**TABLE 1 (**)  DO NOT SCALE FROM THIS PRINT**

<table>
<thead>
<tr>
<th>No. OF POS.</th>
<th>MAX COPLANARITY</th>
</tr>
</thead>
<tbody>
<tr>
<td>0-35</td>
<td>.004 [.10]</td>
</tr>
<tr>
<td>40-50</td>
<td>.006 [.15]</td>
</tr>
</tbody>
</table>

**NOTE:**

1. **()** REPRESENTS A CRITICAL DIMENSION.
2. MINIMUM PUSHOUT FORCE: 12 oz.
3. LOAD INSERTS IN DIRECTION OF THE ARROW USING HAND LOAD THERMAL INSERTION PRESS.
4. THREADED INSERT MUST BE ABLE TO HANDLE 20 in-oz's OF TORQUE MIN WITHOUT ROTATING OR "LOOSENING".
5. THREADED INSERT RETENSION TO BE 7lbs. MIN.
6. THREADED INSERT TO BE FLUSH TO .003 [.08] BELOW HOUSING SURFACE.
7. -SD OPTION: RETENTION TO BE 3lb MIN AND MUST WITHSTAND 6 in-oz's OF TORQUE.
8. APPLICATIONS REQUIRING 40-50 POSITIONS WITHOUT THREADED INSERTS, PLEASE CONTACT SAMTEC INTERCONNECT PROCESSING GROUP.
9. MAXIMUM ALLOWABLE SHEAR BURR: .003 [.08], IN DIRECTION SHOWN.

**OPTIONS**

- **TR:** TAPE & REEL PACKAGING (BLANK FOR TUBED PARTS)
- **K:** POLYAMIDE FILM PAD (USE K-500-300) (SEE FIGS 4 & 5, SHEET 3)
- **SD:** SCREW DOWN OPTION (USE THS-4-A-0-560-XX) (AVAILABLE ON 10, 20 & 30 POS. WITH -AD ONLY; SEE SHEET 4) (SEE NOTE 7)

**OPTION UNAVAILABLE WITH ANY THREADED INSERT OPTION**

- **ALIGNMENT PIN OPTION**
  - **AT:** TOP SIDE (USE FSI-XX-03-D-AT-X)
  - **AB:** BOTTOM SIDE (USE FSI-XX-03-D-AB-X)
  - **AD:** DUAL (TOP & BOTTOM) (USE FSI-XX-03-D-AD-X, SEE FIG 2)
  - **LC:** LOCKING CLIP BLANK FOR NO ALIGNMENT PIN

**THREAD INSERT OPTION**

- **E:** THREADED INSERT (ENGLISH) (USE INS-C-2-56-100, SEE FIG 3, SHT 2)
- **M:** THREADED INSERT (METRIC) (USE INS-C-M2-100-N, SEE FIG 3, SHT 2)

LEAVE BLANK FOR NO THREADED INSERT

* = NOT RELEASED FOR PRODUCTION
** = NOT TOOLED

**DIMENSIONS ARE IN INCHES.**

- **DECIMALS**
  - -XX: ± .01 [.2]
  - -XXX: ± .005 [.13]

- **ANGLES**
  - 2°

- **TOLERANCES**

**MATERIAL:**

- **INSULATOR:** VECTRA E130i
- **CONTACT:** BeCu
- **INSERT:** BRASS

**NOTES:**

1. **()** REPRESENTS A CRITICAL DIMENSION.
2. MINIMUM PUSHOUT FORCE: 12 oz.
3. LOAD INSERTS IN DIRECTION OF THE ARROW USING HAND LOAD THERMAL INSERTION PRESS.
4. THREADED INSERT MUST BE ABLE TO HANDLE 20 in-oz's OF TORQUE MIN WITHOUT ROTATING OR "LOOSENING".
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8. APPLICATIONS REQUIRING 40-50 POSITIONS WITHOUT THREADED INSERTS, PLEASE CONTACT SAMTEC INTERCONNECT PROCESSING GROUP.
9. MAXIMUM ALLOWABLE SHEAR BURR: .003 [.08], IN DIRECTION SHOWN.

**PRODUCTIVE NOTE**

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**DESCRIPTION:**

1mm SINGLE ELEMENT INTERFACE

**Dwg. No.:** FSI-1XX-03-X-D-X-XX-XX

**Material:** DO NOT SCALE DRAWING SHEET SCALE: 4:1

**Revision:** AE

**Date:** 1/27/99

**Location:** 520 PARK EAST BLVD, NEW ALBANY, IN 47150

**Phone:** 812-944-6733 | **Fax:** 812-948-5047

**E-Mail:** info@SAMTEC.com | **Code:** 55322

**Sheet Scale:** 4:1

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**FIG 1 FSI-110-03-G-D SHOWN**
PACKAGING VIEW

PARTS ARE TO BE PACKAGED IN PT-1-24-01-61 TUBES WITH TWO TP-03 PLUGS PER TUBE.

TABLE 2: INSERT OPTION

<table>
<thead>
<tr>
<th>OPTION</th>
<th>INSERT</th>
<th>THREAD</th>
</tr>
</thead>
<tbody>
<tr>
<td>-E</td>
<td>INS-C-2-56-100</td>
<td>2 x 56</td>
</tr>
<tr>
<td>-M</td>
<td>INS-C-M2-100-N</td>
<td>M2.0 x 4</td>
</tr>
</tbody>
</table>

LOAD INSERT FROM BOTTOM (SEE NOTE 6)
FIG 4
-K: POLYAMIDE FILM PAD
.098 [2.50] DIA PAD USED ON ALL POSITIONS EXCEPT -40 & -50 POSITIONS WITH THREADED INSERT OPTION

\[ M = \text{(No OF POS x .03937[1.000])} + .030[.76] \text{ REF} \]
\[ P = \left( \frac{M - .098[2.50]}{2} \right) \pm .020[.51] \]

FIG 5
-K: POLYAMIDE FILM PAD
.315 [8.00] DIA PAD USED ONLY ON -40 & -50 POSITIONS WITH THREADED INSERT OPTION

\[ R = \text{(No OF POS x .03937[1.000])} + .870[22.10] \text{ REF} \]
\[ S = \left( \frac{R - .315[8.00]}{2} \right) \pm .020[.51] \]
FIG 6

-SD: SCREW DOWN OPTION
(FSI-110-03-G-D-AD-SD SHOWN)
(AVAILABLE IN POS -10, -20 & -30 WITH -AD OPTION ONLY)

OPTION UNAVAILABLE WITH ANY THREADED INSERT OPTION

NOTE:
PARTS ARE TO BE PACKAGED IN PT-FS1001-03-SD TUBES WITH TWO TP-03 PLUGS PER TUBE.

PACKAGING VIEW

NOTE:

FLUSH TO .004 [0.10] (MAX)

.275 [6.985] REF

.4420 [11.227] REF

(No OF POS x .03937 [1.0000]) + .555 [7.24]

"B"

"B"

.275 [6.985] REF

(No OF POS x .03937 [1.0000]) + .285 [7.24]

(MEASURED AT THE BODY)

2° MAX SWAY
(EITHER DIRECTION)

THS-4-40-.560-XX

LOAD STUD FROM BOTTOM

SURFACE MOUNT SIDE

.006 [0.15]

520 PARK EAST BLVD, NEW ALBANY, IN 47150
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e-Mail: info@SAMTEC.com code: 55322

DESCRIPTION:
1mm SINGLE ELEMENT INTERFACE

FILE: F:\DWG\MISC\MKTG\FSI-1XX-03-X-D-X-XX-XX-MKT.DDRW

REV 6