

NOTES:

1. Ⓢ REPRESENTS A CRITICAL DIMENSION.
2. MINIMUM CONTACT PUSHOUT FORCE: 0.5 LB.
3. MAXIMUM ALLOWABLE BOW .003[0.08] IN/IN AFTER ASSEMBLY.
4. FOR A 1 POSITION SINGLE ROW ALL SPACERS ARE TO BE LBS-S.
5. SPACERS SHALL BE ASSEMBLED AS SHOWN WITH SNAP GROOVES AWAY FROM SSW BODY.
6. SINGLE ROW, 33 POS PART TO USE 31 POS AND 2 POS SPACERS.
7. MAXIMUM CUT FLASH: .015.

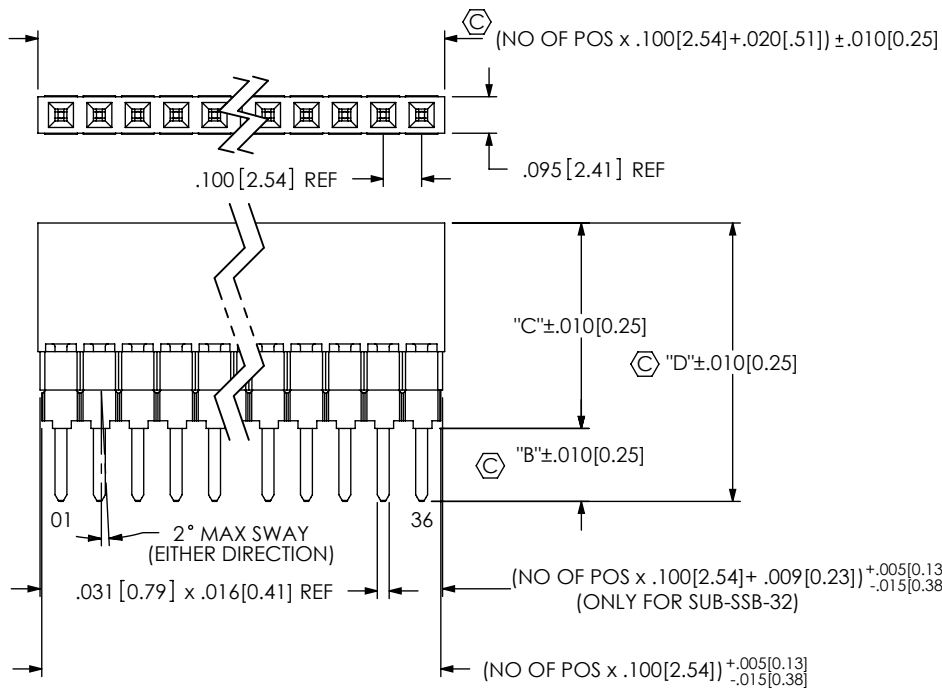
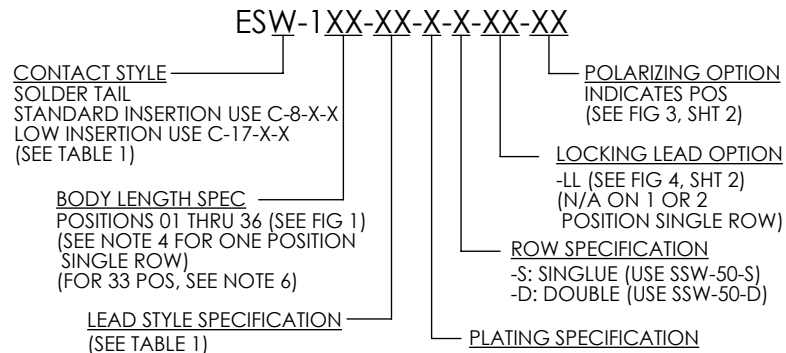


FIG 1
ESW-1XX-XX-X-S SHOWN

STANDARD INSERTION FORCE	CONTACT	SPACER SPECIFICATION (SEE NOTE 4)		"B"	"C"	"D"	"E"
		ESW-S	ESW-D				
-12	C-8-2-X			.090 [2.29]	.435 [11.05]	.525 [13.34]	.100 [2.54]
-13	C-8-3-X			.290 [7.37]	.435 [11.05]	.725 [18.42]	N/A
-14	C-8-5-X			.480 [12.19]	.435 [11.05]	.915 [23.24]	N/A
-23	C-8-3-X	(1) SUB-SSB-32	(1) DSB-XX	.190 [4.83]	.535 [13.59]	.725 [18.42]	N/A
-24	C-8-5-X	(1) SUB-SSB-32	(1) DSB-XX	.380 [9.65]	.535 [13.59]	.915 [23.24]	N/A
-33	C-8-3-X	(2) SUB-SSB-32	(2) DSB-XX	.090 [2.29]	.635 [16.13]	.725 [18.42]	N/A
-34	C-8-5-X	(2) SUB-SSB-32	(2) DSB-XX	.280 [7.11]	.635 [16.13]	.915 [23.24]	N/A
-44	C-8-5-X	(1) ESS-XX-S	(3) DSB-XX	.180 [4.57]	.735 [18.67]	.915 [23.24]	N/A
LOW INSERTION FORCE							
-37	C-17-2-X			.090 [2.29]	.435 [11.05]	.525 [13.34]	.100 [2.54]
-38	C-17-3-X			.290 [7.37]	.435 [11.05]	.725 [18.42]	N/A
-39	C-17-5-X			.480 [12.19]	.435 [11.05]	.915 [23.24]	N/A
-48	C-17-3-X	(1) SUB-SSB-32	(1) DSB-XX	.190 [4.83]	.535 [13.59]	.725 [18.42]	N/A
-49	C-17-5-X	(1) SUB-SSB-32	(1) DSB-XX	.380 [9.65]	.535 [13.59]	.915 [23.24]	N/A
-58	C-17-3-X	(2) SUB-SSB-32	(2) DSB-XX	.090 [2.29]	.635 [16.13]	.725 [18.42]	N/A
-59	C-17-5-X	(2) SUB-SSB-32	(2) DSB-XX	.280 [7.11]	.635 [16.13]	.915 [23.24]	N/A
-69	C-17-5-X	(1) ESS-XX-S	(3) DSB-XX	.180 [4.57]	.735 [18.67]	.915 [23.24]	N/A



- G: 20μ" SELECTIVE GOLD IN CONTACT AREA, 3μ" SELECTIVE GOLD ON TAIL.
- T: MATTE TIN ON ENTIRE PIN.
- (STANDARD INSERTION FORCE ONLY)
- S: 30μ" SELECTIVE GOLD IN CONTACT AREA, MATTE TIN ON TAIL.
- H: 30μ" SELECTIVE GOLD IN CONTACT AREA, 3μ" SELECTIVE GOLD ON TAIL.
- F: 3μ" SELECTIVE GOLD IN CONTACT AREA, MATTE TIN ON TAIL.
- E: 50μ" SELECTIVE GOLD IN CONTACT AREA, 3μ" SELECTIVE GOLD ON TAIL.
- L: 10μ" SELECTIVE GOLD IN CONTACT AREA, MATTE TIN ON TAIL.

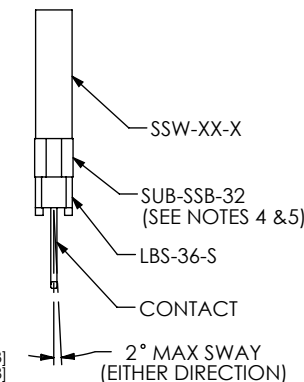
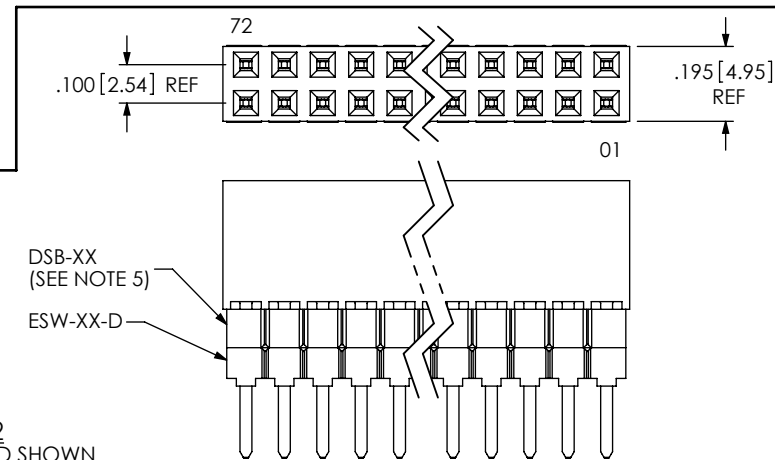


FIG 2
ESW-1XX-XX-X-D SHOWN



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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520 PARK EAST BLVD, NEW ALBANY, IN 47150
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e-Mail: info@SAMTEC.com code 55322

MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 2:1
SSW: LCP, UL 94 VO, COLOR: BLACK
SSB, ESS, DSB: PBT, UL 94 VO, COLOR: BLACK
LBS: HTN, UL 94 VO, COLOR: BLACK
CONTACT: PHOS BRONZE

DESCRIPTION: ESW STRIP ASM.
DWG. NO. ESW-1XX-XX-X-X-XX-XX
BY: JORDAN 07/16/1985 SHEET 1 OF 2

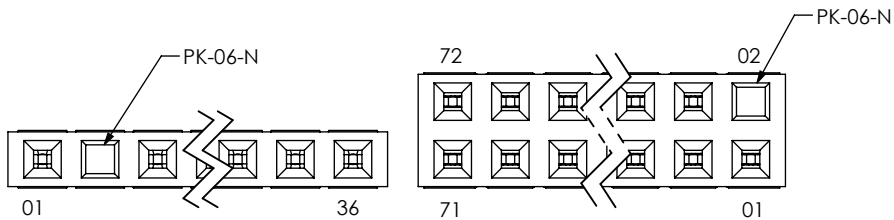


FIG 3
POLARIZATION LOCATION
INSERT PK-06-N INTO SPECIFIED POS AND BREAK OFF TAB
(ESW-1XX-XX-X-X-02 SHOWN)
(SAME AS FIG 1, DIFFERENT AS SHOWN)

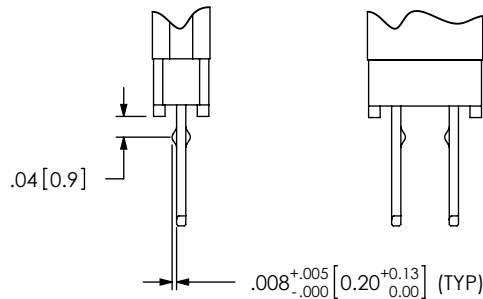


FIG 4
LOCKING LEAD OPTION
LOCATED ON OR ABOUT THE CENTERLINE
(N/A IN 1 OR 2 POSITION SINGLE ROW)

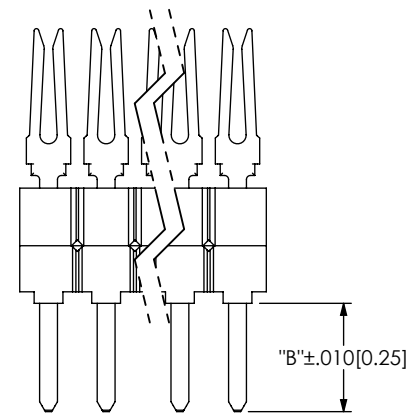


FIG 5
IN PROCESS 'A'
(LEAD STYLES -13, -14, -23, -24, -33, -34, -44, -38, -39, -48, -49, -58, -59, -69)

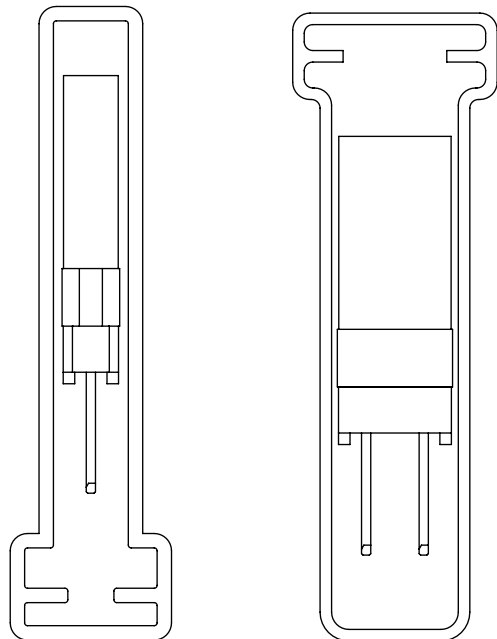
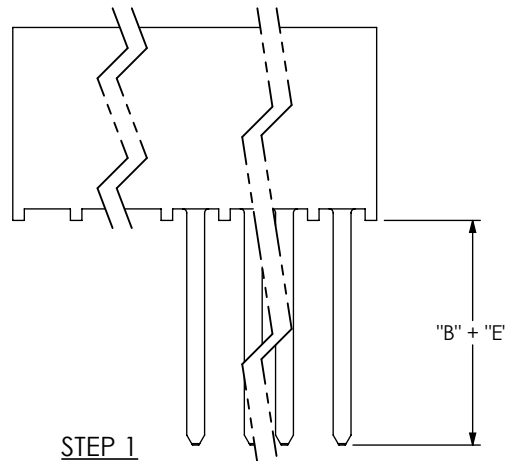


FIG 7
TUBE VIEWS

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



STEP 1
STEPS:
1. MACHINE FILL SSW-50-D TO 36 POS.
2. MOUNT ESW-36-D.
3. ROTO CUT TO POS. (SEE FIG 1)

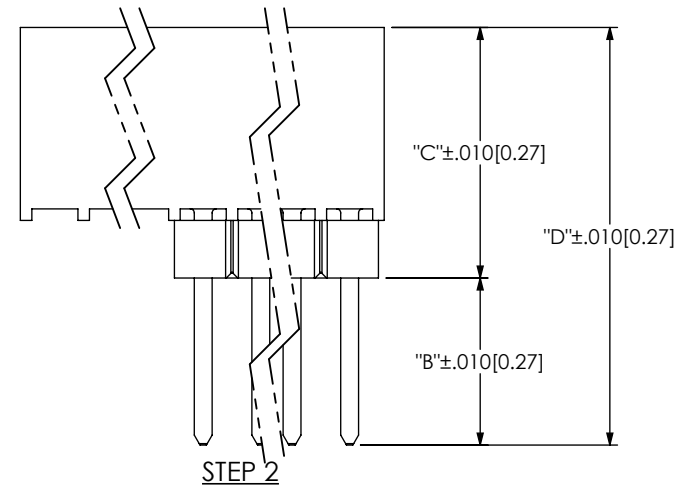


FIG 6
IN PROCESS 'B'
(LEAD STYLES -12 & -37)

TABLE 2			
LEAD STYLE	ROW	TUBE	PLUG
-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-09
-12, -37		PT-1-24-03-44	TP-07
-13, -14, -23, -24, -33, -34, -44, -38, -39, -48, -49, -58, -59, -69	-D	PT-1-24-02-47	TP-03

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DO NOT SCALE DRAWING

SHEET SCALE: 3:1



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DESCRIPTION:
ESW STRIP ASM.

DWG. NO. ESW-1XX-XX-X-X-XX-XX

BY: JORDAN 07/16/1985 SHEET 2 OF 2