

REVISION BU

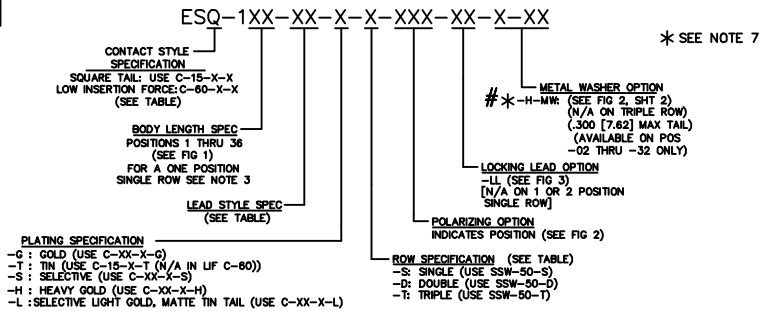
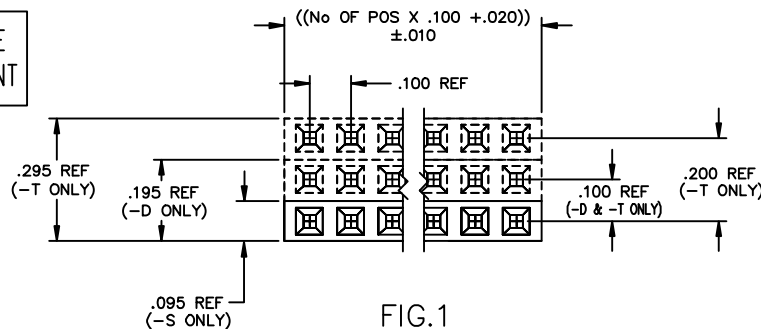
DO NOT SCALE
FROM THIS PRINT

FIG.1

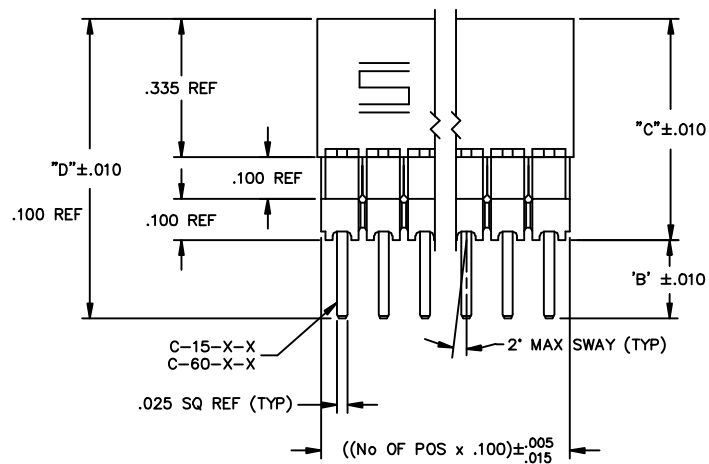
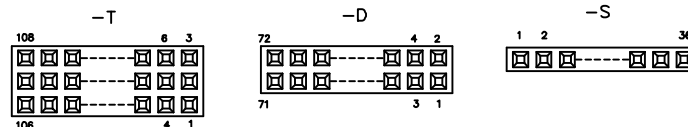


FIG.2

POLARIZATION LOCATION
INSERT PK-06-N INTO SPECIFIED POS
AND BREAK OFF TAB

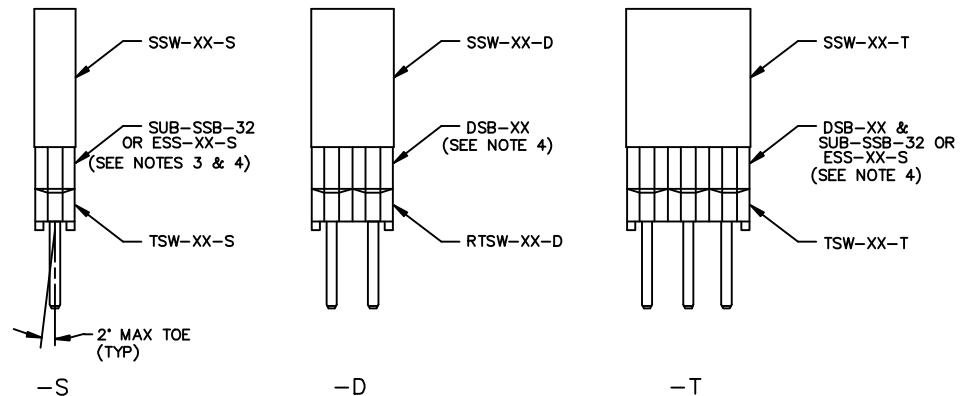
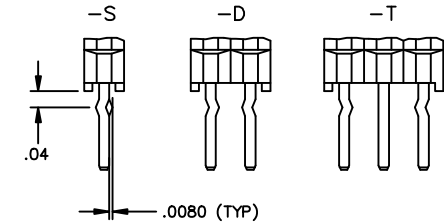
UNLESS OTHERWISE NOTED				TOLERANCES ARE:		TITLE:		DWG NO:									
DIMENSIONS ARE IN INCHES		THREE PLACE DECIMALS ± .005		ANGLES ± 2°		ESQ STRIP ASM.		ESQ-1XX-XX-X-X-XXX-XX-X-XX									
ONE PLACE DECIMALS ±.1		FOUR PLACE DECIMALS ± .0020						SHEET 1 OF 3									
TWO PLACE DECIMALS ±.01																	
		STANDARD INSERTION FORCE		CONTACT		SPACER SPECIFICATION (FOR A ONE POSITION SINGLE ROW SEE NOTE 3)				"B"		"C"		"D"		"E"	
						ESQ-S		ESQ-D		ESQ-T							
		-12	C-15-2-X	N/A		N/A		N/A		N/A		.090	.435	.525	.100		
		-13	C-15-2-X	N/A		N/A		N/A		N/A		.290	.435	.725	N/A		
		-14	C-15-4-X	N/A		N/A		N/A		N/A		.480	.435	.915	N/A		
		-23	C-15-3-X	(1) SUB-SSB-32		(1) DSB-XX		(1) SUB-SSB-32		(1) DSB-XX		.190	.535	.725	N/A		
		-24	C-15-4-X	(1) SUB-SSB-32		(1) DSB-XX		(1) SUB-SSB-32		(1) DSB-XX		.380	.535	.915	N/A		
		-33	C-15-3-X	(2) SUB-SSB-32		(2) DSB-XX		(2) SUB-SSB-32		(2) DSB-XX		.090	.635	.725	N/A		
		-34	C-15-4-X	(2) SUB-SSB-32		(2) DSB-XX		(2) SUB-SSB-32		(2) DSB-XX		.280	.635	.915	N/A		
		-44	C-15-4-X	(1) ESS-XX-S		(3) DSB-XX		(1) ESS-XX-S		(3) DSB-XX		.180	.735	.915	N/A		
		LOW INSERTION FORCE		CONTACT		SPACER SPECIFICATION (FOR A ONE POSITION SINGLE ROW SEE NOTE 3)				"B"		"C"		"D"		"E"	
						ESQ-S		ESQ-D		ESQ-T							
		-37	C-60-2-X	N/A		N/A		N/A		N/A		.090	.435	.525	.100		
		-38	C-60-3-X	N/A		N/A		N/A		N/A		.290	.435	.725	N/A		
		-39	C-60-4-X	N/A		N/A		N/A		N/A		.480	.435	.915	N/A		
		-48	C-60-3-X	SUB-SSB-32		(1) DSB-XX		(1) SUB-SSB-32		(1) DSB-XX		.190	.535	.725	N/A		
		-49	C-60-4-X	(1) SUB-SSB-32		(1) DSB-XX		(1) SUB-SSB-32		(1) DSB-XX		.380	.535	.915	N/A		
		-58	C-60-3-X	(2) SUB-SSB-32		(2) DSB-XX		(2) SUB-SSB-32		(2) DSB-XX		.090	.635	.725	N/A		
		-59	C-60-4-X	(2) SUB-SSB-32		(2) DSB-XX		(2) SUB-SSB-32		(2) DSB-XX		.280	.635	.915	N/A		
		-69	C-60-4-X	(1) ESS-XX-S		(3) DSB-XX		(1) ESS-XX-S		(3) DSB-XX		.180	.735	.915	N/A		

NOTES:

- CONTACT PUSHOUT SHALL BE 1.5 LBS. MIN.
- MAX ALLOWABLE BOW .003 INCH/INCH AFTER ASSEMBLY.
- FOR A 1 POSITION SINGLE ROW ALL SPACERS ARE TO BE TSW-XX-S
- SPACERS SHALL BE ASSEMBLED AS SHOWN WITH SNAP GROOVES AWAY FROM SSW BODY.
- FOR IN-PROCESS VIEW SEE SHEET 3, FIGS 4 & 5.
- MAX CUT FLASH : .010
- DO NOT USE USB SPACER BODY FOR THIS OPTION.

- MW OPTION, DO NOT DESIGN IN. SAMTEC WILL
ONLY SUPPORT EXISTING BUSINESS 2/12/02.

FIG.3

LOCKING LEAD OPTION
LOCATED ON OR ABOUT CENTERLINE
(N/A IN 1 OR 2 POSITION SINGLE ROW)

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ESQ-ASM

samtec

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CODE 55322

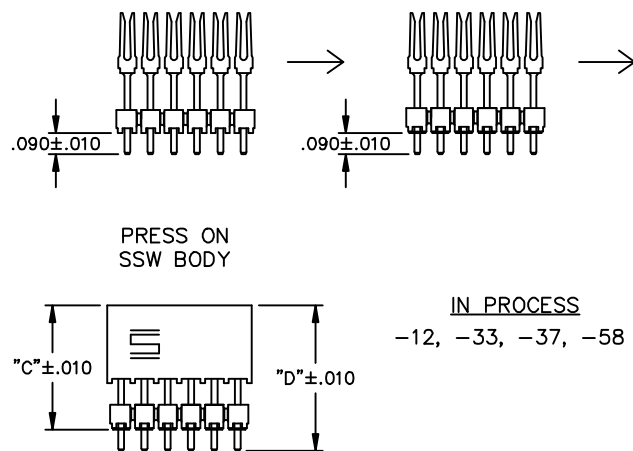
MADE BY:
JORDAN 7-16-85

ESQ-1XX-XX-X-X-XXX-XX-X-XX
SHEET 1 OF 3

REV. BU

LOAD CONTACT

PRESS ON -MW



UNLESS OTHERWISE NOTED

DIMENSIONS ARE IN INCHES
 ONE PLACE DECIMALS $\pm 1[2.5]$ THREE PLACE DECIMALS $\pm .005 [.13]$
 TWO PLACE DECIMALS $\pm .01 [.25]$ FOUR PLACE DECIMALS $\pm .0020 [.05]$

TOLERANCES ARE:

 ANGLES
 $\pm 2^\circ$

 TITLE: .100
 TERMINAL STRIP
 ASSEMBLY

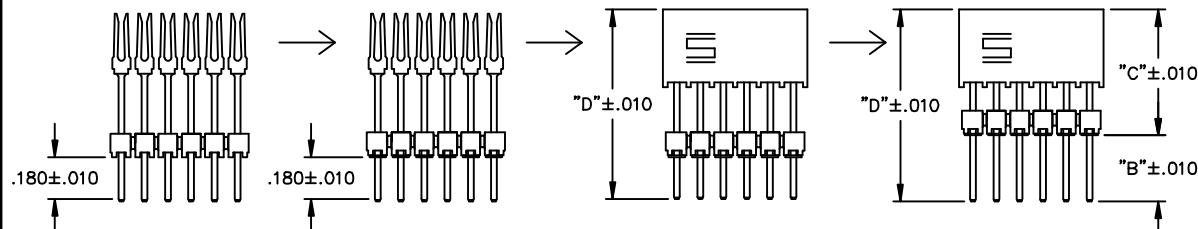
DWG NO:

ESQ-1XX-XX-X-X-XXX-XX-X-XX

SHEET 2 OF 3

LOAD CONTACT

PRESS ON -MW

PRESS ON
SSW BODY
 REPRESS STACKER BODY
 AND -MW TO PROPER "C" DIM


IN PROCESS

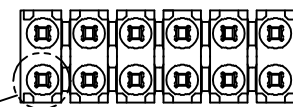
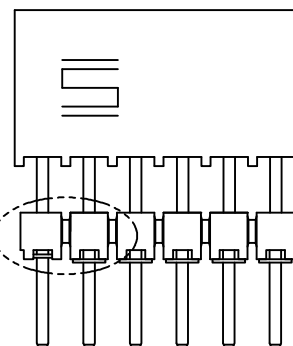
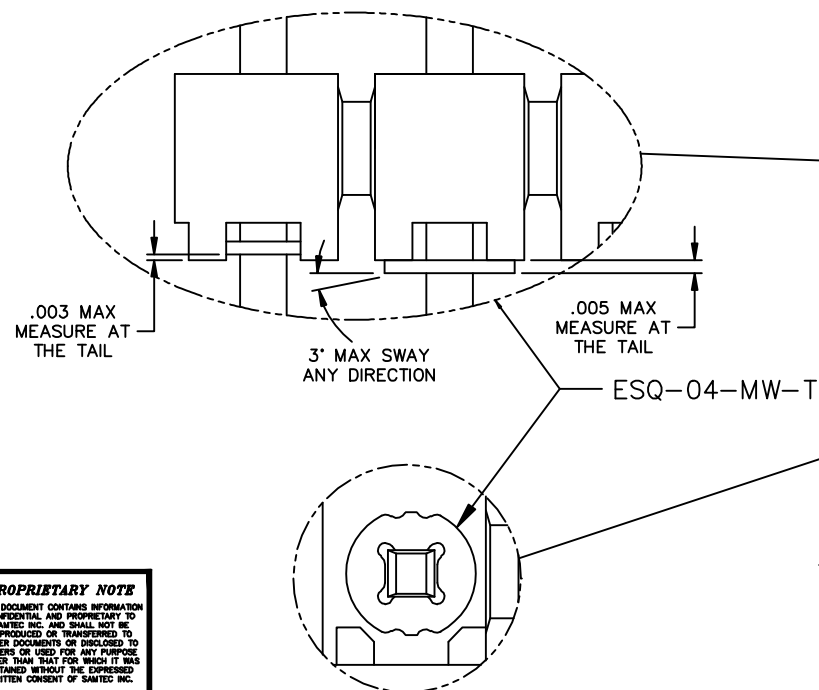
 -13, -14, -23, -24, -34, -38,
 -39, -44, -48, -49, -59, -69


FIG. 2

-H-MW: METAL WASHER
 (ONE PER POSITION)
 (-S & -D BODY SPECS ONLY)
 (SEE NOTE 7)

- MW OPTION, DO NOT DESIGN IN. SAMTEC WILL
 ONLY SUPPORT EXISTING BUSINESS 2/12/02.

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 CODE 55322

MADE BY:
 WHITTAKER 9-11-98

ESQ-1XX-XX-X-X-XXX-XX-X-XX
 SHEET 2 OF 3

DIMENSIONS ARE IN INCHES		UNLESS OTHERWISE NOTED	TOLERANCES ARE:	ANGLES
ONE PLACE DECIMALS $\pm .1$ [2.5]	THREE PLACE DECIMALS $\pm .005$ [.13]			$\pm 2^\circ$
TWO PLACE DECIMALS $\pm .01$ [.25]	FOUR PLACE DECIMALS $\pm .0020$ [.05]			

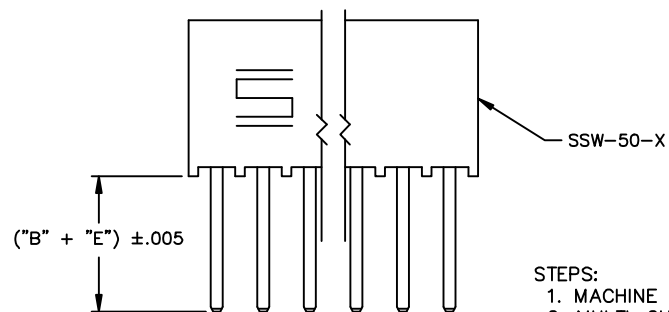
TITLE: .100
TERMINAL STRIP
ASSEMBLY

DWG NO:
ESQ-1XX-XX-X-X-XXX-XX-X-XX
SHEET 3 OF 3

- MW OPTION, DO NOT DESIGN IN. SAMTEC WILL
ONLY SUPPORT EXISTING BUSINESS 2/12/02.

TABLE 2			
LEAD STYLE	ROW	TUBE	PLUG (2)
-12, -37	-S	PT-1-24-01-46	TP-24
-13, -14, -23, -24, -33, -34, -44 -38, -39, -48, -49, -58, -59, -69		PT-1-24-01-47	TP-24
-12, -37	-D	PT-1-24-03-44	TP-07
-13, -14, -23, -24, -33, -34, -44 -38, -39, -48, -49, -58, -59, -69		PT-1-24-02-47	TP-07
-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

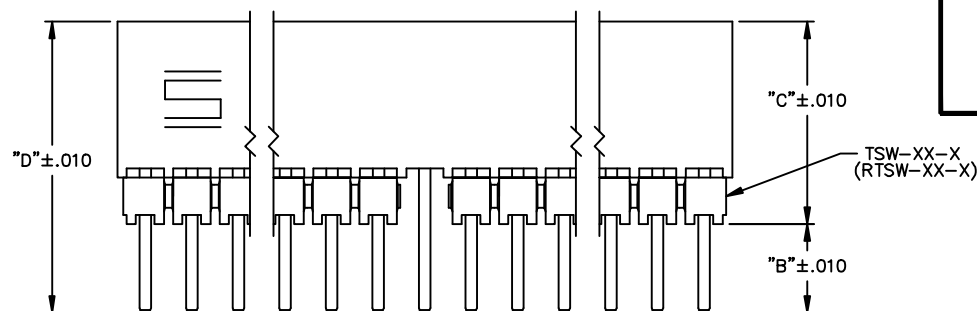
1. FOR -12 & -37 LEAD STYLES TUBE PACKAGE -04 THRU -36 POSITIONS ONLY.
2. FOR -13, -23, -33, -38, -48, & -58 LEAD STYLES TUBE PACKAGE -08 THRU -36 POSITIONS ONLY.
3. FOR -14, -24, -34, -44, -39, -49, -59, & -69 LEAD STYLES TUBE PACKAGE -05 THRU -36 POSITIONS ONLY.



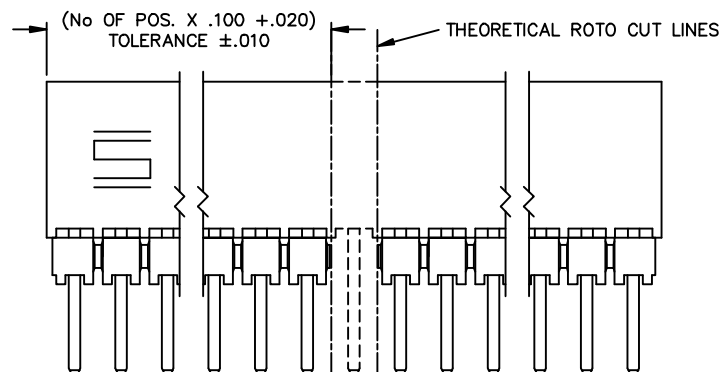
STEP 1

- STEPS:
1. MACHINE FILL SSW-50-X
 2. MULTI-CUT TSW-50-X TO POS (RTSW-50-D FOR DOUBLE ROW) AND MOUNT AS SHOWN.
 3. ROTO CUT TO POS.

(IF RTSW-50-D NOT AVAILABLE, TSW-50-D MAY BE USED)



STEP 2



STEP 3

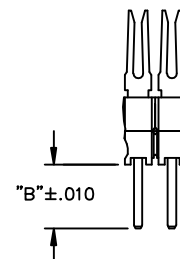


FIG. 4

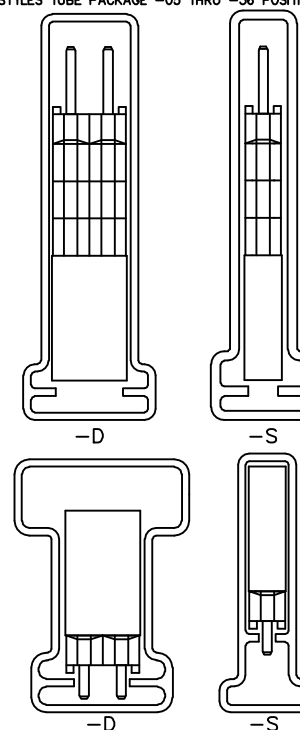
IN-PROCESS 'A'

(LEAD STYLE -12-T, -13, -14, -23, -24, -33, -34, -44, -37-T, -38, -39, -48, -49, -58, -59, -69)

FIG. 5

IN-PROCESS 'B'

(LEAD STYLE -12 & -37)
(-S & -D ONLY)



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ESQ-1XX-XX-X-X-XXX-XX-X-XX
SHEET 3 OF 3