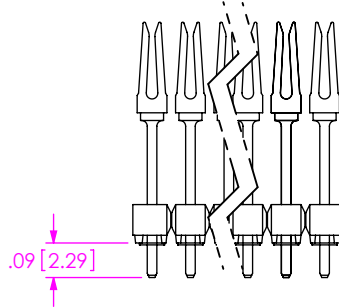
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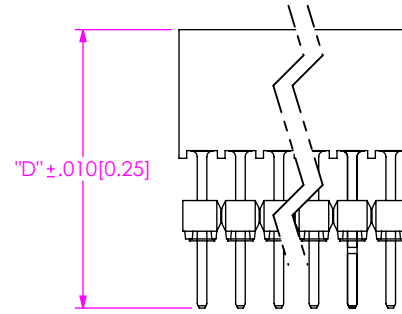
DESCRIPTION: ESQ STRIP ASM  
 DWG. NO. ESQ-1XX-XX-X-X-XXX-XX-X-XX  
 BY: WHITTAKER 9-11-98 SHEET 2 OF 4



LOAD CONTACT

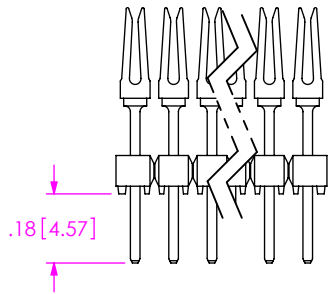


PRESS ON -MW

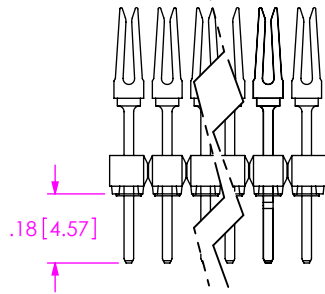


PRESS ON  
SSW BODY

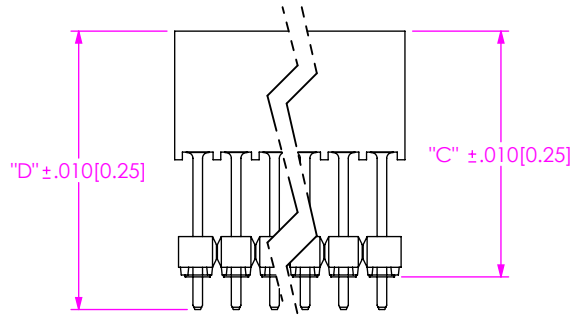
IN-PROCESS  
-12, -33, -37, -58



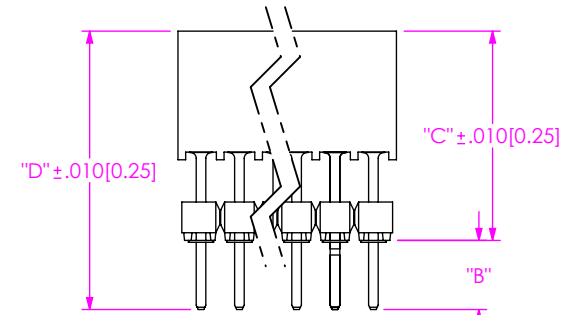
LOAD CONTACT



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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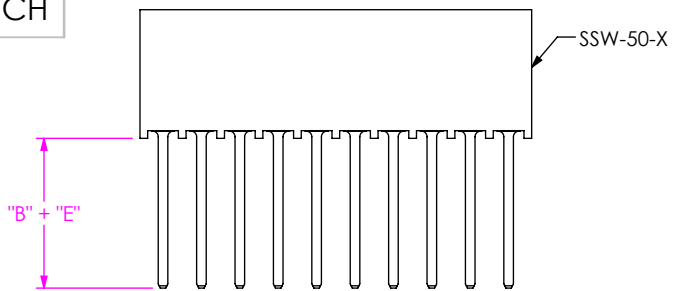


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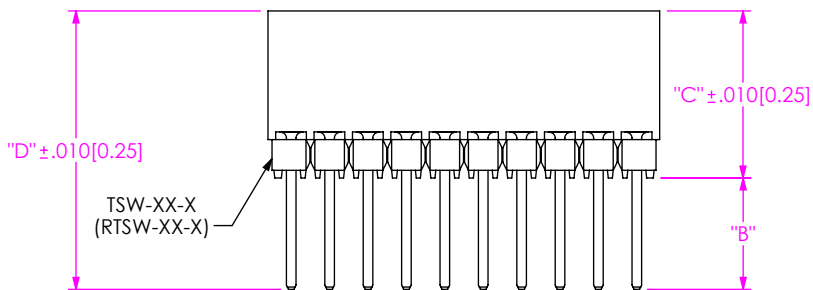
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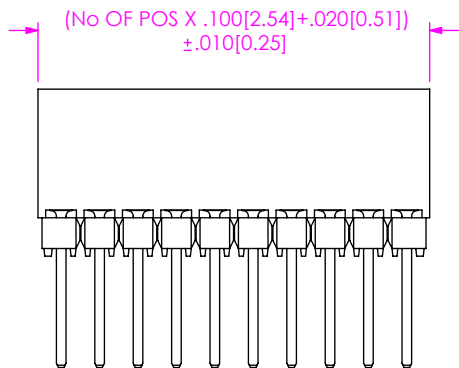
BY: WITHTAKER 9-11-98 SHEET 3 OF 4



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-110-XX-X-S  
IN PROCESS "B"  
(LEAD STYLE -12 & -37)  
(-S & -D ONLY)

TABLE 2			
LEAD STYLE	ROW	TUBE	PLUG (2)
-12, -13, -14, -37, -38, -39	-S	PT-ESQ002	TP-03
-23, -24, -48, -49		PT-ESQ001	TP-03
-33, -34, -44, -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		PT-1-24-01-51	TP-13
-12, -37	-T	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 PAC KAGE -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.

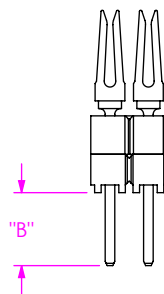
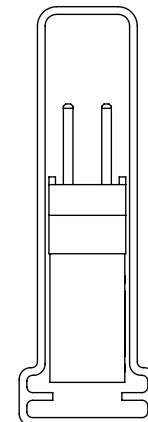
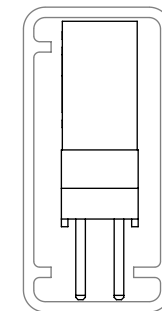


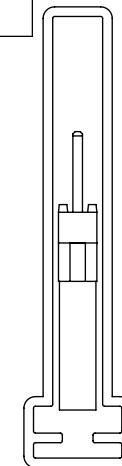
FIG 6  
ESQ-110-XX-X-D  
IN PROCESS "A"  
(LEAD STYLE -12-T, -13, -14, -23, -24, -33, -34, -44, -37-T, -38, -48, -49, -58, -59, -69)



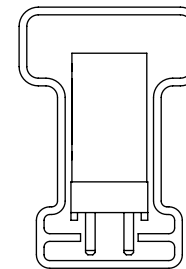
-D  
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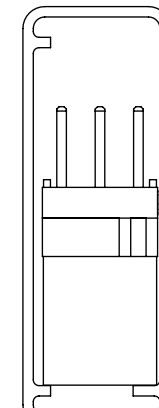
-D  
PT-1-24-01-51



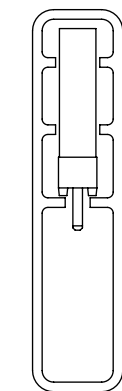
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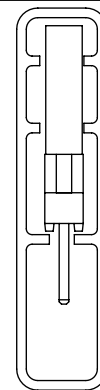
-D  
PT-1-24-03-44



-T  
PT-1-24-03-51



-S  
PT-ESQ002



-S  
PT-ESQ001

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BY: WHITTAKER 9-11-98 SHEET 4 OF 4