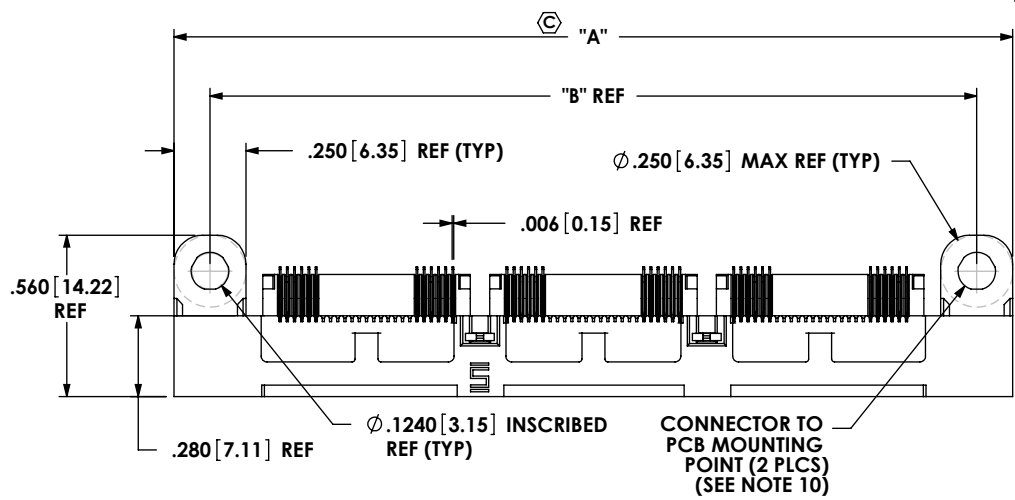


DO NOT  
SCALE FROM  
THIS PRINT



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

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

PLATING SPECIFICATION  
SEE TABLE 2

ROW SPECIFICATION  
-D: DOUBLE  
(USE QSS-25-01-D-XX-RA)

-RA: RIGHT ANGLE

OPTION  
-LS1: LOCKING SCREW  
(SEE FIG. 2, SHT 3)  
(FOR MATING WITH  
QTS-...-RA-...LS1)  
-MTI: THREADED INSERT  
(SEE FIG. 5, SHT 5)  
-SP: SOLDER PIN  
(NOT AVAILABLE  
W/LS1 OPTION)  
(USE SP-19-T)  
(SEE FIG. 3, SHT 4)  
-K: KAPTON PAD  
(SEE FIG. 4, SHEET 4)  
(USE K-500-300)

-WT: WELD TAB  
(SEE NOTE 4)  
(USE WT-16-XX-T)

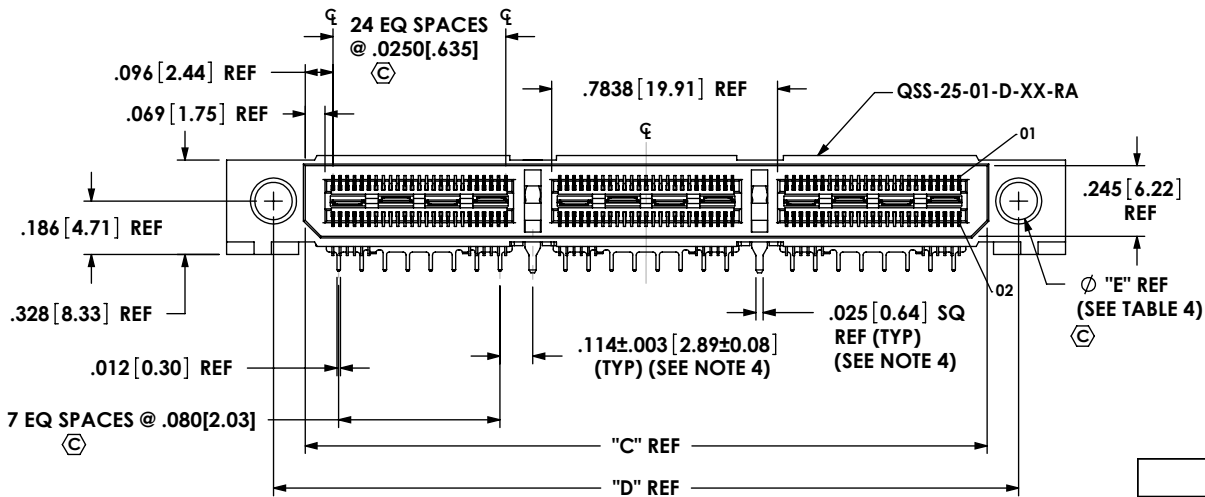
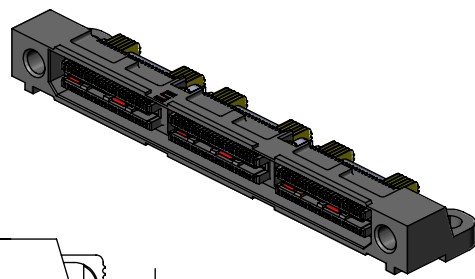


TABLE 2	
MOUNTING OPTION	"E" HOLE DIA
STANDARD	.130[3.30]
-LS1	.0625[1.588]

TABLE 1				
POSITION	"A"	"B"	"C"	"D"
-025	1.338 0.00	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]

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

NOTES:

1. 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.
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.

UNLESS OTHERWISE SPECIFIED,  
DIMENSIONS ARE IN INCHES.

TOLERANCES ARE:

DECIMALS ANGLES  
.XX: ±.01 [.3] 2°  
.XXX: ±.005 [.13]  
.XXXX: ±.0020 [.051]

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MATERIAL: DO NOT SCALE DRAWING

INSULATOR: LCP, COLOR: BLACK

TERMINAL, GROUND PLANE &  
WELD TAB: PHOS BRONZE

F:\DWG\MISC\MKTG\QSS-XXX-XX-XXX-D-RA-WT-XXX-MKT.SLDDRW

SHEET SCALE: 1.5:1

DESCRIPTION:

.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

DWG. NO.

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

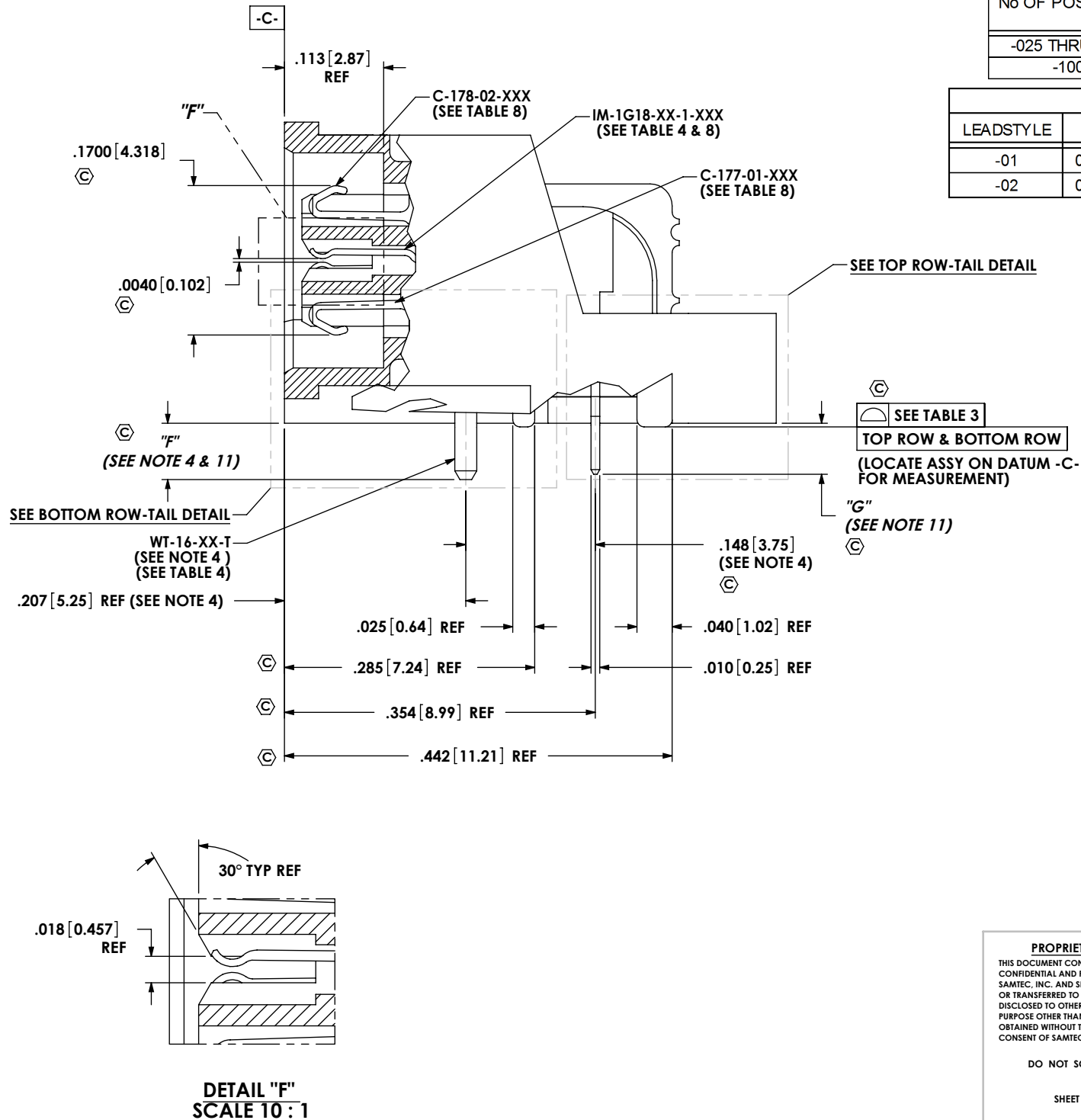
BY: KEVIN B

01/22/02

SHEET 1 OF 6

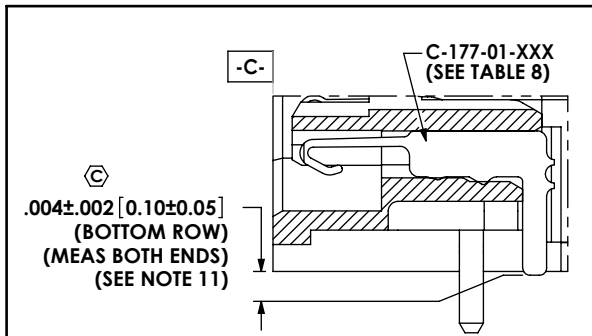
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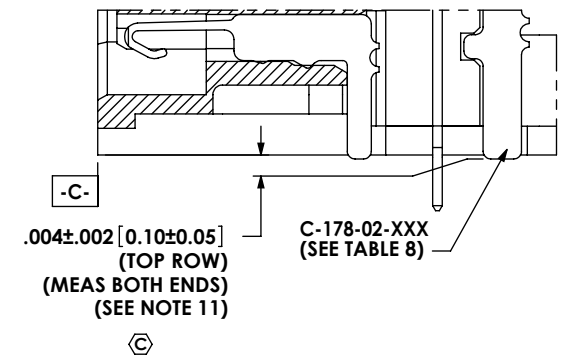


No OF POSITIONS	COPLANARITY	STRAIGHTNESS ROW 1	STRAIGHTNESS ROW 2
-025 THRU -075	.004[.10]	.004[.10]	.004[.10]
-100	.006[.15]	.006[.15]	.006[.15]

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



**BOTTOM ROW - TAIL DETAIL**  
**(LOCATE ASSEMBLY ON**  
**DATUM -C- FOR MEASUREMENT)**



TOP ROW - TAIL DETAIL  
(LOCATE ASSEMBLY ON  
DATUM -C- FOR MEASUREMENT)

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**SHEET SCALE: 6:1**



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DESCRIPTION:

DWG. NO.

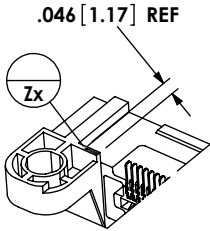
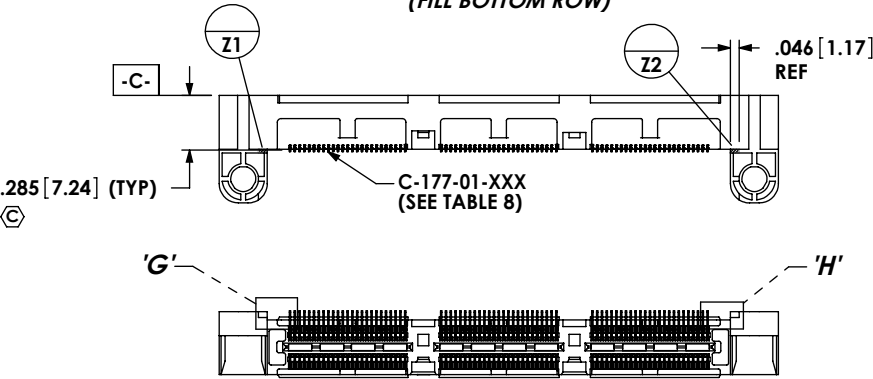
**QSS-XXX-XX-XXX-D-RA-WT-XXX**

BY: KEVIN B

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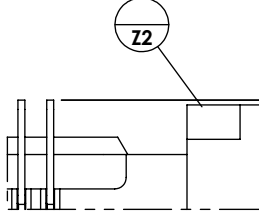
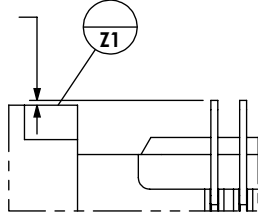
**SHEET 2 OF 6**

INSPECTION VIEW 1  
(FILL BOTTOM ROW)



ISO VIEW OF  
-Z- DATUM ZONE

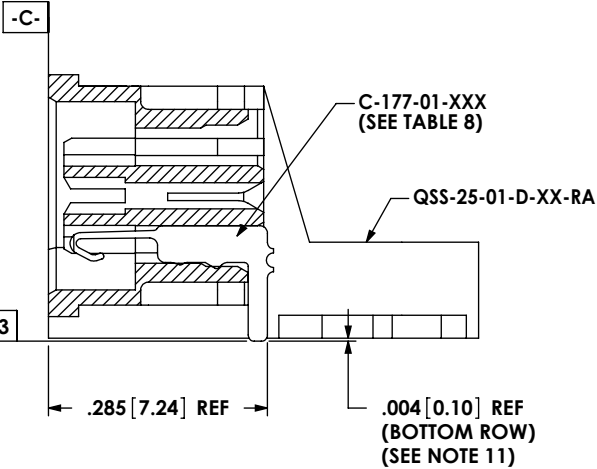
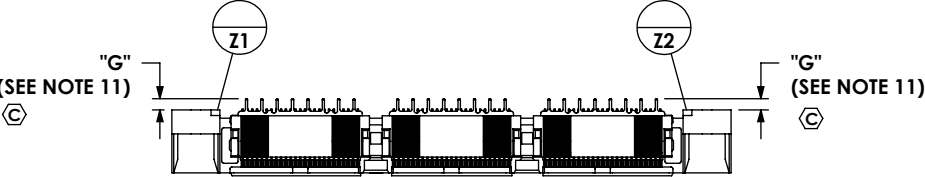
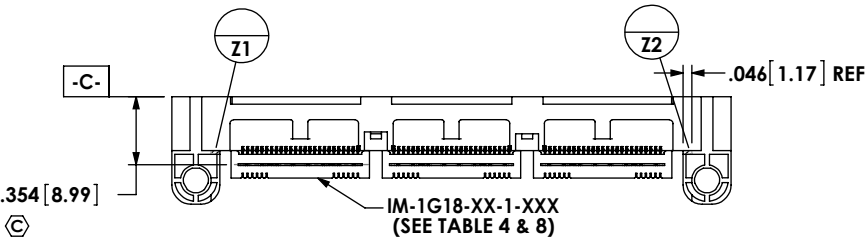
.004±.002 [0.10±0.05]  
(BOTTOM ROW)  
(SEE NOTE 11)



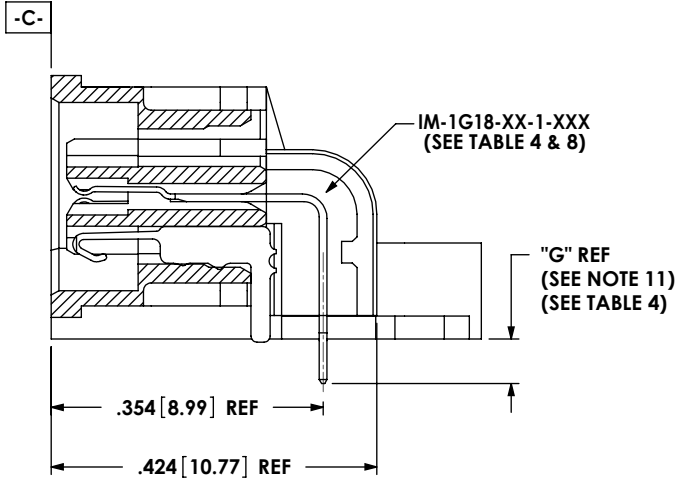
SEE TABLE 3  
WITHIN ROW

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

INSPECTION VIEW 2  
(FILL IM-1G18)



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)

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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-WT-XXX**  
BY: KEVIN B 01/22/02 SHEET 3 OF 6

INSPECTION VIEW 3  
(FILL TOP ROW)

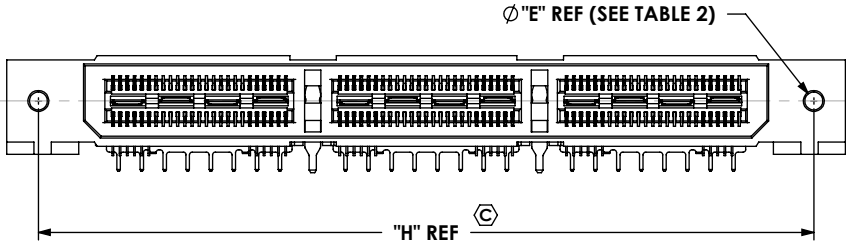
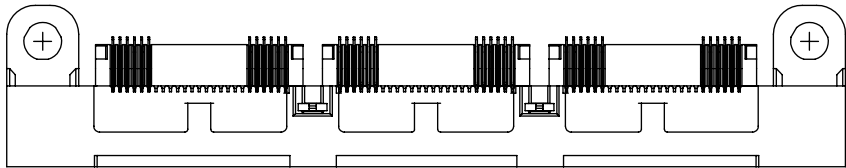
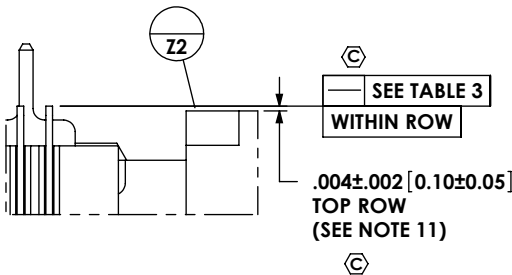
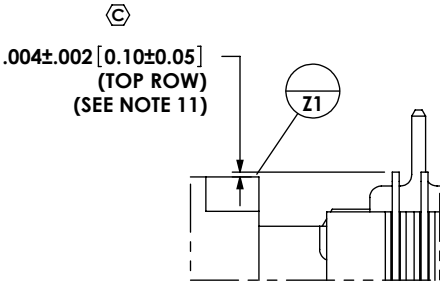
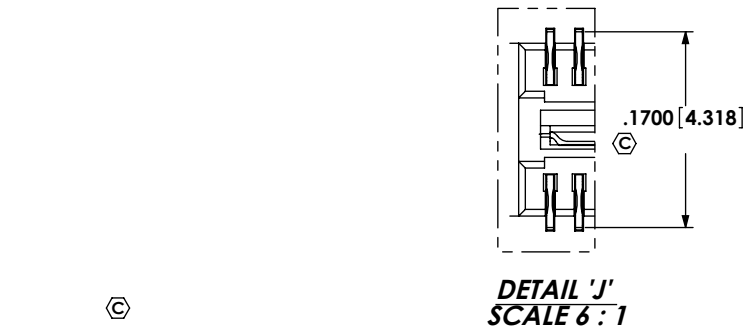
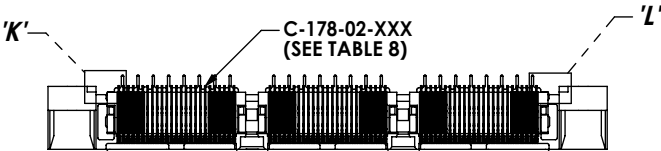
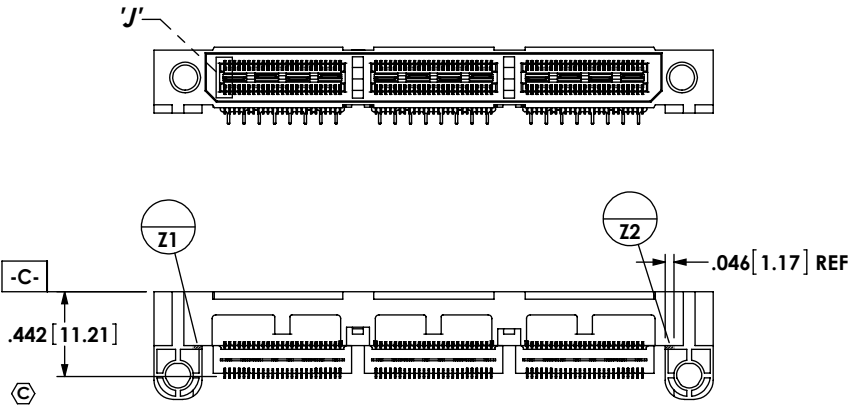
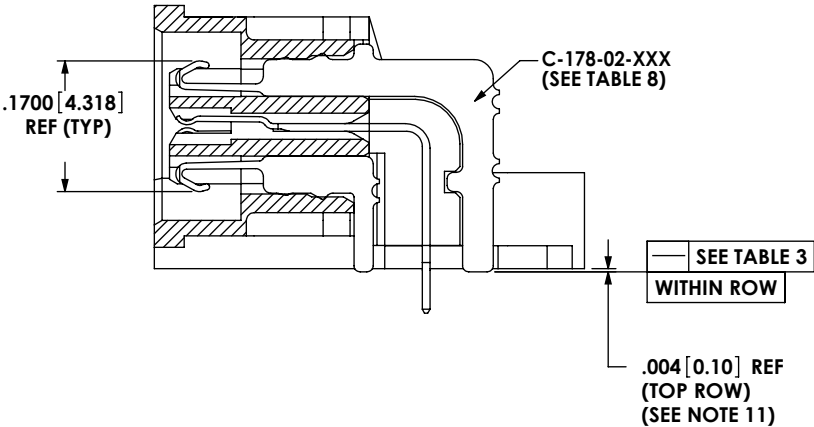


TABLE 5	
POSITION	"H"
-025	1.118 [28.38]
-050	1.905 [48.39]
-075	2.693 [68.39]
-100	3.480 [88.39]

FIG 2  
QSS-075-01-XXX-D-RA-LS1 SHOWN  
(SAME AS FIG. 1, EXCEPT AS SHOWN)  
(SOME CENTER DETAILS REMOVED FOR CLARITY)



IN-PROCESS 3  
(FILL TOP ROW)  
(SEE INSPECTION VIEW 3 FOR ORIENTATION AND CPC'S)

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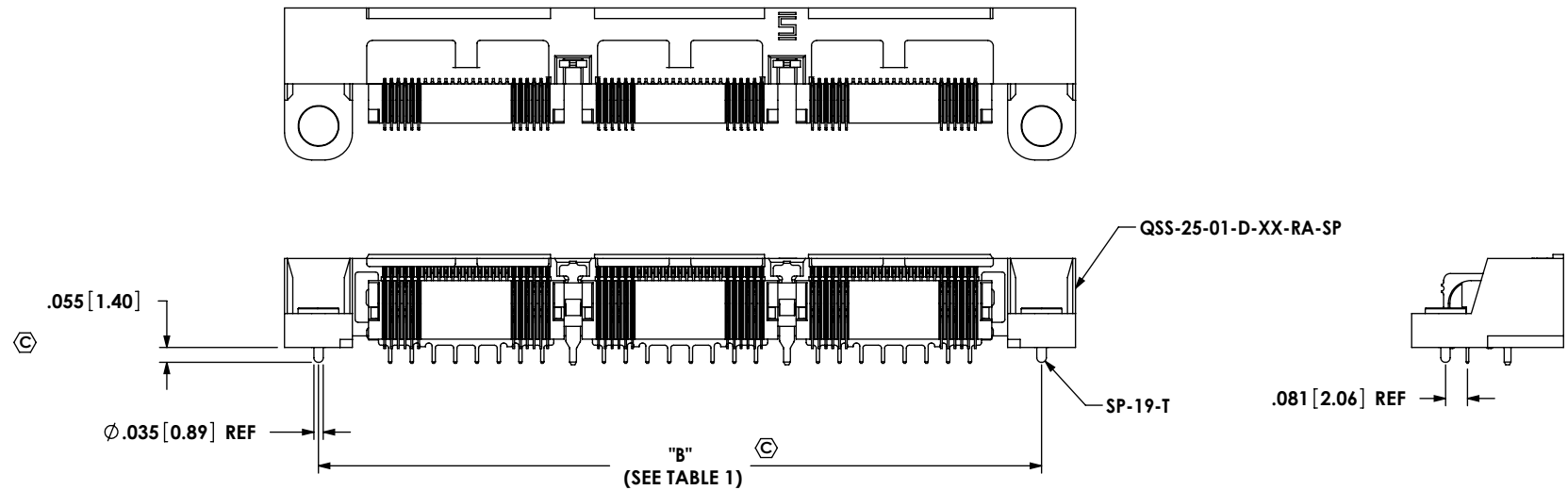
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.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

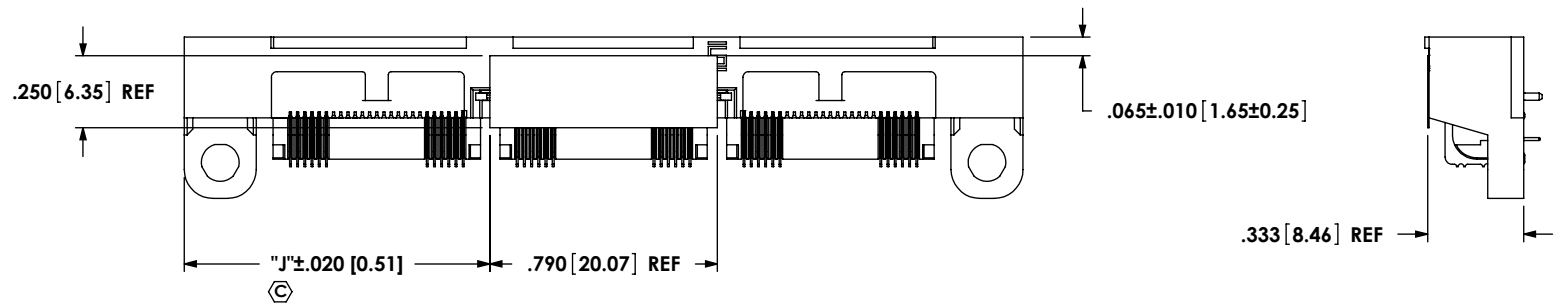
DWG. NO.  
**QSS-XXX-XX-XXX-D-RA-WT-XXX**

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**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]

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DESCRIPTION:  
**.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP**

DWG. NO.

**QSS-XXX-XX-XXX-D-RA-WT-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)

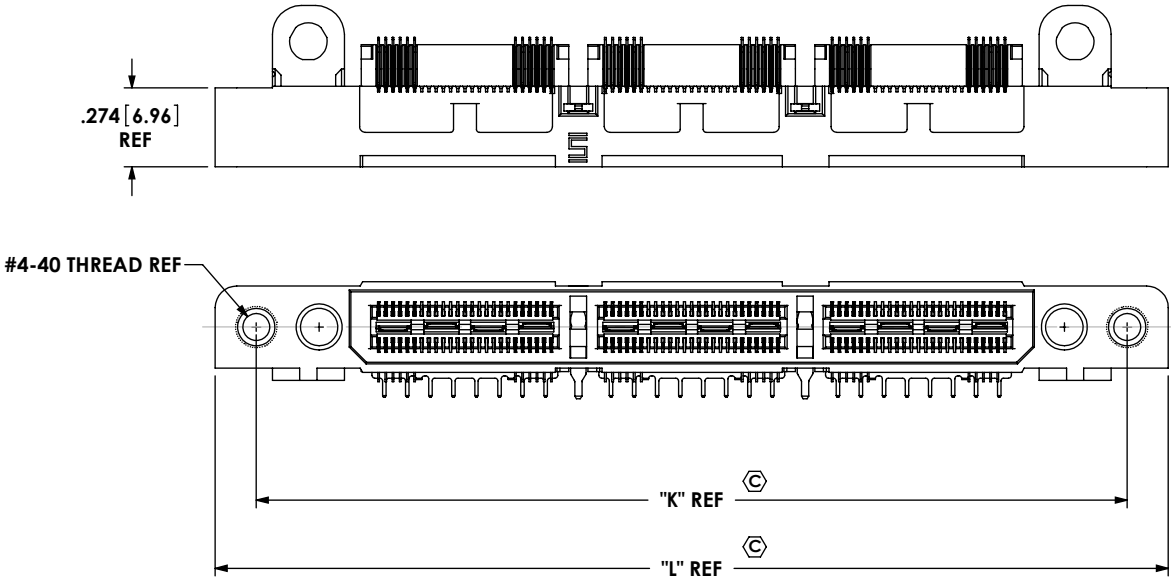


TABLE 7		
POSITION	"K"	"L"
-025	1.450 [36.82]	1.735 [44.06]
-050	2.237 [56.82]	2.522 [64.06]
-075	3.025 [76.82]	3.310 [84.06]
-100	3.812 [96.82]	4.097 [104.06]

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

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DESCRIPTION:  
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DWG. NO. **QSS-XXX-XX-XXX-D-RA-WT-XXX**

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