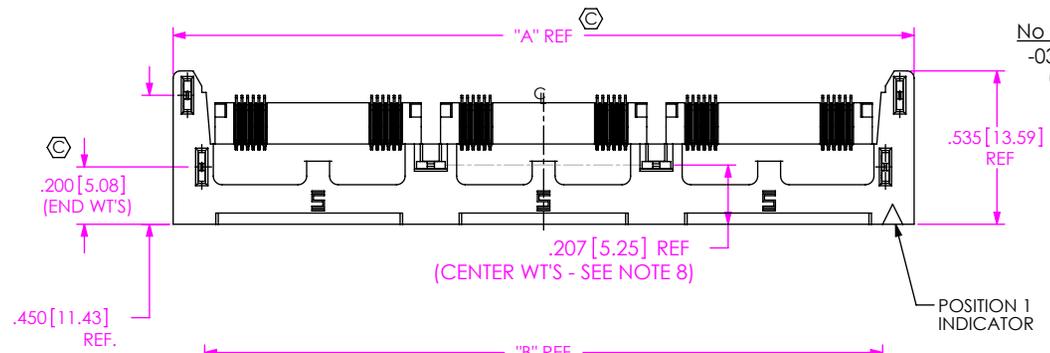


DO NOT SCALE FROM THIS PRINT

QSH-XXX-XX-X-D-RA-XXX



No OF POSITIONS  
-030, -060, -090  
(PER ROW)

LEAD STYLE  
-01  
(SEE NOTE 6)

PLATING SPECIFICATION  
SEE SHEET 2, TABLE 4

ROW SPECIFICATION  
-D: DOUBLE  
(USE QSH-30-01-D-XX-RA)

OPTION  
-GP: GUIDE POST  
(SEE FIG. 3, SHT 6)  
\* -LS1: LOCKING SCREW  
(SEE FIG. 2, SHT 5)  
(FOR MATING WITH  
QTH-...-RA-..LS1)  
-K: KAPTON PAD  
(SEE FIG. 4, SHEET 6)  
(USE K-DOT-256-375-005)

-RA: RIGHT ANGLE

(\* = NOT TOOLED)

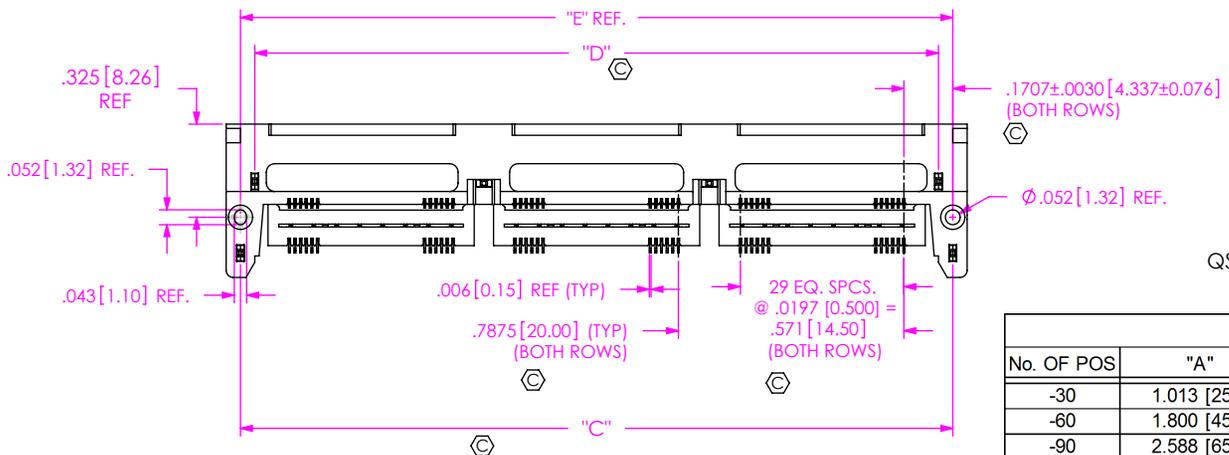
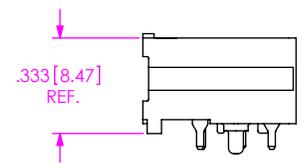
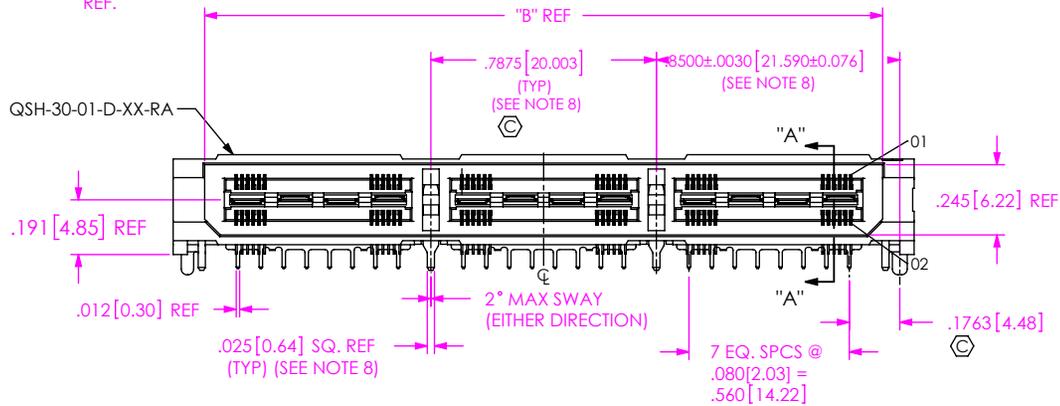


FIG 1  
QSH-090-01-X-D-RA SHOWN

No. OF POS	"A"	"B"	"C"	"D"	"E"
-30	1.013 [25.72]	0.793 [20.13]	.913 [23.18]	.813 [20.64]	0.913 [23.18]
-60	1.800 [45.72]	1.580 [40.13]	1.700 [43.18]	1.600 [40.64]	1.700 [43.18]
-90	2.588 [65.72]	2.368 [60.13]	2.488 [63.18]	2.388 [60.64]	2.488 [63.18]

- NOTES:
- ⊗ REPRESENTS A CRITICAL DIMENSION.
  - BURR ALLOWANCE: .0010 MAX.
  - MINIMUM PUSHOUT FORCE: 6 OZ.
  - IF NEEDED, -L PLATING CAN BE SUBSTITUTED FOR -F PLATING.
  - IM-1G18-01-2-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.
  - CENTER WELD TABS ARE NOT AVAILABLE ON -030 POSITION.
  - USE -Z- DATUM ZONE ONLY FOR MEASUREMENTS.

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE:  
DECIMALS ANGLES  
.XX: ±.01 [0.3]  
.XXX: ±.005 [0.13]  
.XXXX: ±.0020 [0.051]

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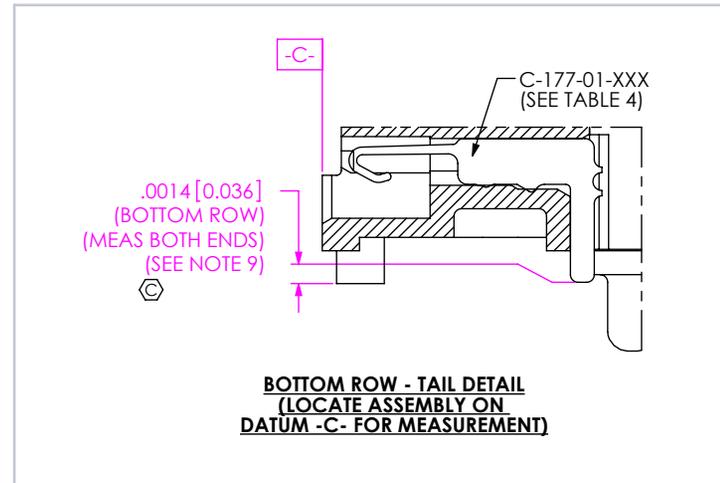
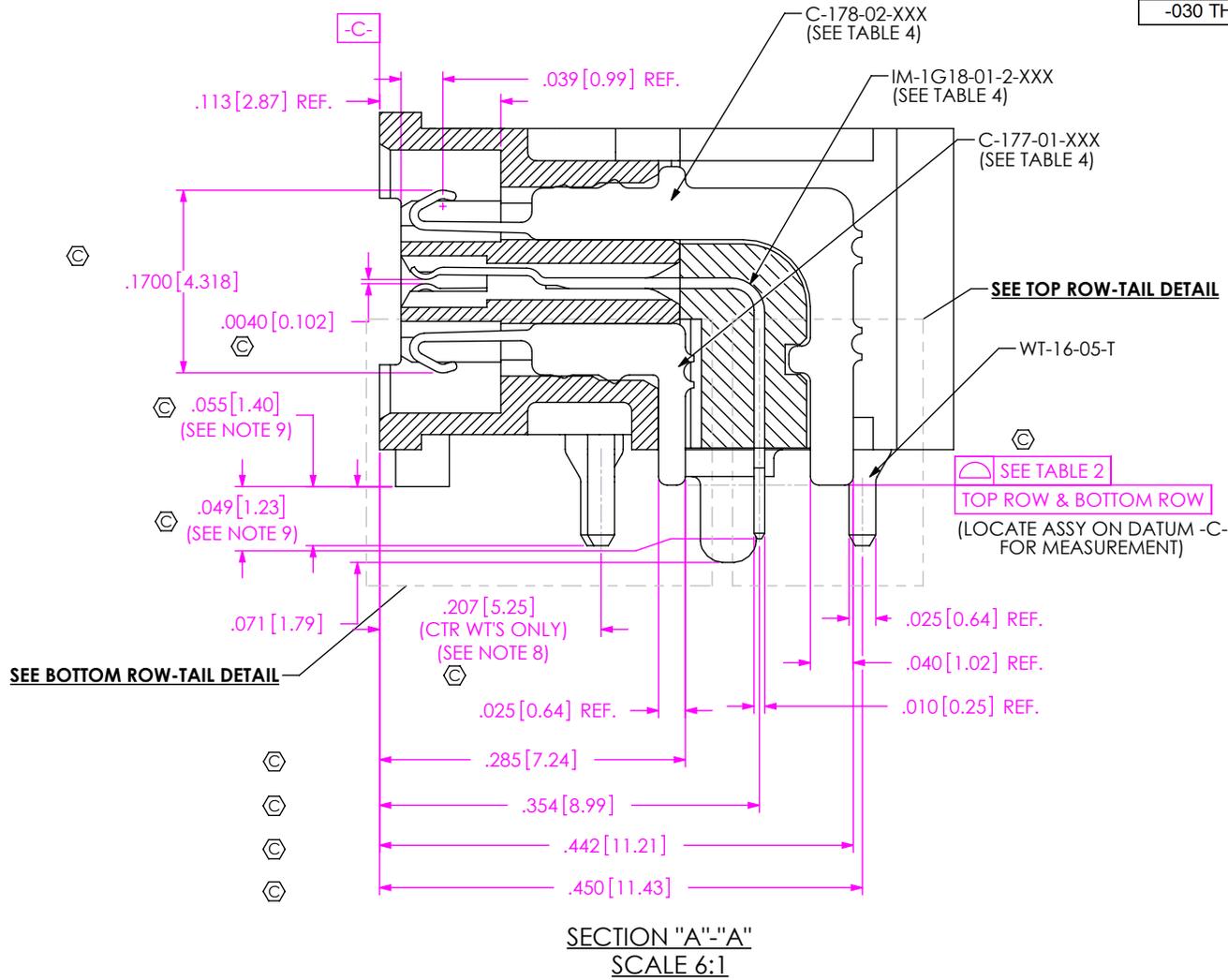
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e-Mail info@SAMTEC.com code 55322

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

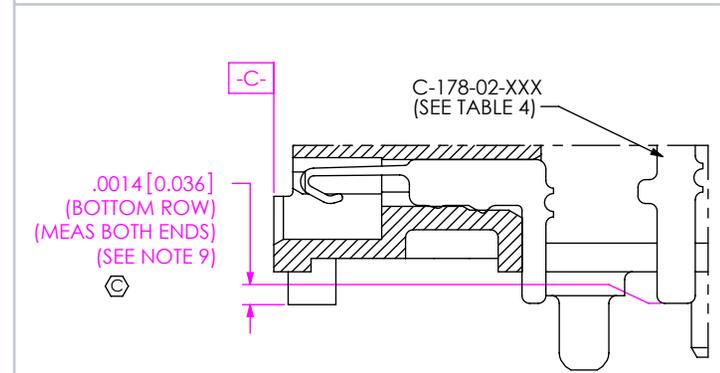
DESCRIPTION:  
.50mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP  
DWG. NO.  
QSH-XXX-XX-X-D-RA-XXX

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 ASSEMBLY ON  
DATUM -C- FOR MEASUREMENT)**



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

SEE BOTTOM ROW-TAIL DETAIL

SEE TOP ROW-TAIL DETAIL

**SECTION "A"-A"  
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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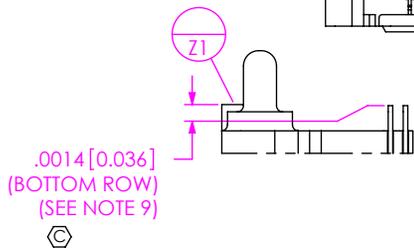
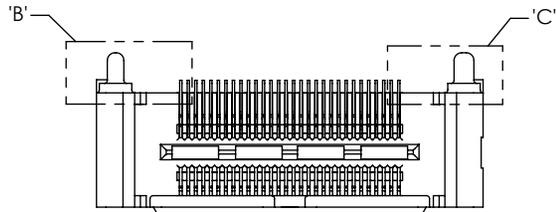
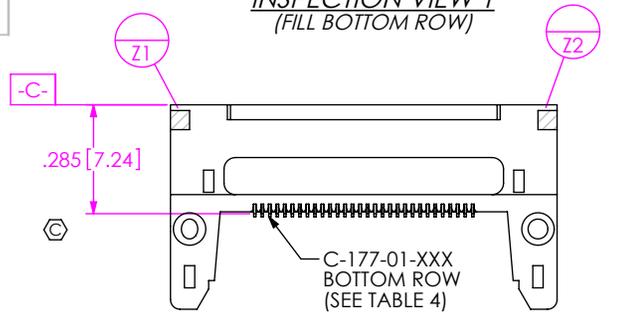
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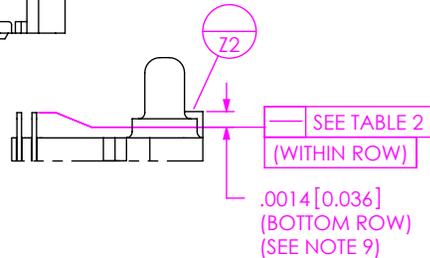
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**INSPECTION VIEW 1**  
(FILL BOTTOM ROW)

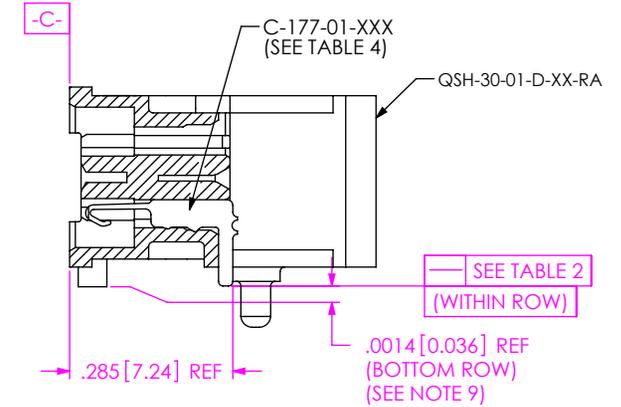
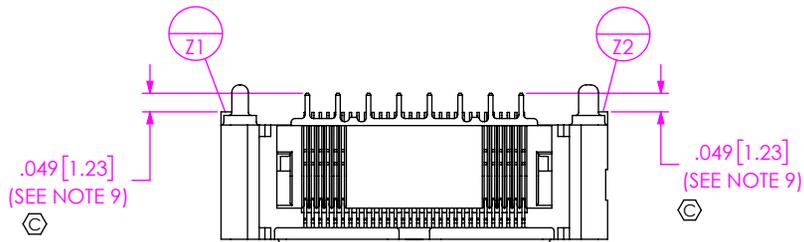
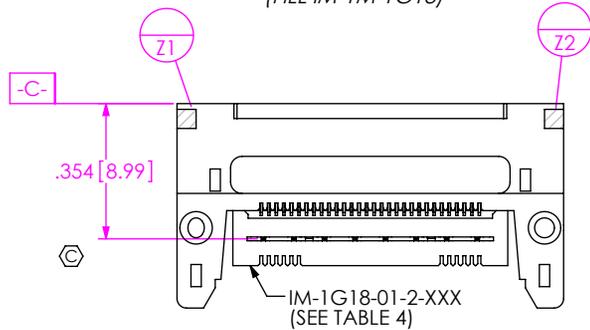


DETAIL 'B'  
SCALE 4:1

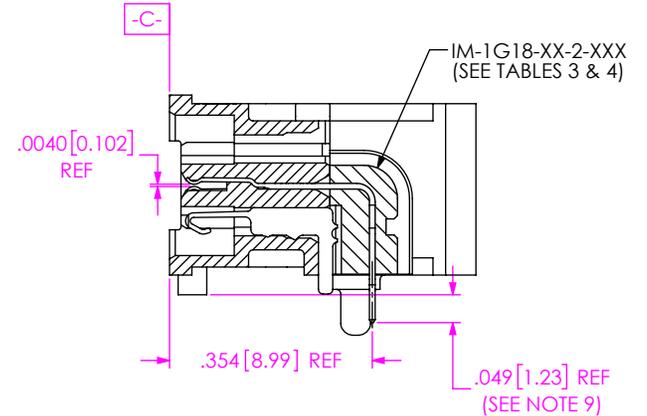


DETAIL 'C'  
SCALE 4:1

**INSPECTION VIEW 2**  
(FILL IM-1M-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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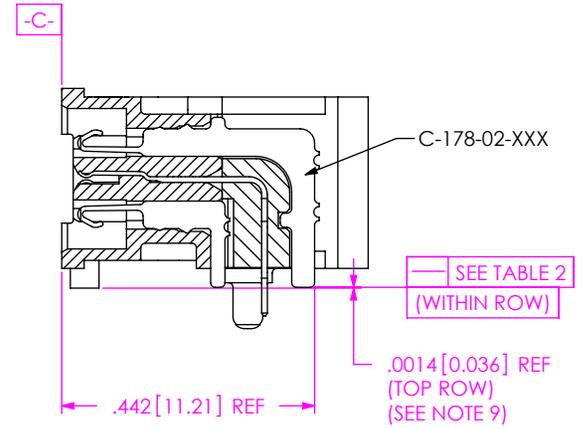
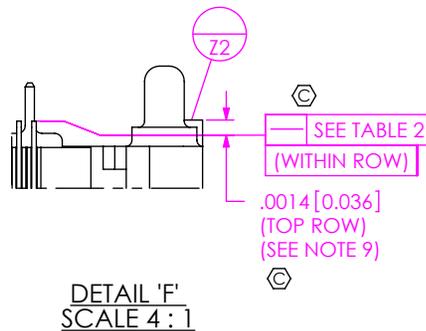
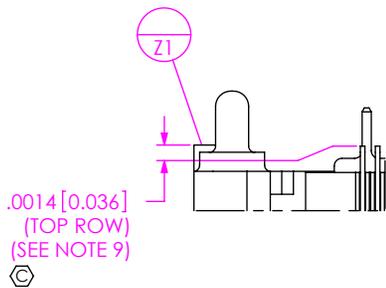
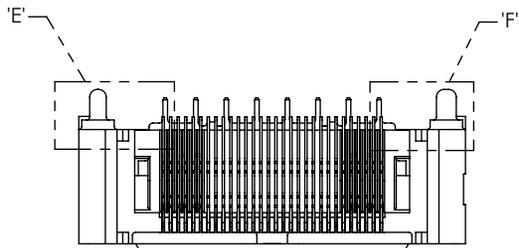
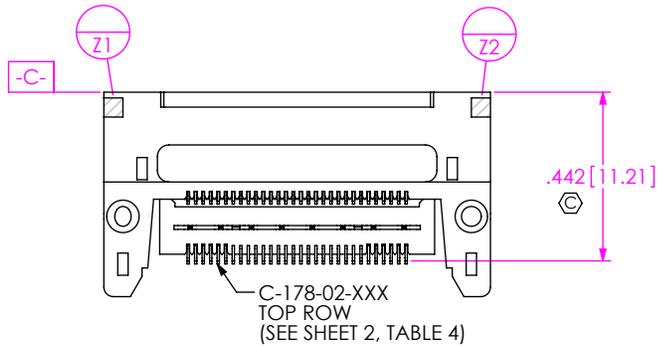
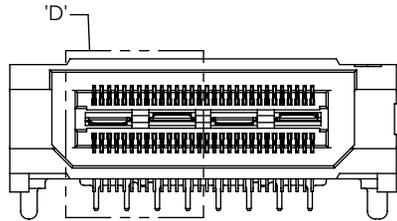
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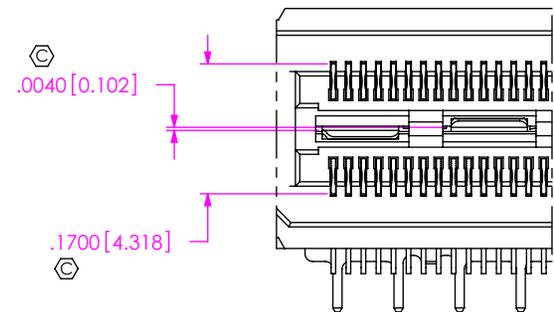
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**INSPECTION VIEW 3**  
(FILL TOP ROW)



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



**DETAIL 'D'**  
SCALE 4 : 1

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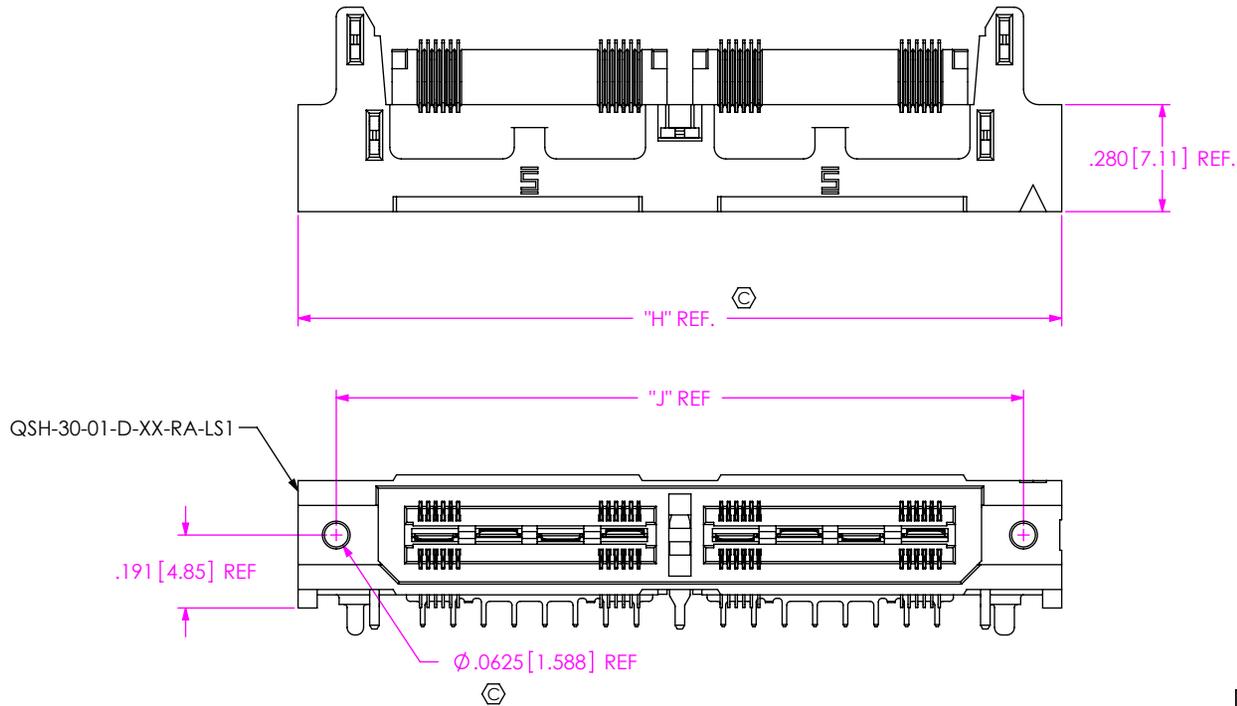


FIG 2  
 QSH-060-01-X-D-RA-LS1 SHOWN  
 (SAME AS FIG. 1, EXCEPT AS SHOWN)  
 (NOT TOOLED)

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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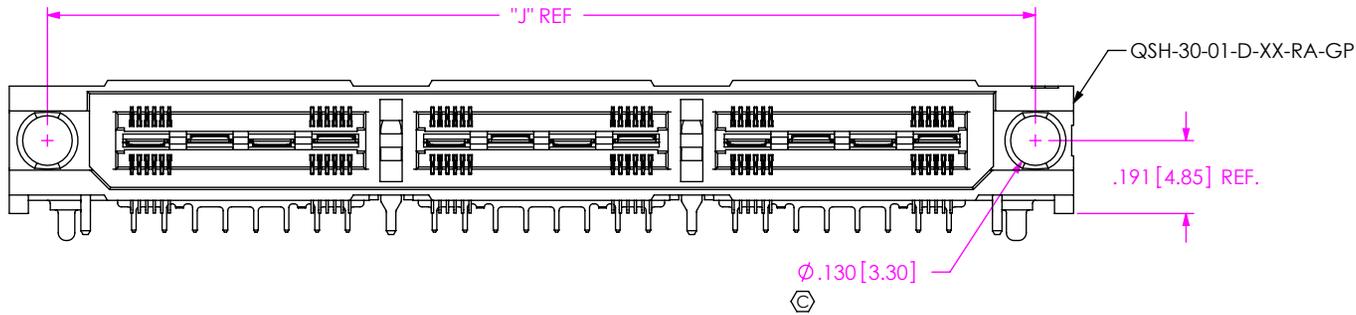
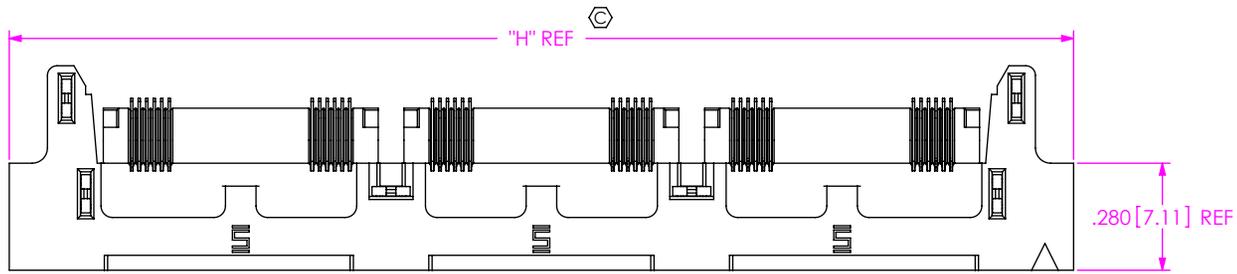


FIG 3  
QSH-090-01-X-D-RA-GP SHOWN  
(SAME AS FIG. 1, EXCEPT AS SHOWN)

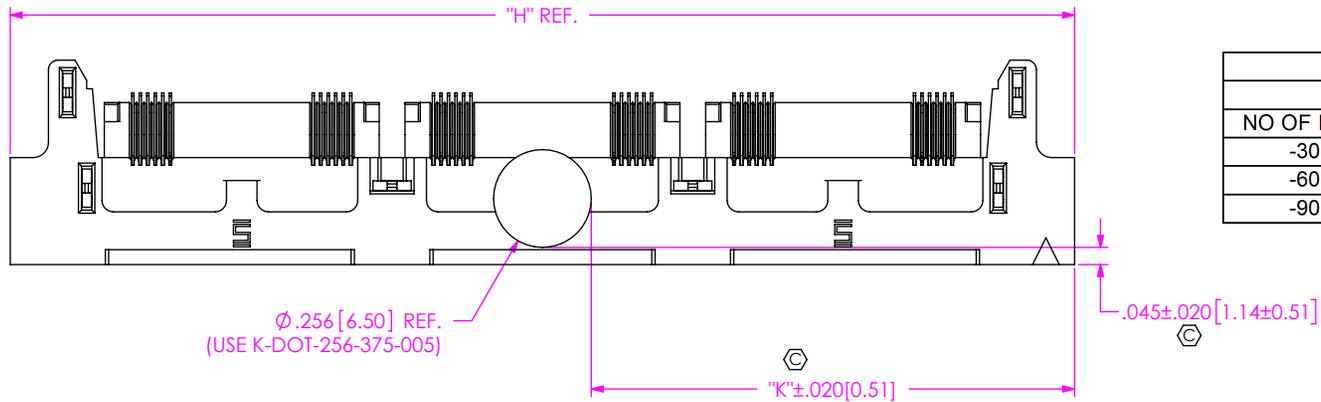


FIG 4  
QSH-090-01-X-D-RA-GP-K SHOWN  
(SAME AS FIG. 1, EXCEPT AS SHOWN)

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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