

- NOTES:
1. MINIMUM 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. MAXIMUM ALLOWABLE BOW .003[0.08] INCH/INCH AFTER ASSEMBLY
 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

DO NOT SCALE FROM THIS PRINT

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

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

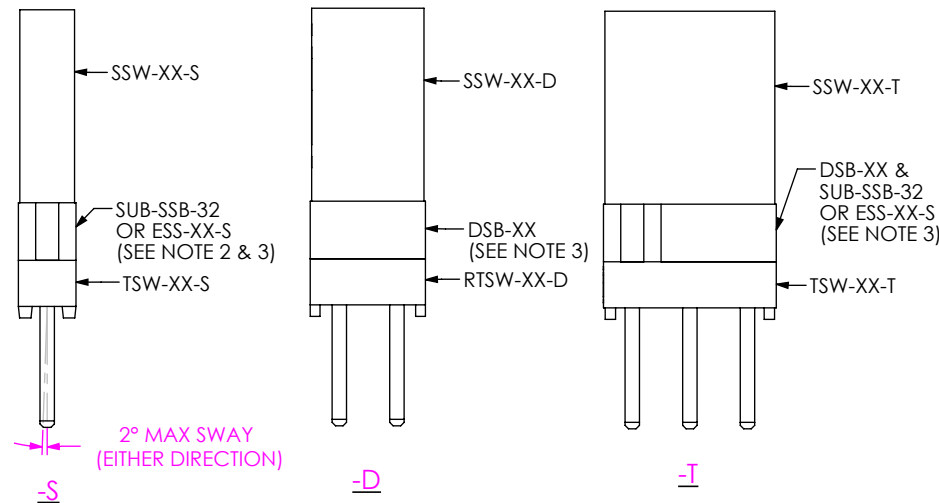
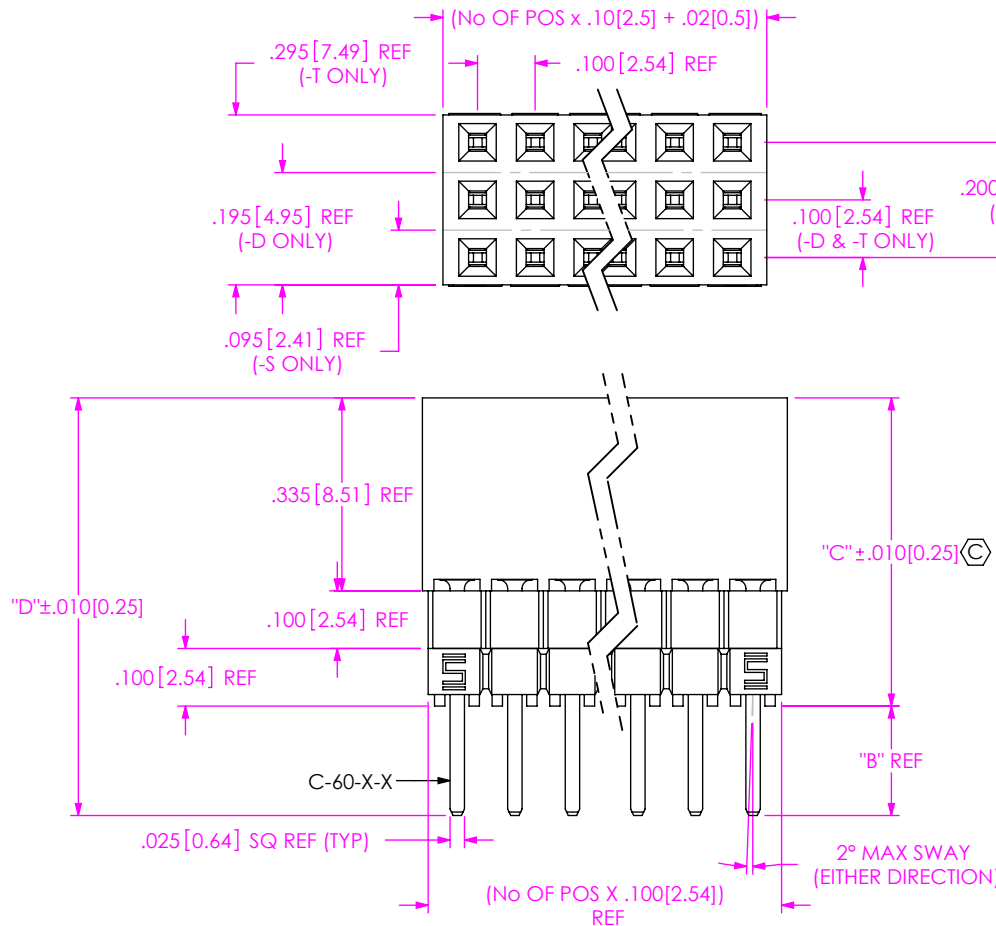


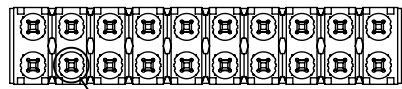
FIG 1
 ESQ-110-XX-X-T

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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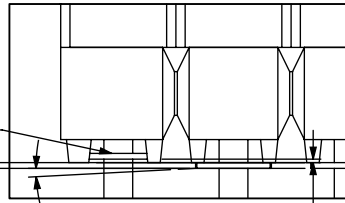
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 CONTACT : PHOS BRONZE

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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

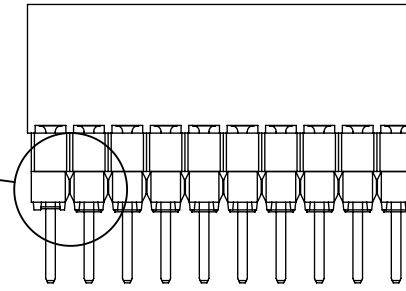


FIG 3
 #-H-MW: METAL WASHER
 ESQ-110-XX-X-MWT
 (ONE PER POSITION)
 (-S & -D BODY SPECS ONLY)
 (SEE NOTE 5)
 (SAME AS FIG 1 UNLESS OTHERWISE NOTED)

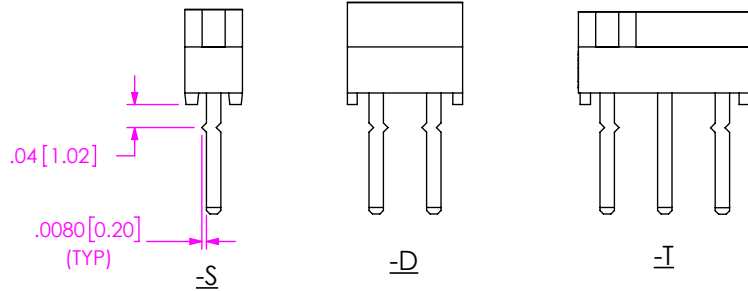
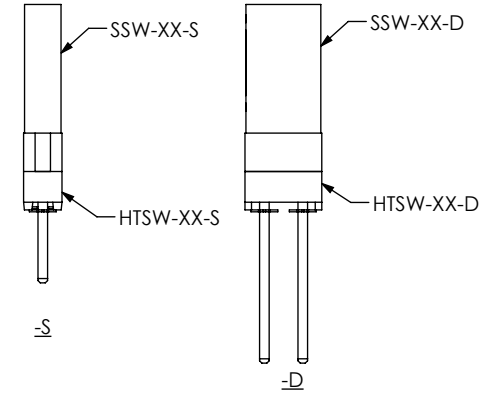


FIG 2
 -LL: LOCKING LEAD OPTION
 LOCATED ON OR ABOUT CENTERLINE
 [N/A IN 1 OR 2 POSITION SINGLE ROW]

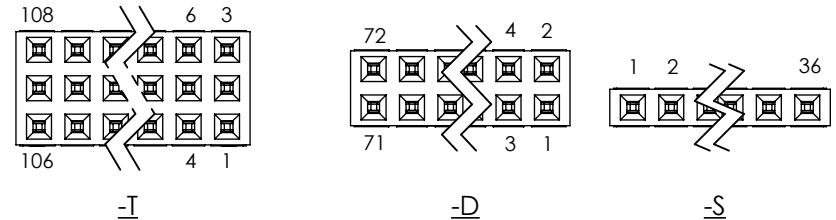


FIG 4
 XXX: POLARIZATION LOCATION
 INSERT PK-06-N INTO SPECIFIED POS
 AND BREAK OFF TAB

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

		TABLE 1 SPACER SPECIFICATION (FOR A ONE POSITION SINGLE SEE NOTE 3)			"B"	"C"	"D"	"E"
STANDARD INSERTION FORCE	CONTACT	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
		SPACER SPECIFICATION (FOR A ONE POSITION SINGLE SEE NOTE 3)			"B"	"C"	"D"	"E"
LOW INSERTION FORCE	CONTACT	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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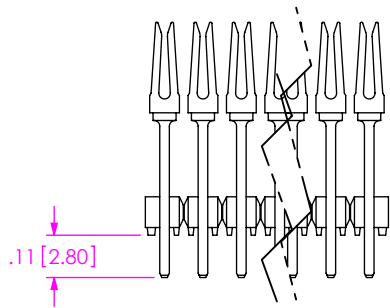
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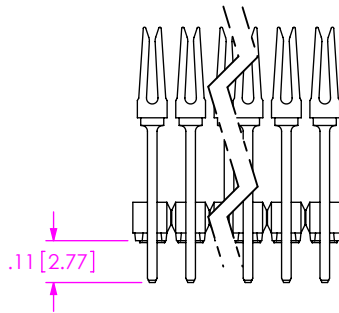


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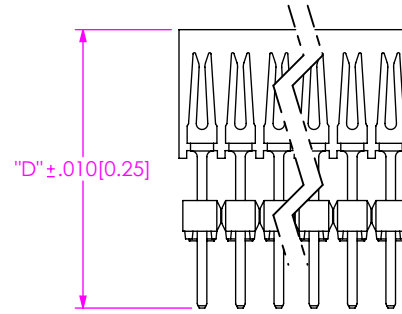
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 DWG. NO. ESQ-1XX-XX-X-X-XXX-XX-X-XX
 BY: WHITTAKER 9-11-98 SHEET 2 OF 4



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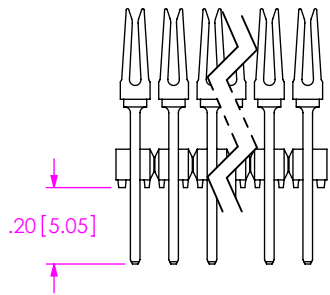


PRESS ON -MW

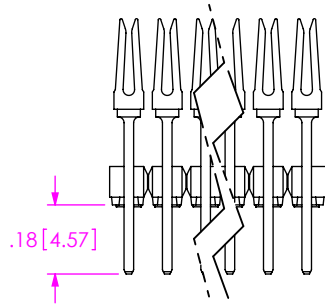


PRESS ON
SSW BODY

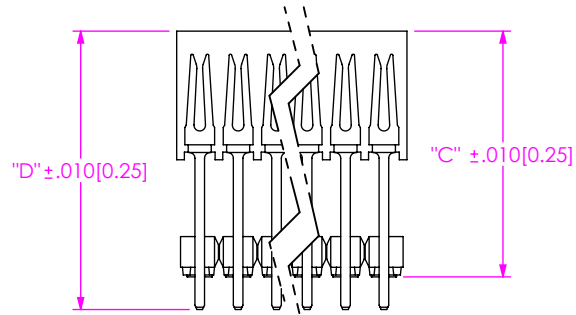
IN-PROCESS
-12, -33, -37, -58



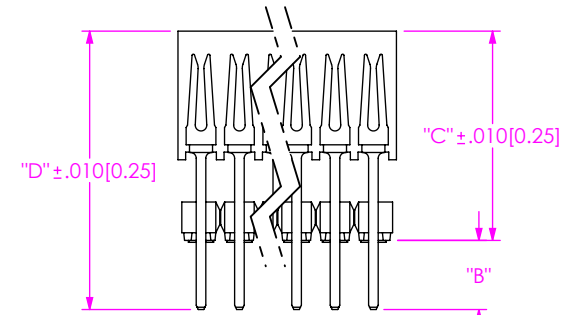
LOAD CONTACT



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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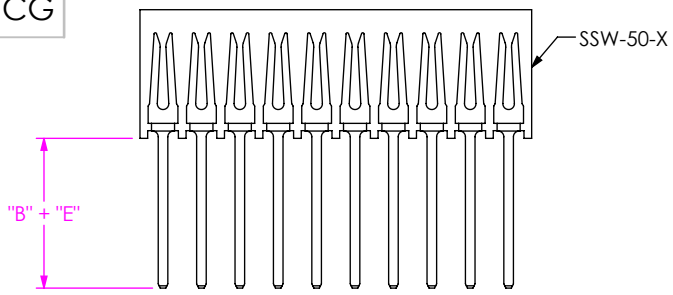


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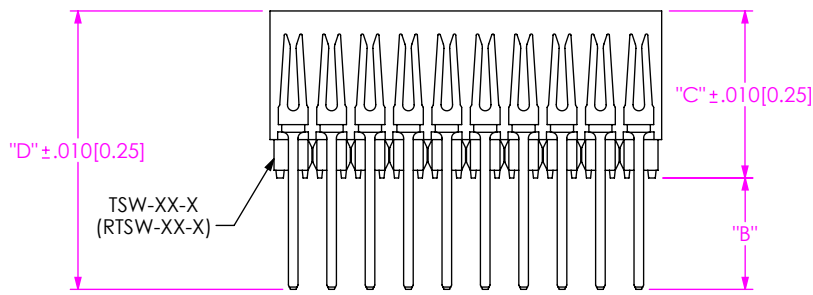
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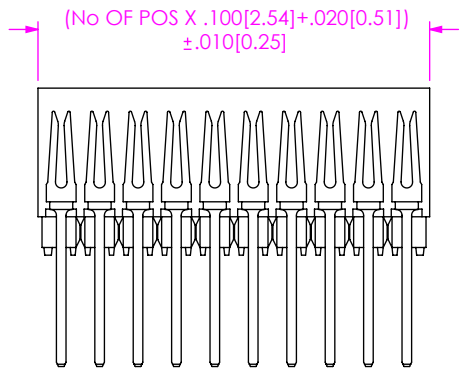
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STEP 1
MACHINE FILL SSW-50-X



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.

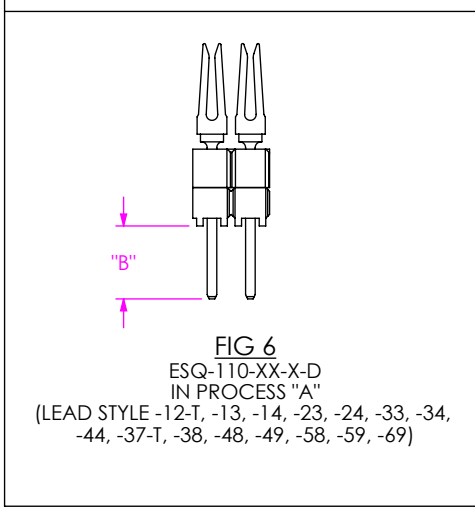
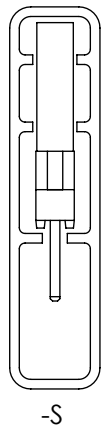
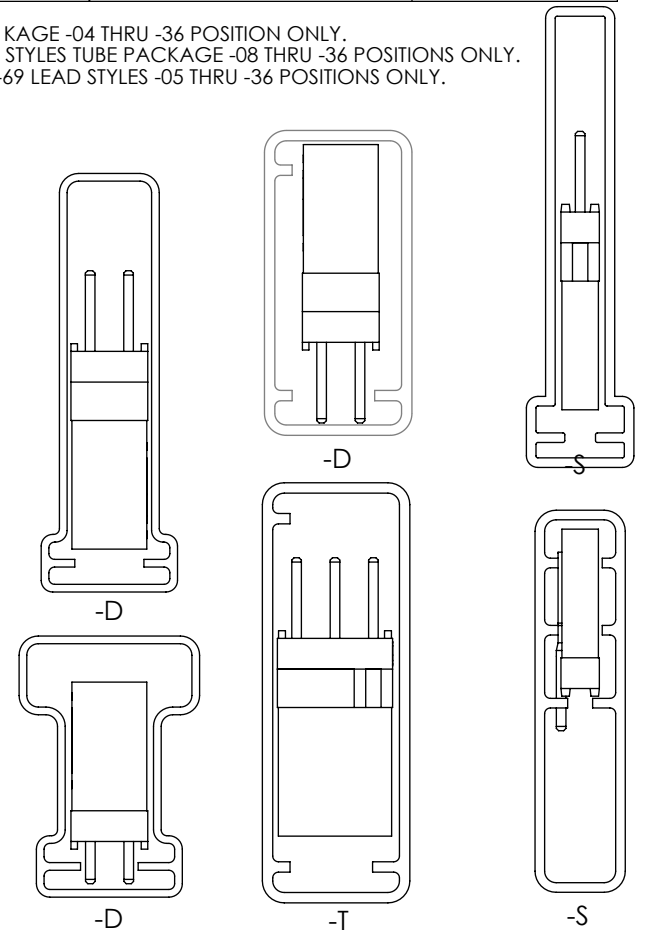


FIG 6
ESQ-110-XX-X-D
IN PROCESS "A"
(LEAD STYLE -12-T, -13, -14, -23, -24, -33, -34, -44, -37-T, -38, -48, -49, -58, -59, -69)



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