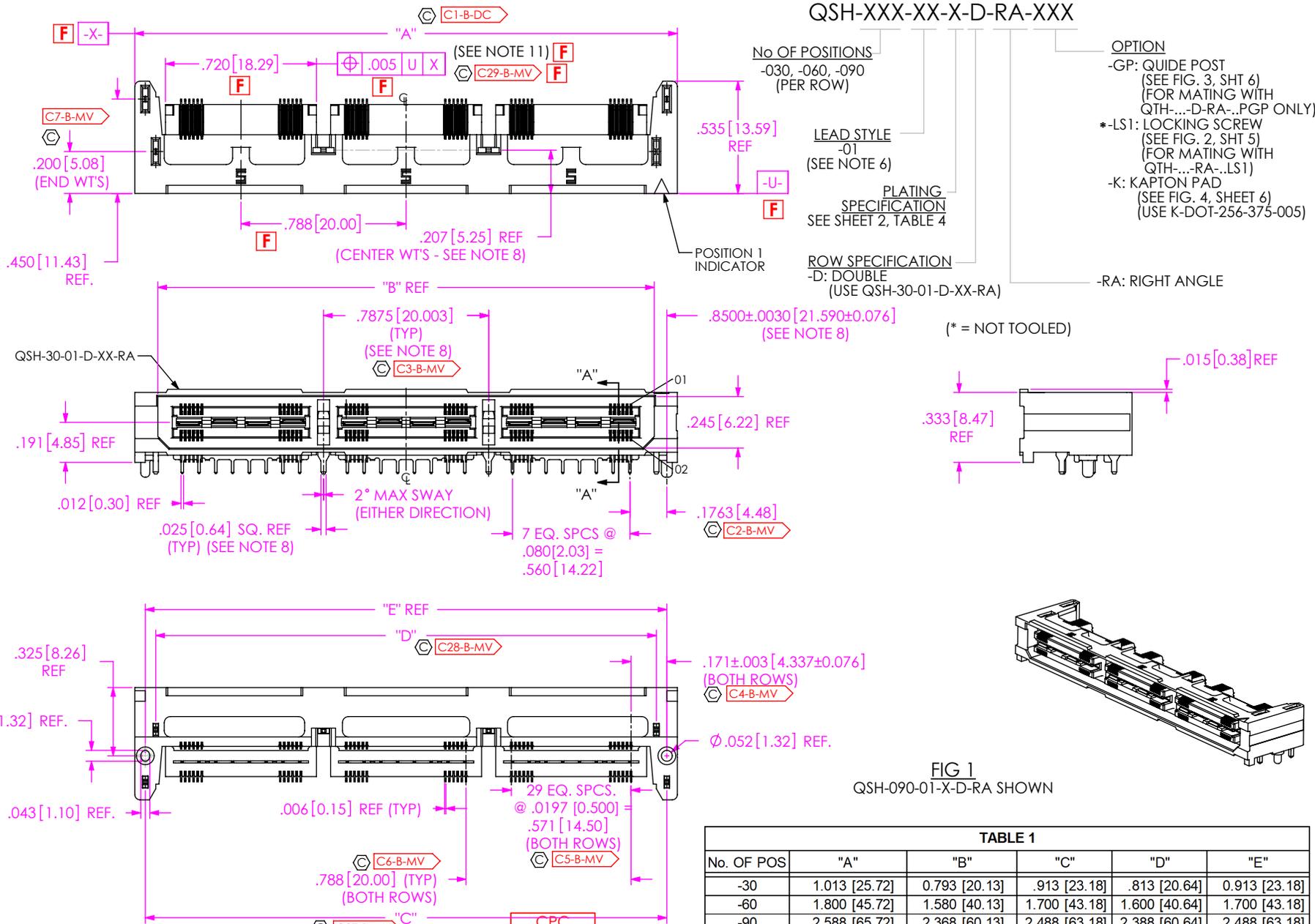


DO NOT SCALE FROM THIS PRINT

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)
(FOR MATING WITH
QTH-...-D-RA-...PGP ONLY)
- *-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)

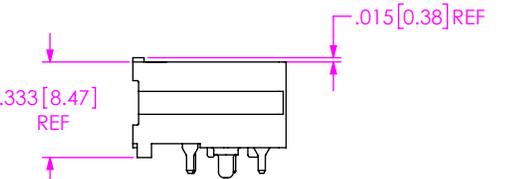


FIG 1
QSH-090-01-X-D-RA SHOWN

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:
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.
 11. ESTABLISH DATUM -X- 0.1 FROM DATUM -U-.

CPC FREQUENCY THIS SHEET	
A	
B	C1-C7, C27, C28, C29
C	
D	

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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MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 2:1

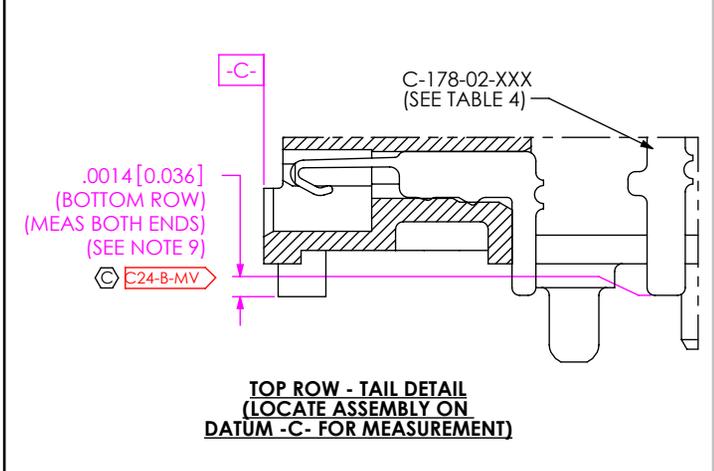
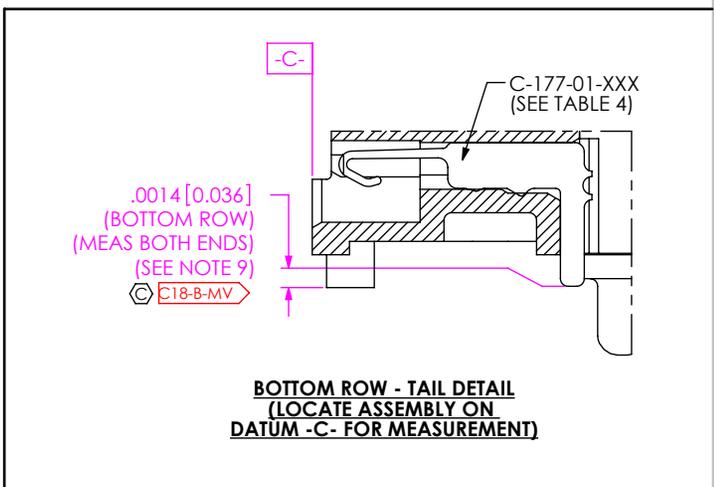
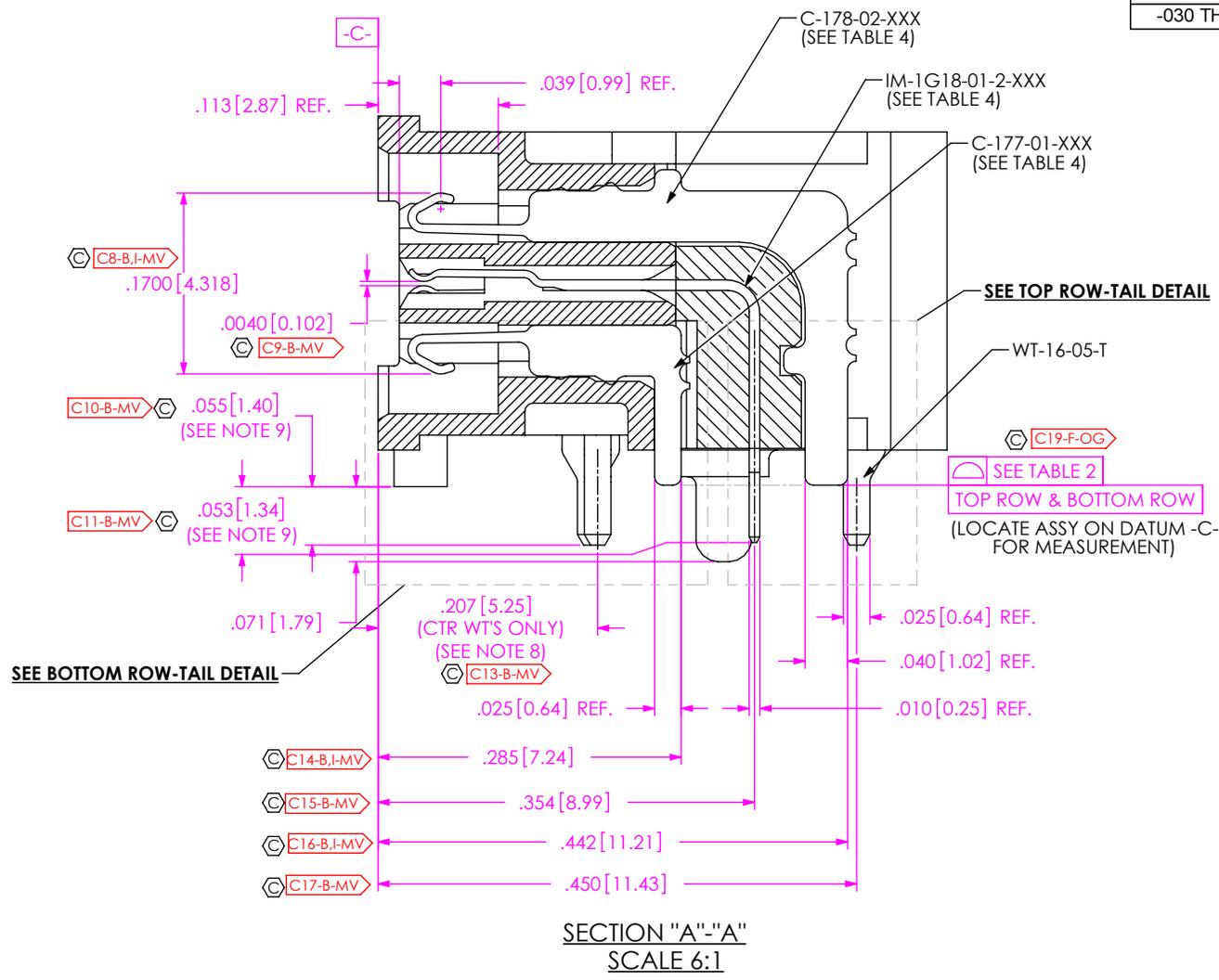
INSULATOR: LCP UL94V-0, COLOR BLACK
TERMINAL, GROUND PLANE & WELD TAB: PHOS BRONZE

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]



SEE BOTTOM ROW-TAIL DETAIL

SEE TABLE 2
TOP ROW & BOTTOM ROW
(LOCATE ASSY ON DATUM -C-
FOR MEASUREMENT)

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

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

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

CPC FREQUENCY THIS SHEET	
A	
B	C8-C18, C24
C	
D	

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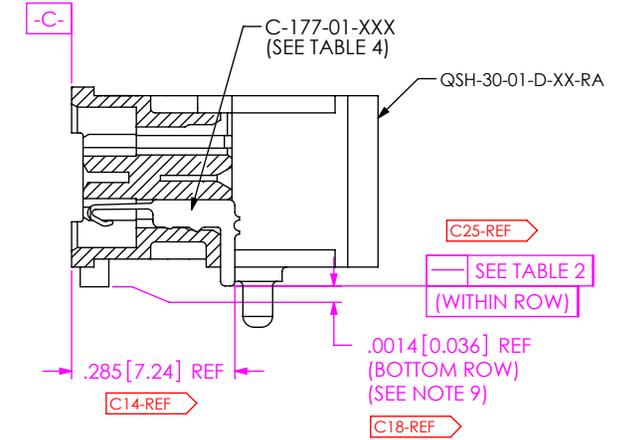
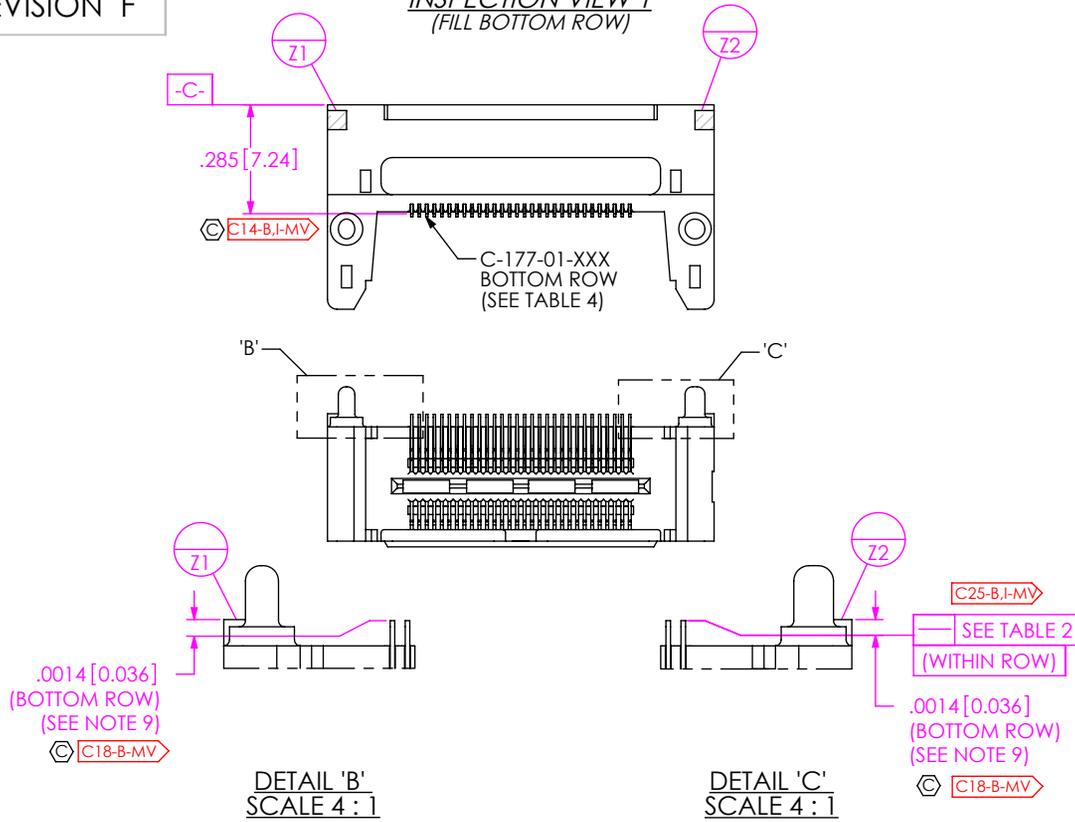
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DESCRIPTION:
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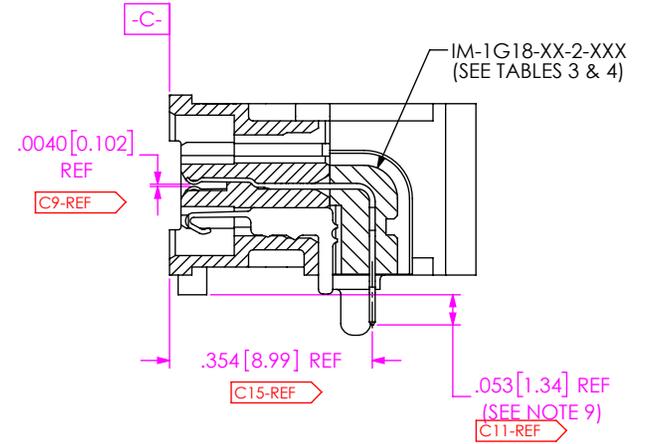
DWG. NO.
QSH-XXX-XX-X-D-RA-XXX

BY: DUKES Z 01/31/2010 SHEET 2 OF 6

INSPECTION VIEW 1
(FILL BOTTOM ROW)

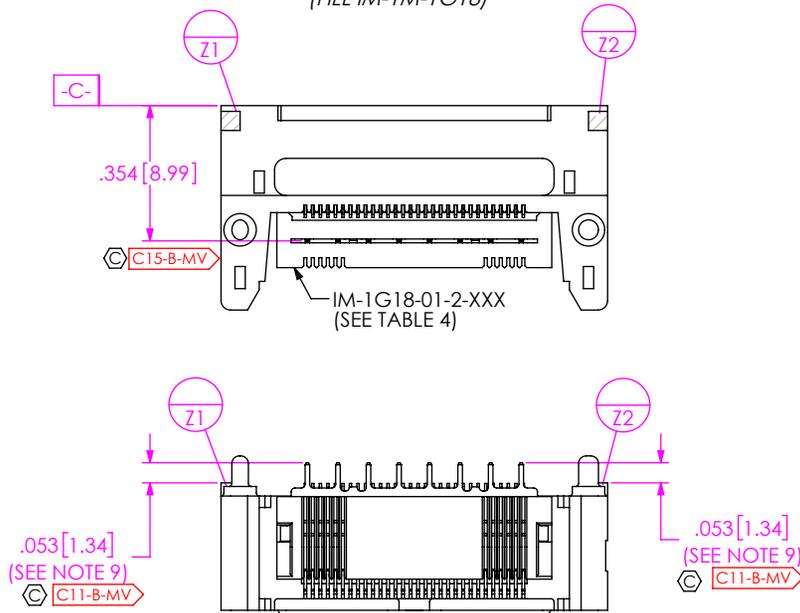


IN-PROCESS 1
(FILL BOTTOM ROW)
(SEE INSPECTION VIEW 1 FOR ORIENTATION AND CPC'S)



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

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



CPC FREQUENCY THIS SHEET	
A	
B	C11, C14, C15, C18, C25
C	
D	

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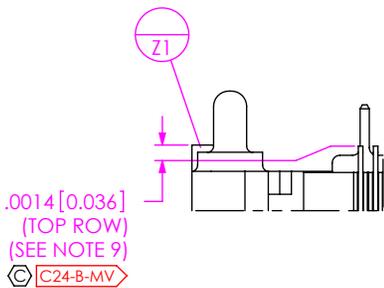
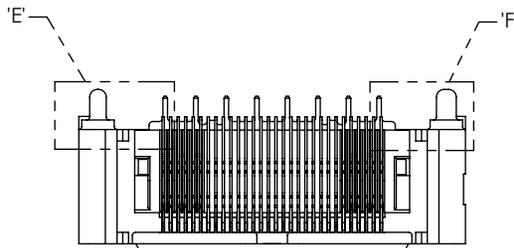
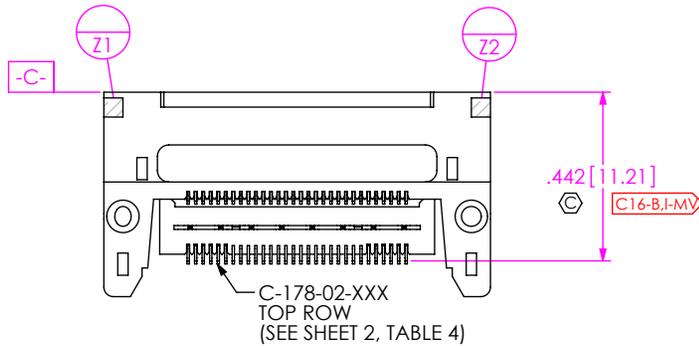
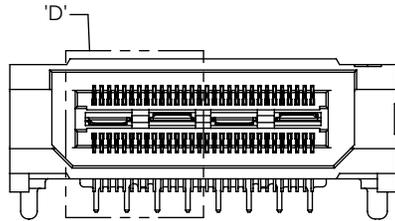
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DESCRIPTION:
.50mm DOUBLE ROW RIGHT ANGLE SOCKET STRIP

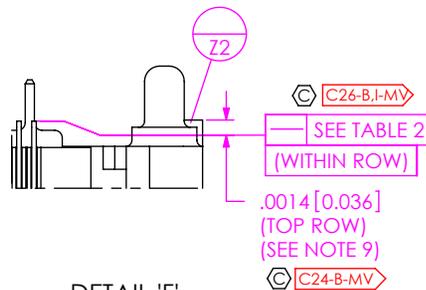
DWG. NO.
QSH-XXX-XX-X-D-RA-XXX

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

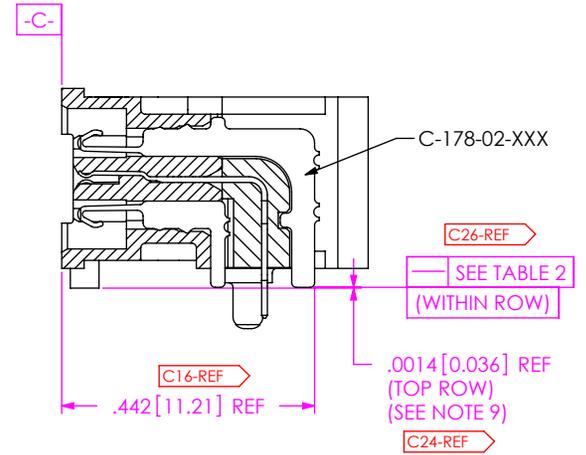
INSPECTION VIEW 3
(FILL TOP ROW)



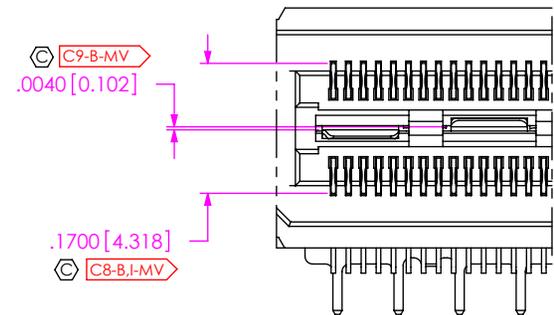
DETAIL 'E'
SCALE 4 : 1



DETAIL 'F'
SCALE 4 : 1



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



DETAIL 'D'
SCALE 4 : 1

CPC FREQUENCY THIS SHEET	
A	
B	C8, C9, C16, C24, C26
C	
D	

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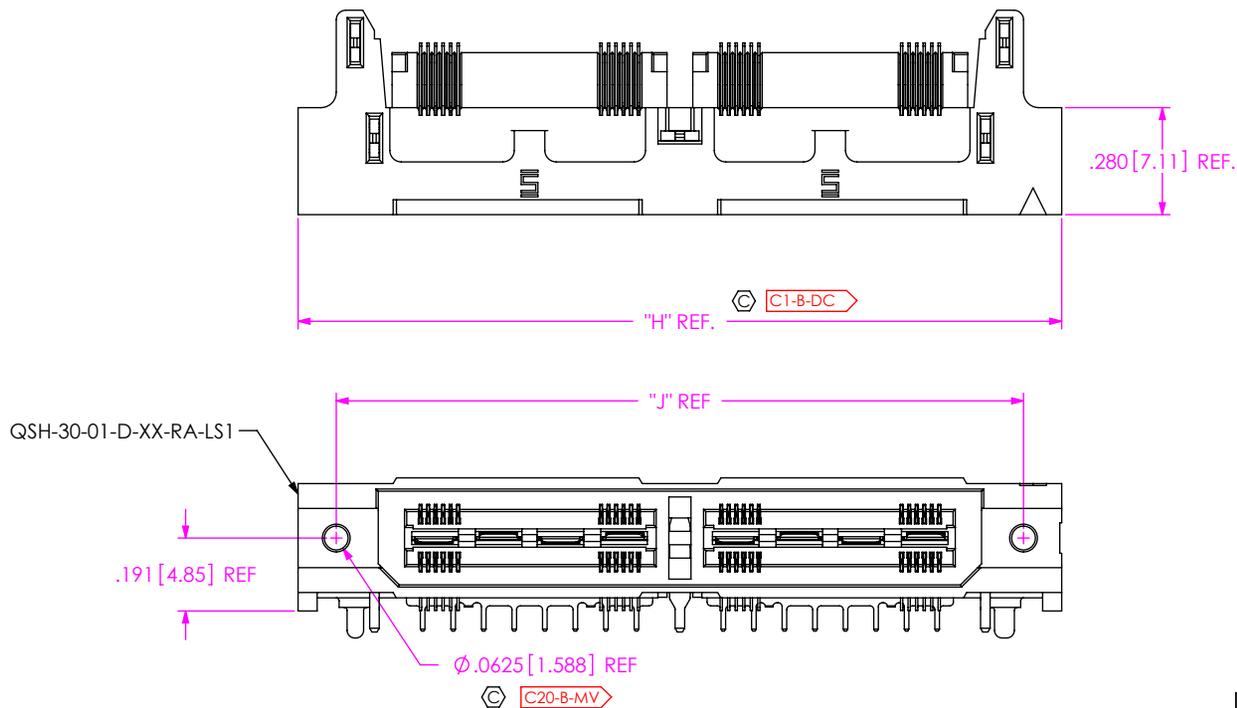


FIG 2
QSH-060-01-X-D-RA-LS1 SHOWN
(SAME AS FIG. 1, EXCEPT AS SHOWN)
(NOT TOOLED)

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]

CRITICAL DIMENSION INSPECTION INSTRUCTION TABLE

ASSEMBLY OPERATION	IN-PROCESS INSPECTION
FILL C-177-01-XXX	C1, C4, C5, C6, C14, C18, C25
FILL IM-1G18-01-2-XXX	C2, C9, C11, C15, C29
FILL C-178-02-XXX	C4, C5, C6, C8, C16, C24, C26
FILL WT-16-XXX-T	C3, C7, C10, C13, C17, C27, C28
APPLY K-DOT	C22, C23
FINAL ASSEMBLY	C1, C4, C5, C6, C8, C9

F

CPC FREQUENCY THIS SHEET	
A	
B	C1, C20
C	
D	

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

BY: DUKES Z 01/31/2010 SHEET 5 OF 6

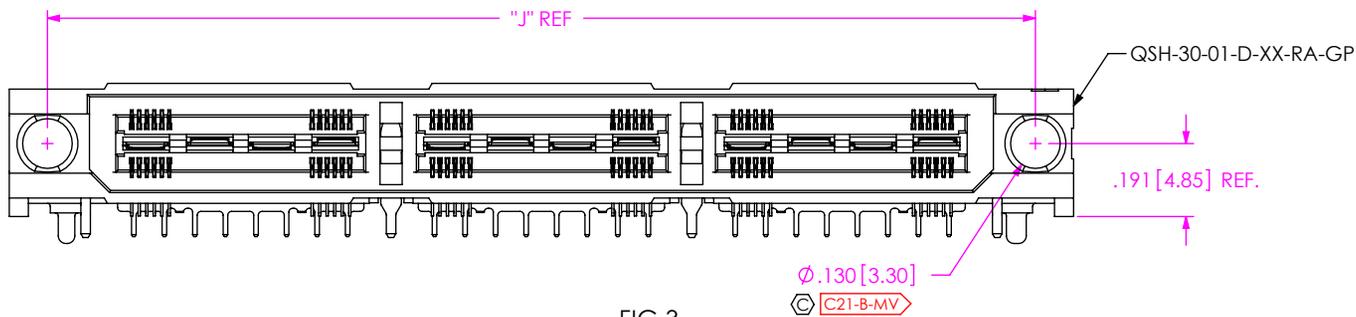
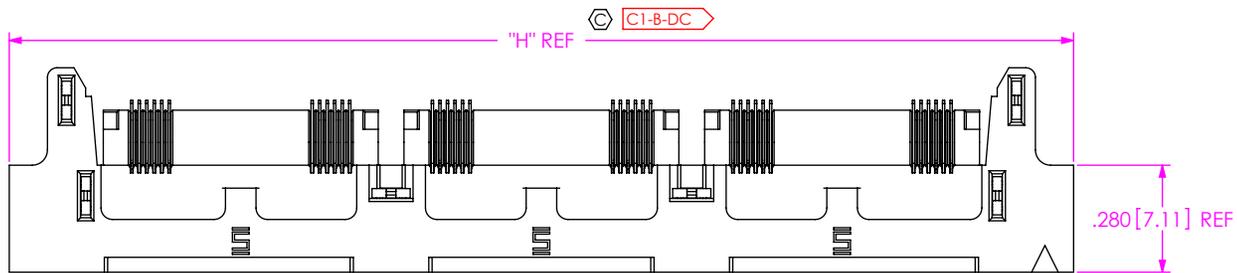


FIG 3
QSH-090-01-X-D-RA-GP SHOWN
(SAME AS FIG. 1, EXCEPT AS SHOWN)

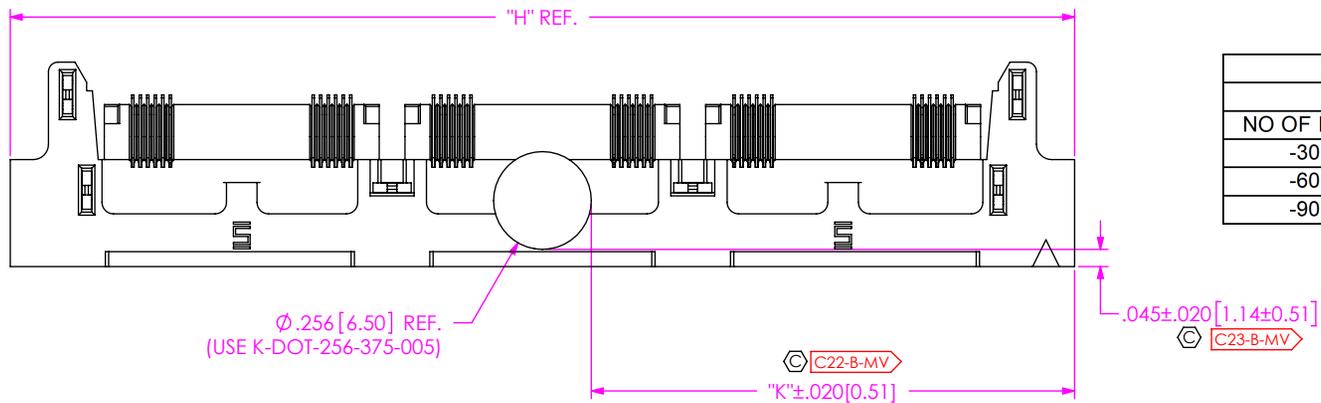


TABLE 6				
NO OF POS	"K"			
	-GP		NON -GP	
-30	.478	[12.14]	.378	[9.60]
-60	.872	[22.15]	.772	[19.61]
-90	1.266	[32.16]	1.166	[29.62]

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

CPC FREQUENCY THIS SHEET	
A	
B	C1, C21, C22, C23
C	
D	

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

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