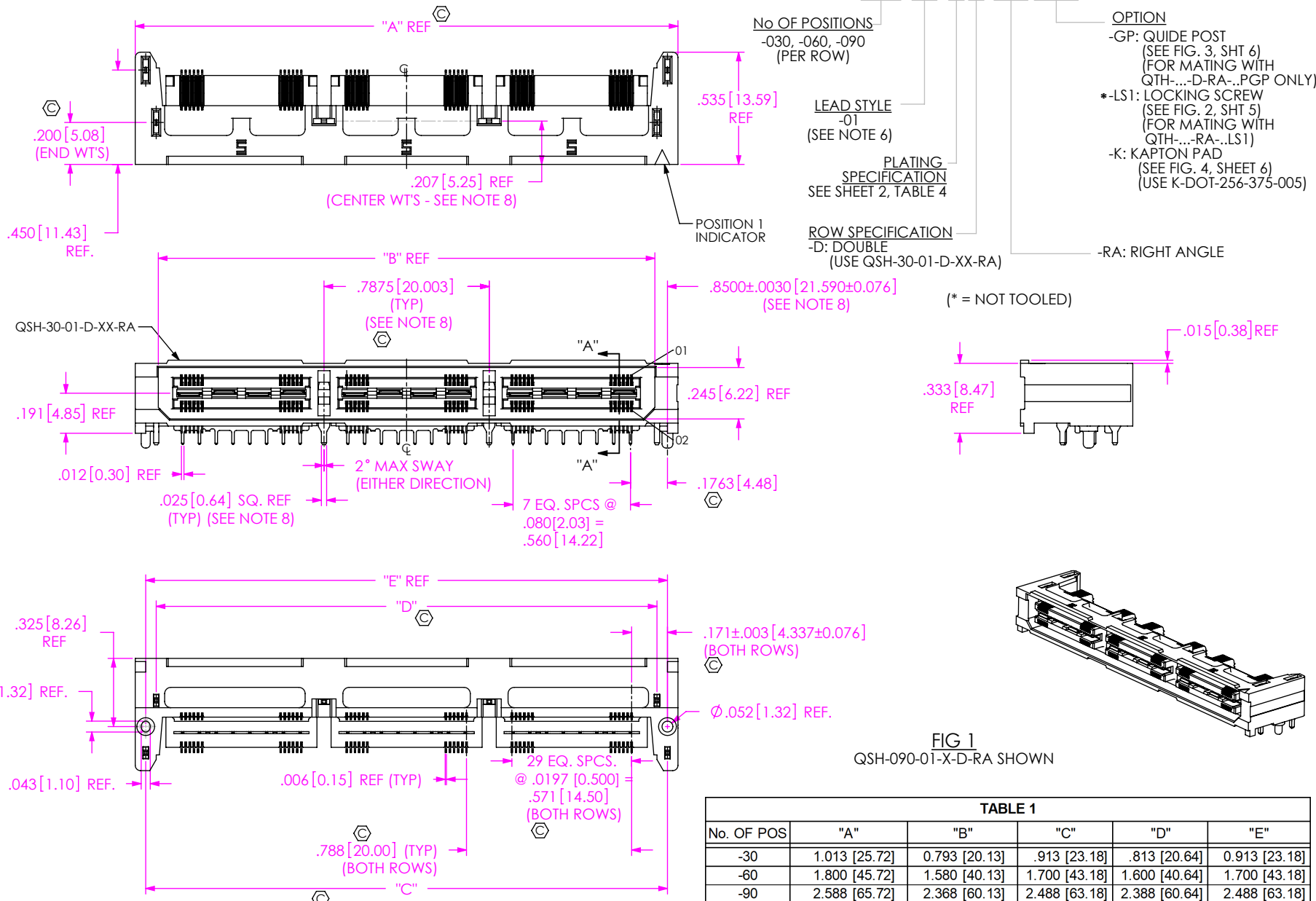


DO NOT SCALE FROM THIS PRINT



NOTES:

1. Ⓢ REPRESENTS A CRITICAL DIMENSION.
2. BURR ALLOWANCE: .0010 MAX.
3. MINIMUM PUSHOUT FORCE: 6 OZ.
4. IF NEEDED, -L PLATING CAN BE SUBSTITUTED FOR -F PLATING.
5. IM-1G18-01-2-XX RETENTION TO BE 1.0 LBS. MINIMUM PRIOR TO SECOND ROW FILL.
6. DESIGNED FOR USE WITH A .062 OR .093 THICK PCB
7. ASSEMBLIES TO BE PACKAGED IN TRAYS.
8. CENTER WELD TABS ARE NOT AVAILABLE ON -030 POSITION.
9. USE -Z- DATUM ZONE ONLY FOR MEASUREMENTS.
10. NOTE DELETED.

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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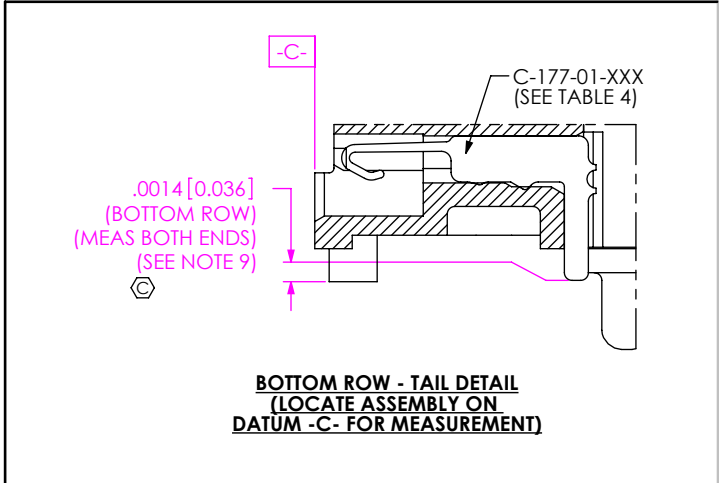
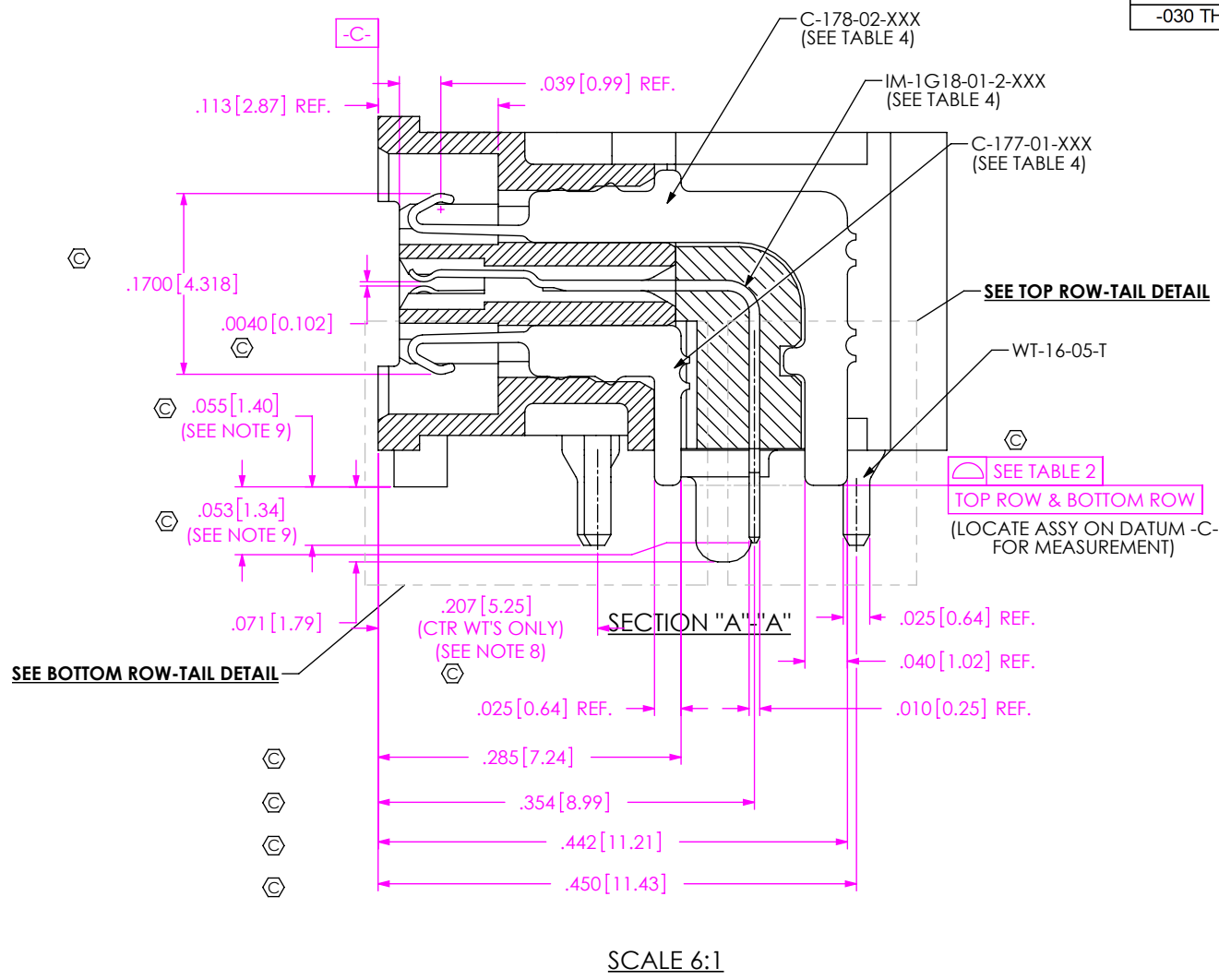


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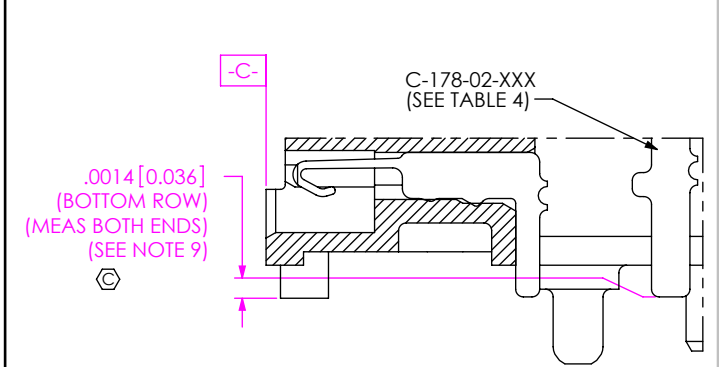
MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 2:1
INSULATOR: LCP UL94V-0, COLOR BLACK
TERMINAL, GROUND PLANE & WELD TAB: PHOS BRONZE

DESCRIPTION: .50mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP
DWG. NO. QSH-XXX-XX-X-D-RA-XXX
BY: DUKES Z 01/31/2010 SHEET 1 OF 6

| TABLE 2 | | | |
|-----------------|-------------|--------------------|--------------------|
| No OF POSITIONS | COPLANARITY | STRAIGHTNESS ROW 1 | STRAIGHTNESS ROW 1 |
| -030 THRU -090 | .004[0.10] | .004[0.10] | .004[0.10] |



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



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

SEE BOTTOM ROW-TAIL DETAIL

SCALE 6:1

TABLE 4: PLATING SPECIFICATIONS

| | C-177-01-XXX CONTACT | C-178-02-XXX CONTACT | IM-1G18-01-2-X GROUND PLANE | WT-16-05-T WELD TAB |
|----|---|--|--|---------------------|
| -F | 3 - 5µ" FLASH GOLD ON CONTACT, MATTE TIN TAIL | 3 - 5µ" FLASH GOLD CONTACT, MATTE TIN TAIL | 3µ" MIN. FLASH GOLD CONTACT, MATTE TIN TAIL | MATTE TIN |
| -L | 10µ" MIN. LIGHT GOLD CONTACT, MATTE TIN TAIL | 10µ" MIN. LIGHT GOLD CONTACT, MATTE TIN TAIL | 10µ" MIN. LIGHT GOLD CONTACT, MATTE TIN TAIL | MATTE TIN |

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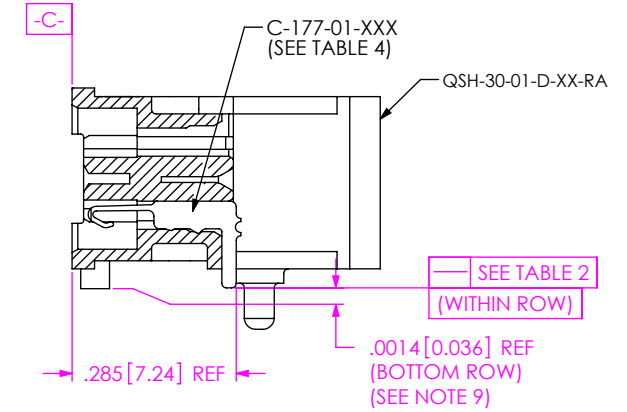
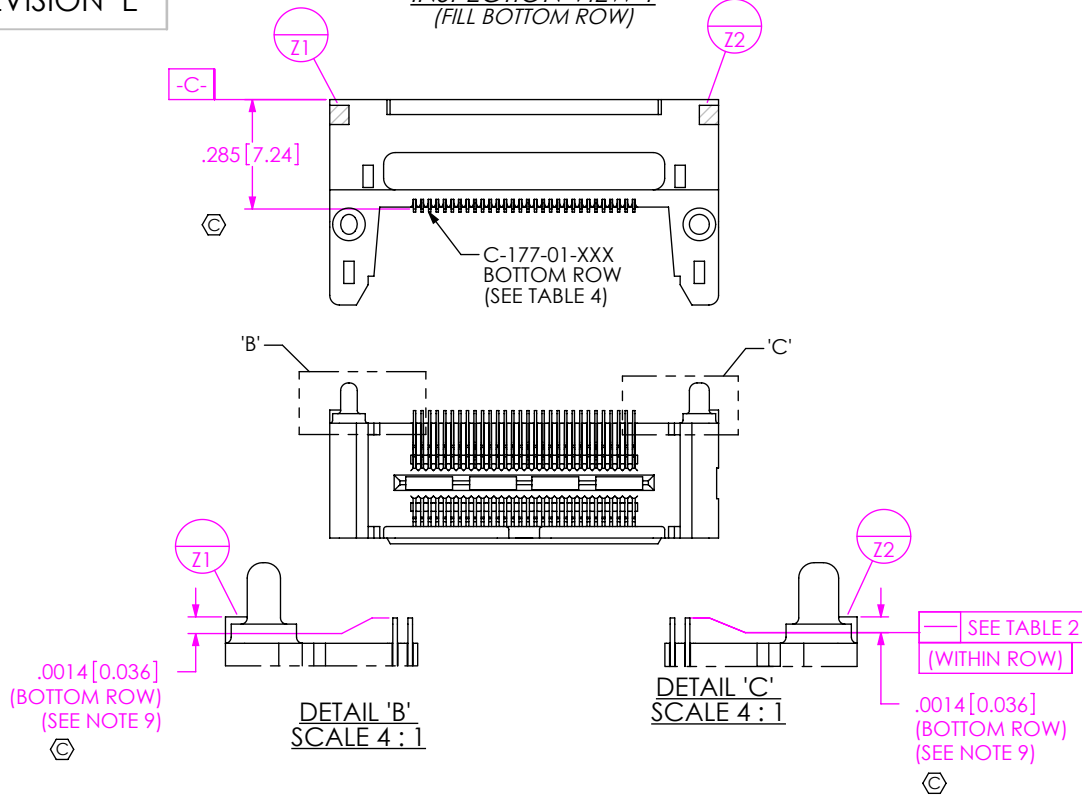
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DESCRIPTION:
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DWG. NO.
QSH-XXX-XX-X-D-RA-XXX

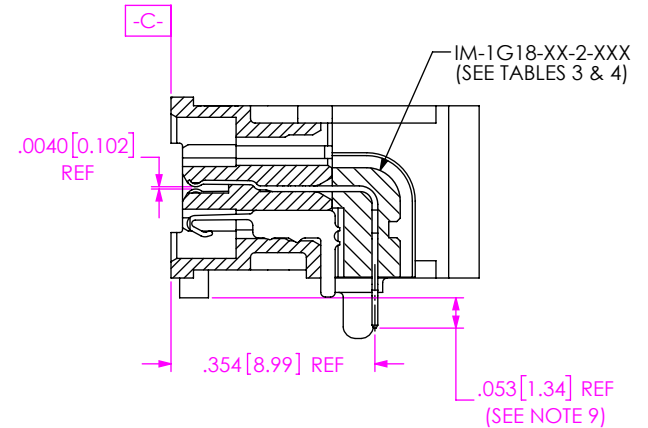
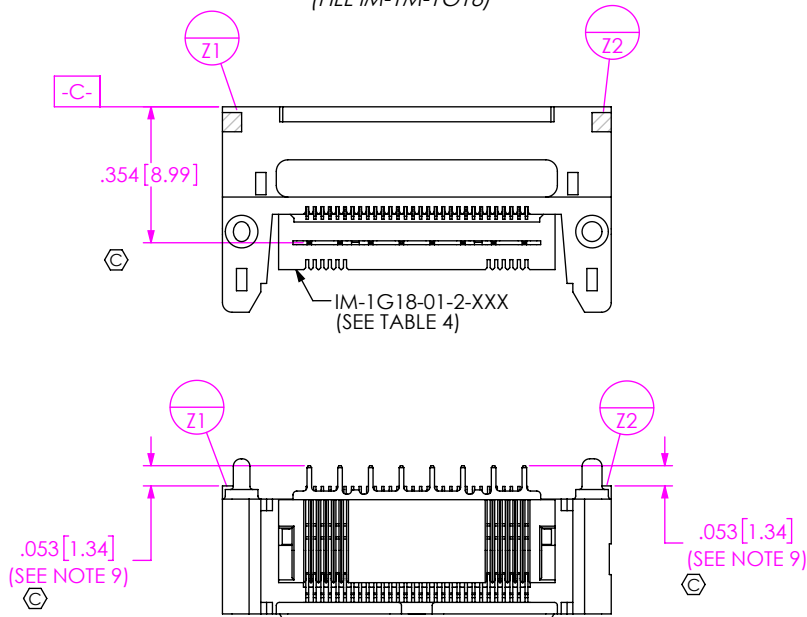
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INSPECTION VIEW 1
(FILL BOTTOM ROW)



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

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



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

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SHEET SCALE: 6:1



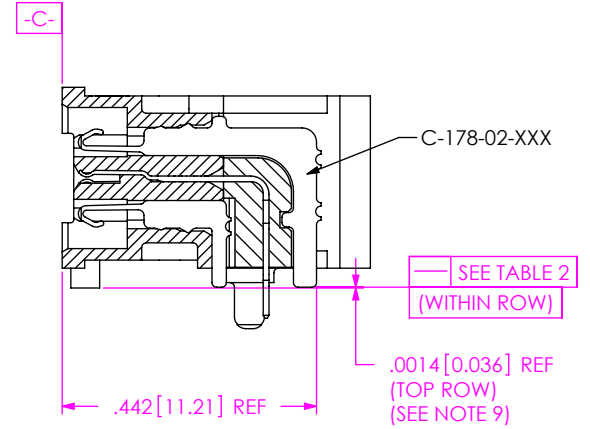
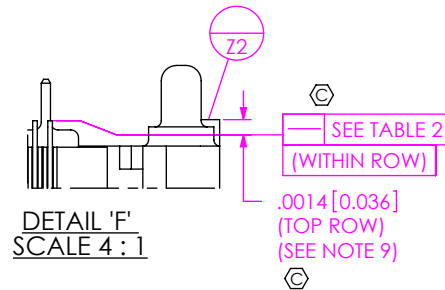
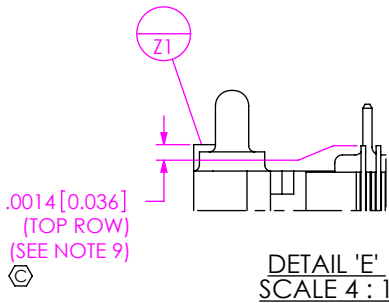
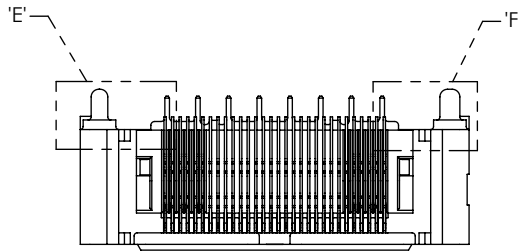
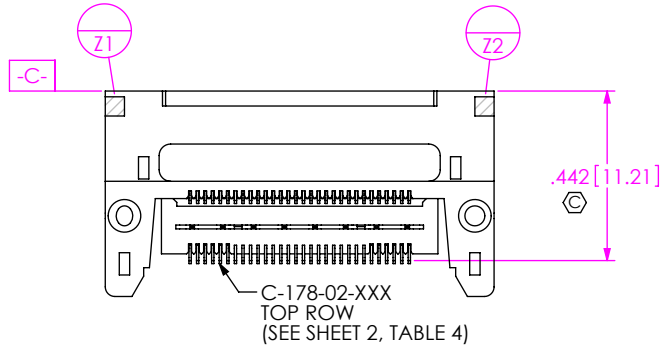
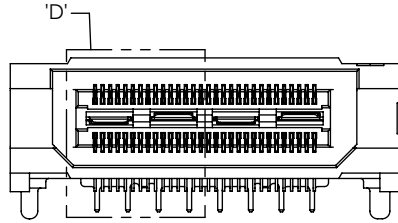
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DESCRIPTION:
.50mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

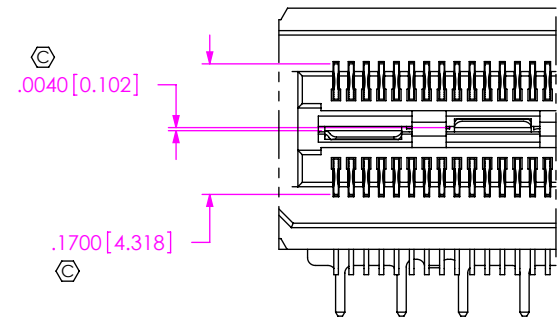
DWG. NO.
QSH-XXX-XX-X-D-RA-XXX

BY: DUKES Z 01/31/2010 SHEET 3 OF 6

INSPECTION VIEW 3
(FILL TOP ROW)



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



DETAIL 'D'
SCALE 4 : 1

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SHEET SCALE: 6:1



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DWG. NO.
QSH-XXX-XX-X-D-RA-XXX

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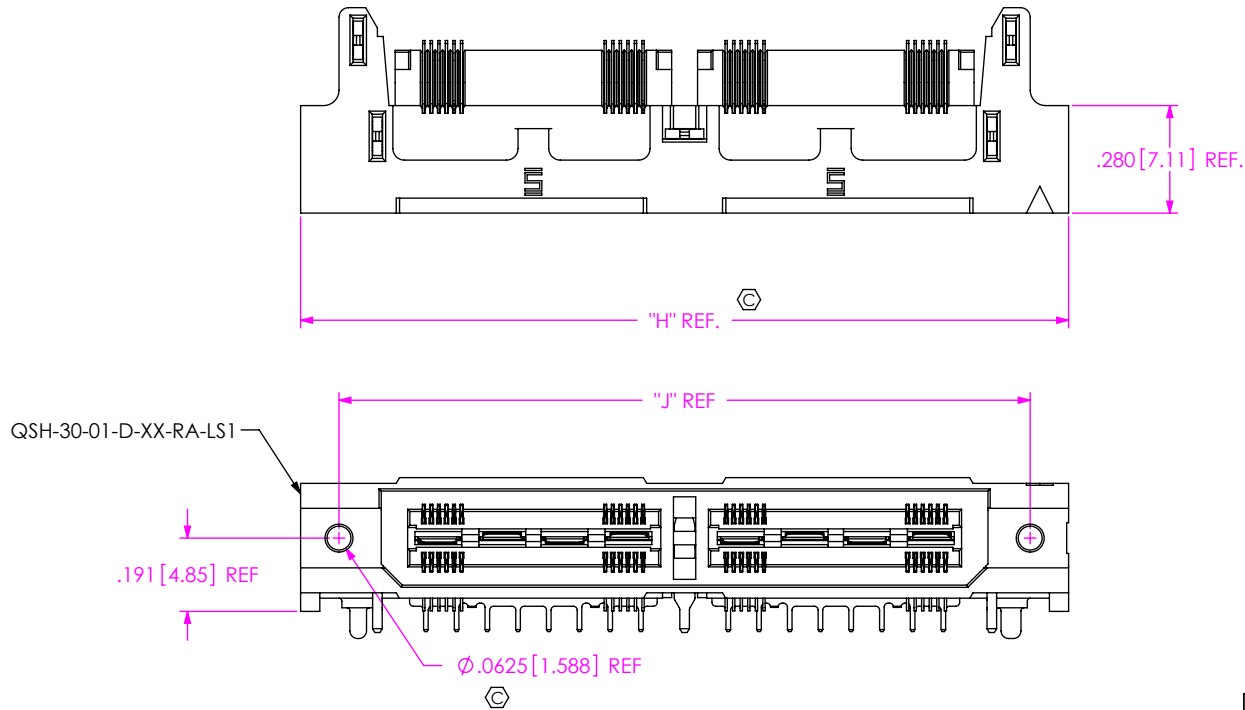



FIG 2
 QSH-060-01-X-D-RA-LS1 SHOWN
 (SAME AS FIG. 1, EXCEPT AS SHOWN)
 (NOT TOOLED)

| TABLE 5 | | |
|-----------|---------------|---------------|
| NO OF POS | "H" | "J" |
| -30 | 1.213 [30.80] | 1.013 [25.72] |
| -60 | 2.000 [50.80] | 1.800 [45.72] |
| -90 | 2.788 [70.80] | 2.588 [65.72] |

| | | |
|--|---|---------------------|
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| | <p>DESCRIPTION: .50mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP</p> | |
| | <p>DWG. NO. QSH-XXX-XX-X-D-RA-XXX</p> | |
| | <p>BY: DUKES Z 01/31/2010</p> | <p>SHEET 5 OF 6</p> |

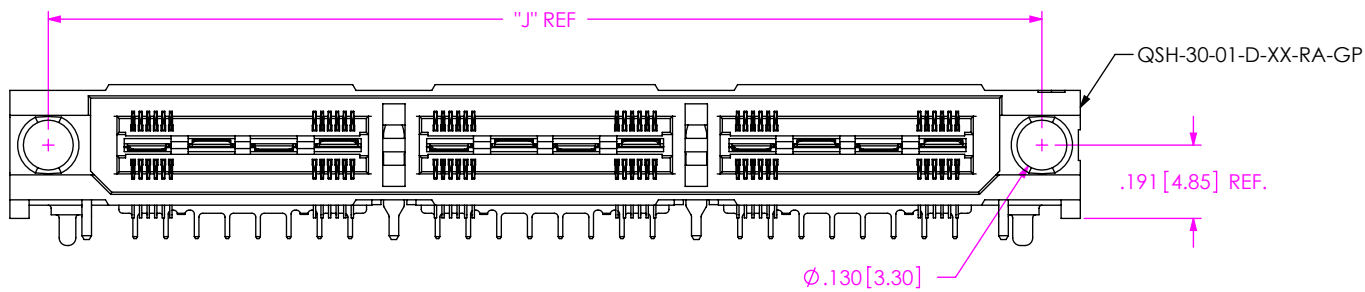
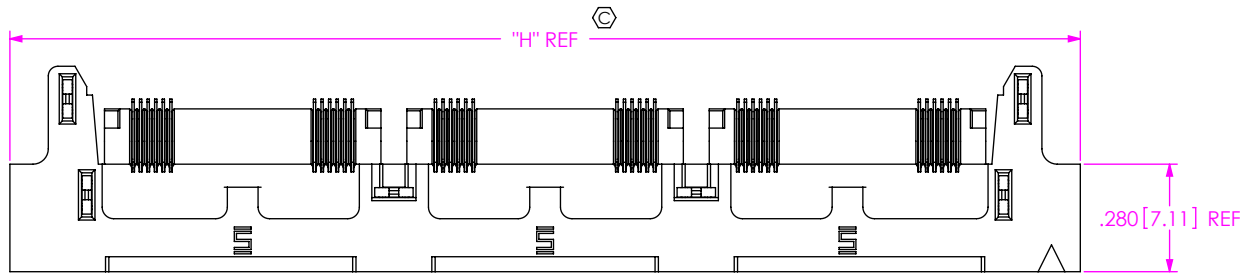


FIG 3
QSH-090-01-X-D-RA-GP SHOWN
(SAME AS FIG. 1, EXCEPT AS SHOWN)

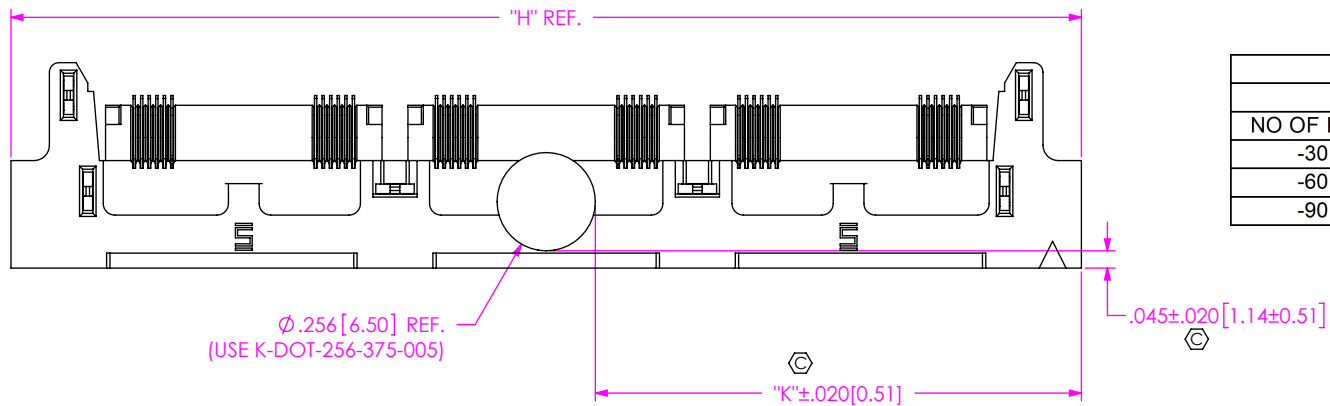


FIG 4
QSH-090-01-X-D-RA-GP-K SHOWN
(SAME AS FIG. 1, EXCEPT AS SHOWN)

| TABLE 6 | | | | |
|-----------|-------|---------|---------|---------|
| NO OF POS | "K" | | | |
| | -GP | | NON -GP | |
| -30 | .478 | [12.14] | .378 | [9.60] |
| -60 | .872 | [22.15] | .772 | [19.61] |
| -90 | 1.266 | [32.16] | 1.166 | [29.62] |

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