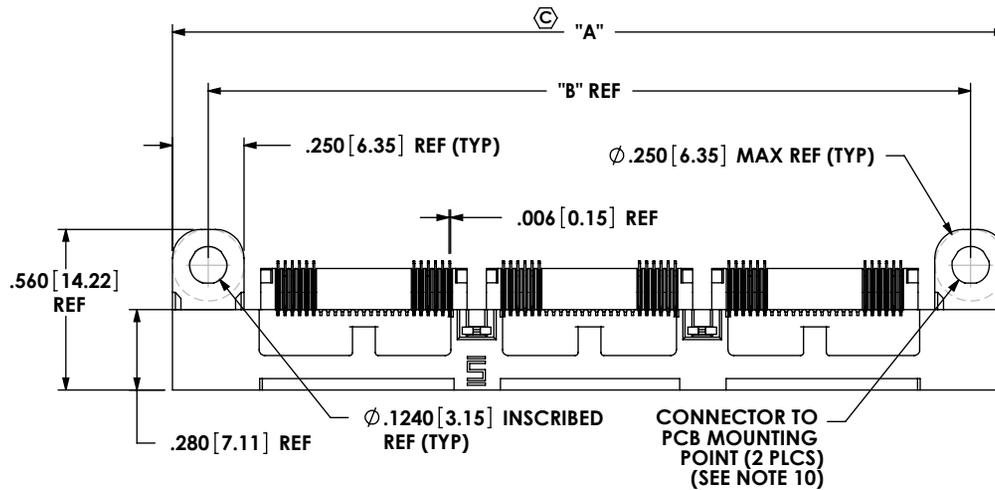


DO NOT SCALE FROM THIS PRINT

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



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

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

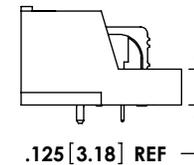
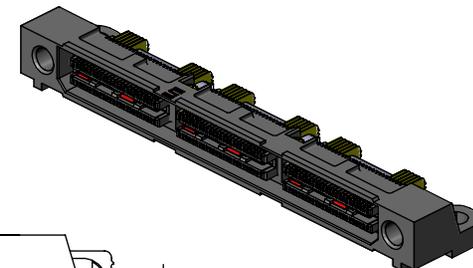
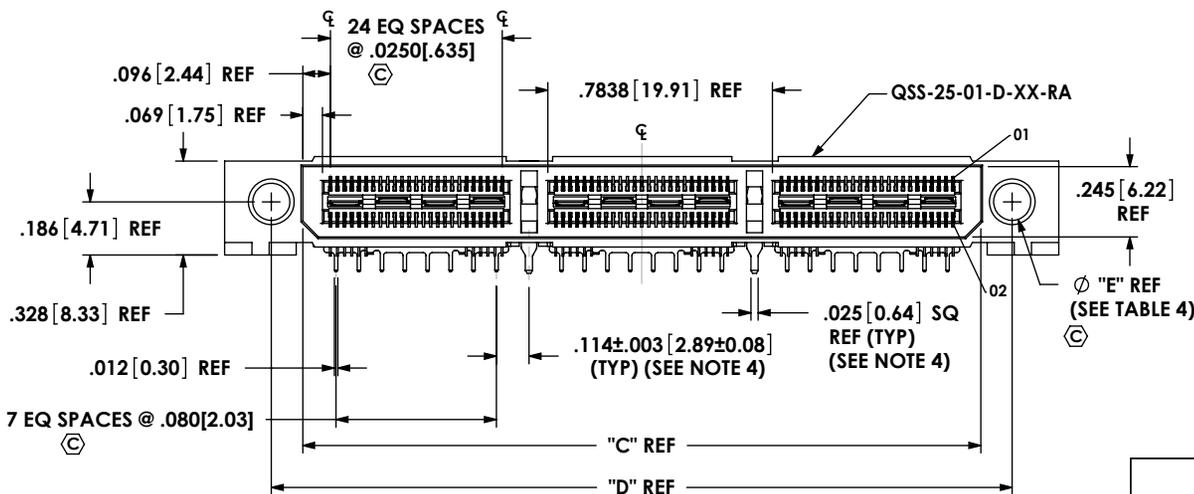
PLATING SPECIFICATION  
SEE TABLE 2

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)



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

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:

- REPRESENTS A CRITICAL DIMENSION.
- BURR ALLOWANCE: .0010 MAX.
- MINIMUM PUSHOUT FORCE: 6 OZ.
- WELD TABS (WT-16-XX-T) NOT AVAILABLE ON -025 POSITION.
- IF NEEDED, -L PLATING CAN BE SUBSTITUTED FOR -F PLATING.
- IM-1G18-XX-1-XX RETENTION TO BE 1.0 LBS. MINIMUM PRIOR TO SECOND ROW FILL.
- DESIGNED FOR USE WITH A .062 OR .093 THICK PCB
- ASSEMBLIES TO BE PACKAGED IN TRAYS.
- NOTE DELETED
- TORQUE TO BE 10.0 IN-OZ USING 4-40 UNC SCREW.
- 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 SHEET SCALE: 1.5:1

INSULATOR: LCP, COLOR: BLACK

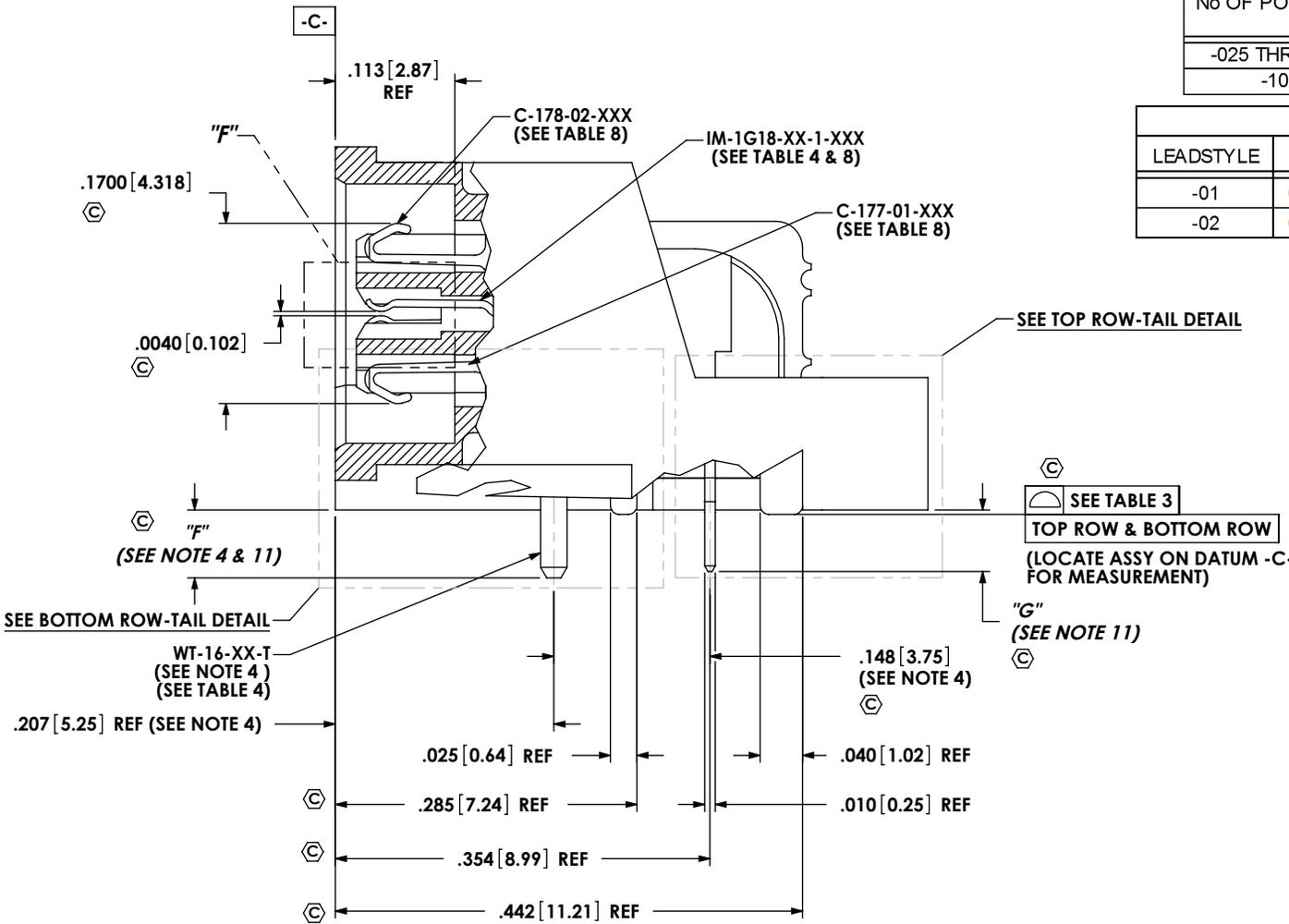
TERMINAL, GROUND PLANE & WELD TAB: PHOS BRONZE

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

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

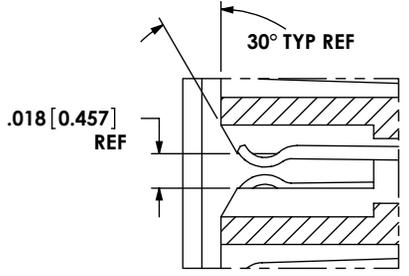


SEE BOTTOM ROW-TAIL DETAIL

WT-16-XX-T  
(SEE NOTE 4)  
(SEE TABLE 4)

SEE TABLE 3  
TOP ROW & BOTTOM ROW  
(LOCATE ASSY ON DATUM -C-  
FOR MEASUREMENT)

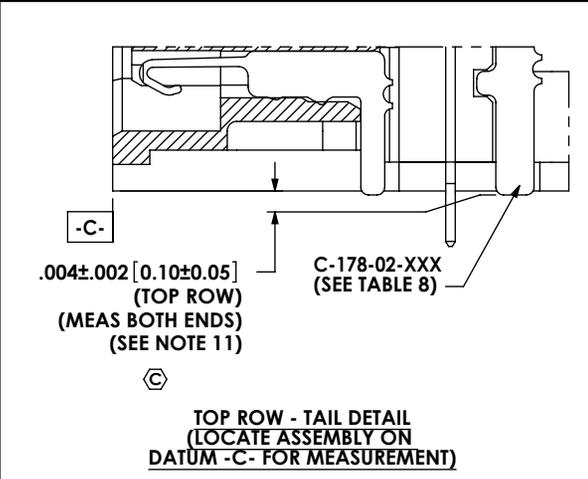
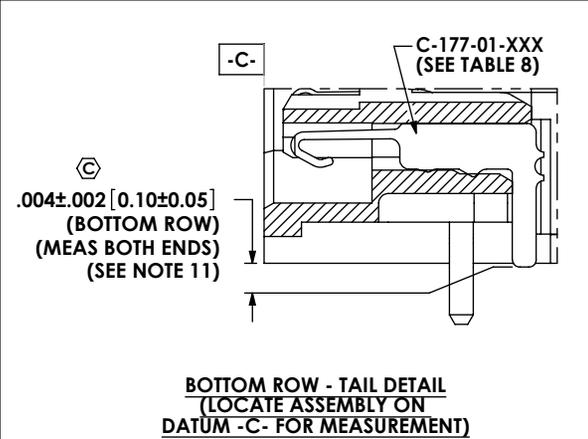
"G"  
(SEE NOTE 11)



DETAIL "F"  
SCALE 10 : 1

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



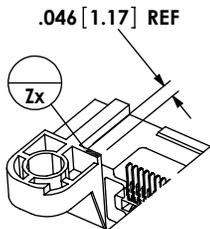
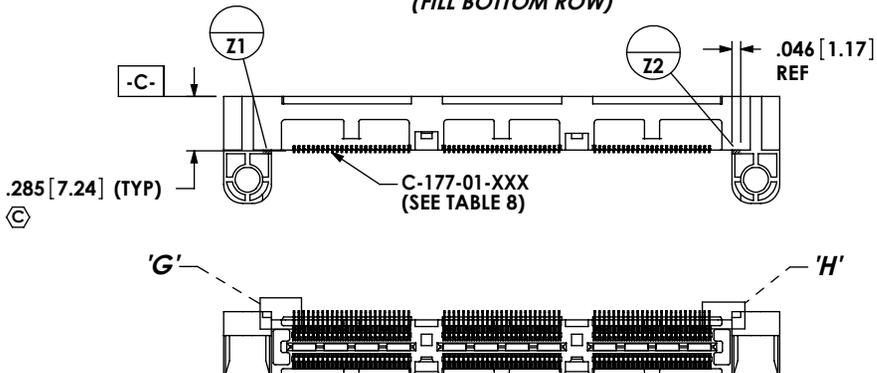
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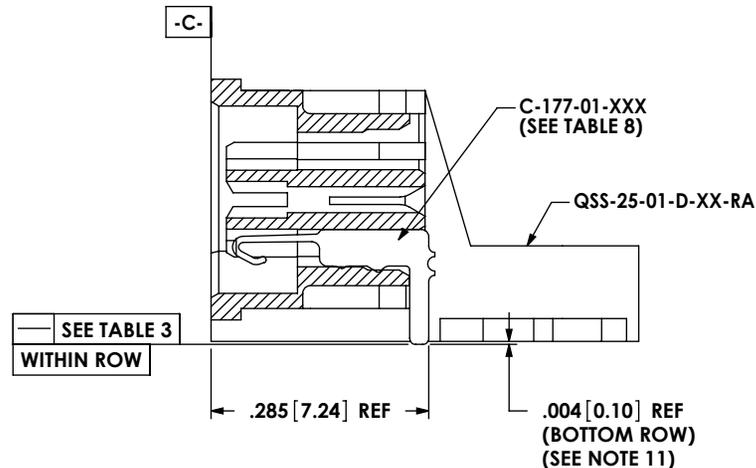
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DESCRIPTION:  
.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP  
DWG. NO.  
**QSS-XXX-XX-XXX-D-RA-WT-XXX**  
BY: KEVIN B 01/22/02 SHEET 2 OF 6

**INSPECTION VIEW 1**  
(FILL BOTTOM ROW)

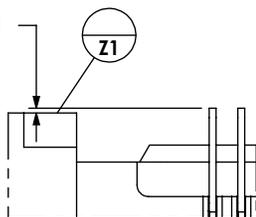


ISO VIEW OF  
-Z- DATUM ZONE

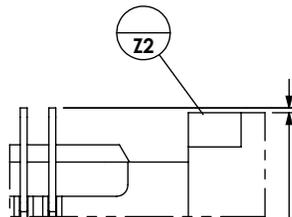


**IN-PROCESS 1**  
(FILL BOTTOM ROW)  
(SEE INSPECTION VIEW 1 FOR ORIENTATION AND CPC'S)

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



**DETAIL 'G'**  
SCALE 6:1



**DETAIL 'H'**  
SCALE 6:1

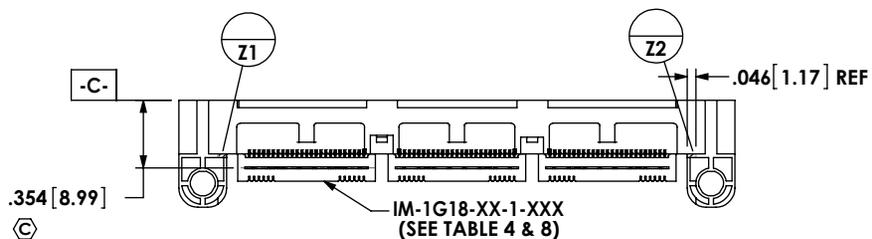
SEE TABLE 3  
WITHIN ROW



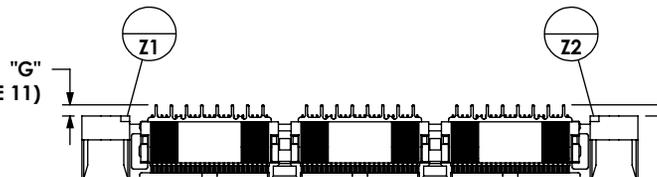
.004±.002 [0.10±0.05]  
(BOTTOM ROW)  
(SEE NOTE 11)



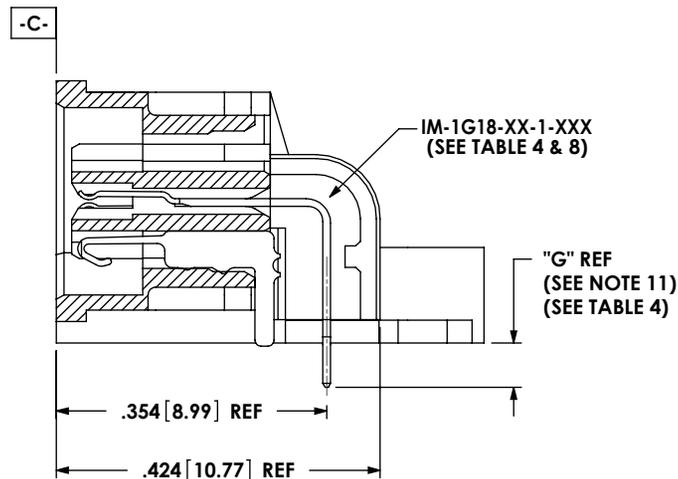
**INSPECTION VIEW 2**  
(FILL IM-1G18)



"G"  
(SEE NOTE 11)



"G"  
(SEE NOTE 11)



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

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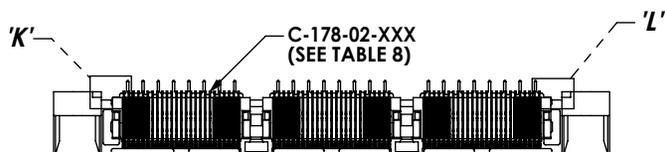
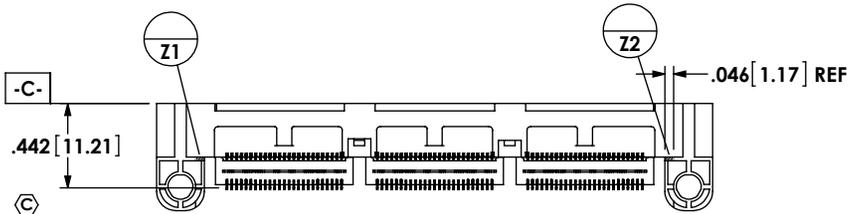
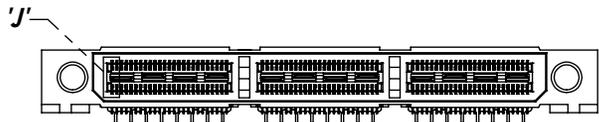
DESCRIPTION:  
.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

DWG. NO.

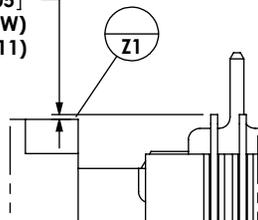
**QSS-XXX-XX-XXX-D-RA-WT-XXX**

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

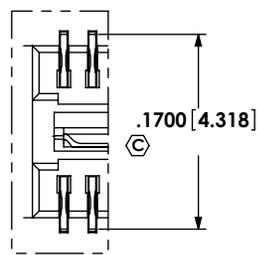
**INSPECTION VIEW 3**  
(FILL TOP ROW)



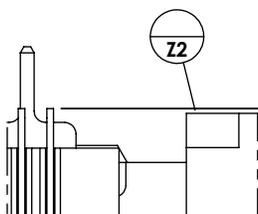
$.004 \pm .002$  [0.10 ± 0.05]  
(TOP ROW)  
(SEE NOTE 11)



**DETAIL 'K'**  
SCALE 6 : 1



**DETAIL 'J'**  
SCALE 6 : 1



**DETAIL 'L'**  
SCALE 6 : 1

SEE TABLE 3  
WITHIN ROW

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

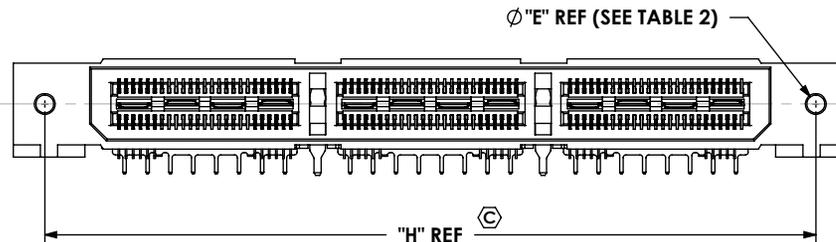
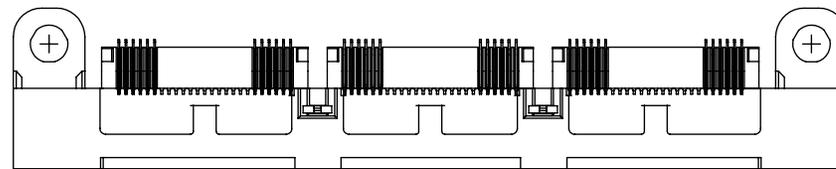
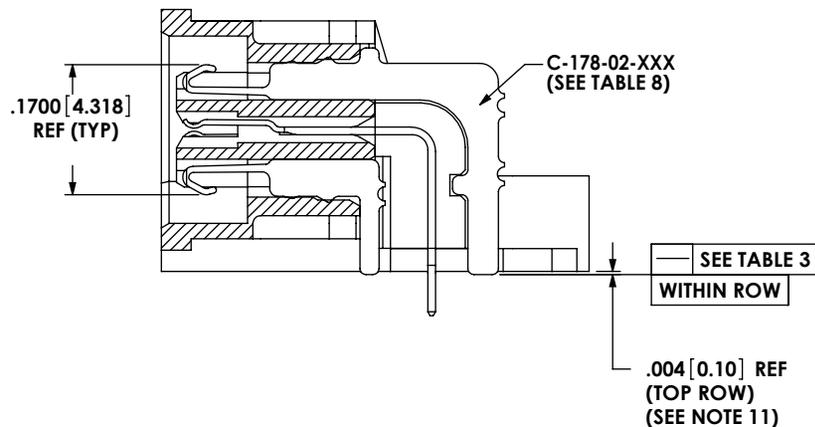


TABLE 5	
POSITION	"H"
-025	1.118 [28.38]
-050	1.905 [48.39]
-075	2.693 [68.39]
-100	3.480 [88.39]

**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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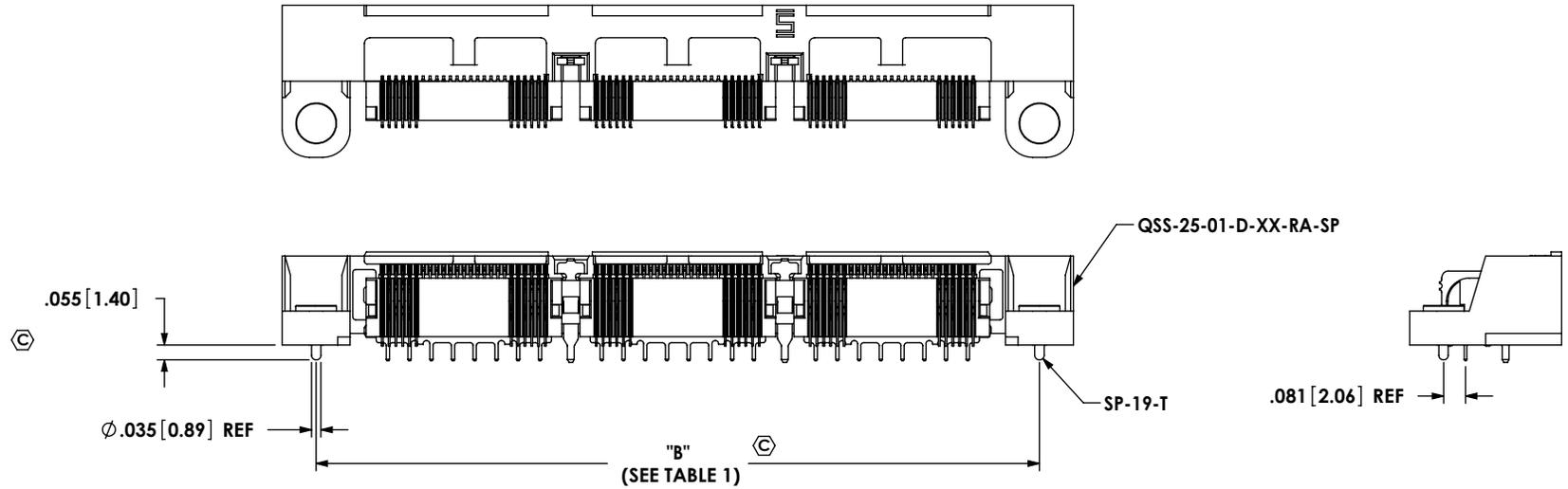
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.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

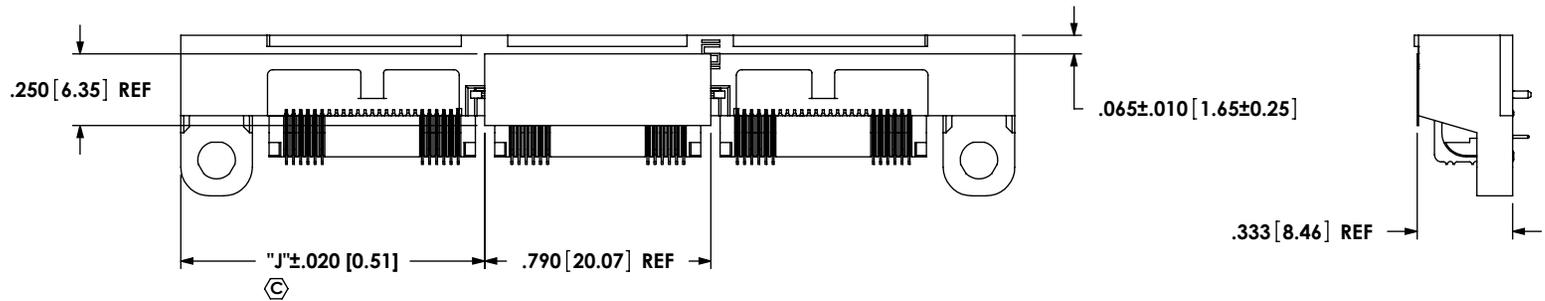
DWG. NO.  
**QSS-XXX-XX-XXX-D-RA-WT-XXX**

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]

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 .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)

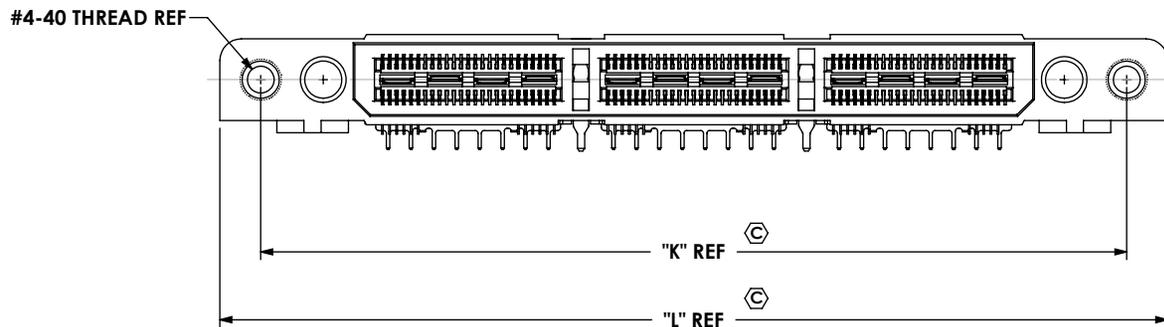
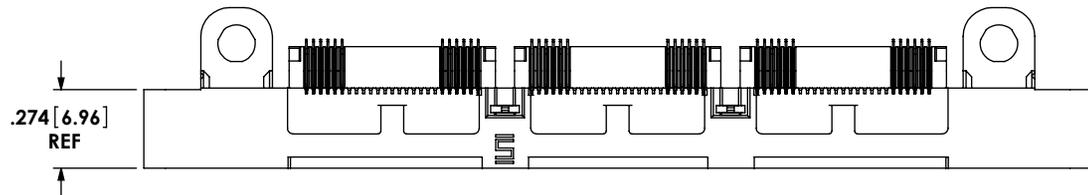


TABLE 7		
POSITION	"K"	"L"
-025	1.450 [36.82]	1.735 [44.06]
-050	2.237 [56.82]	2.522 [64.06]
-075	3.025 [76.82]	3.310 [84.06]
-100	3.812 [96.82]	4.097 [104.06]

**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:**

.635mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

**DWG. NO.**

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

**BY: KEVIN B**

**01/22/02**

**SHEET 6 OF 6**