

REVISION BC

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.

DO NOT SCALE FROM THIS PRINT

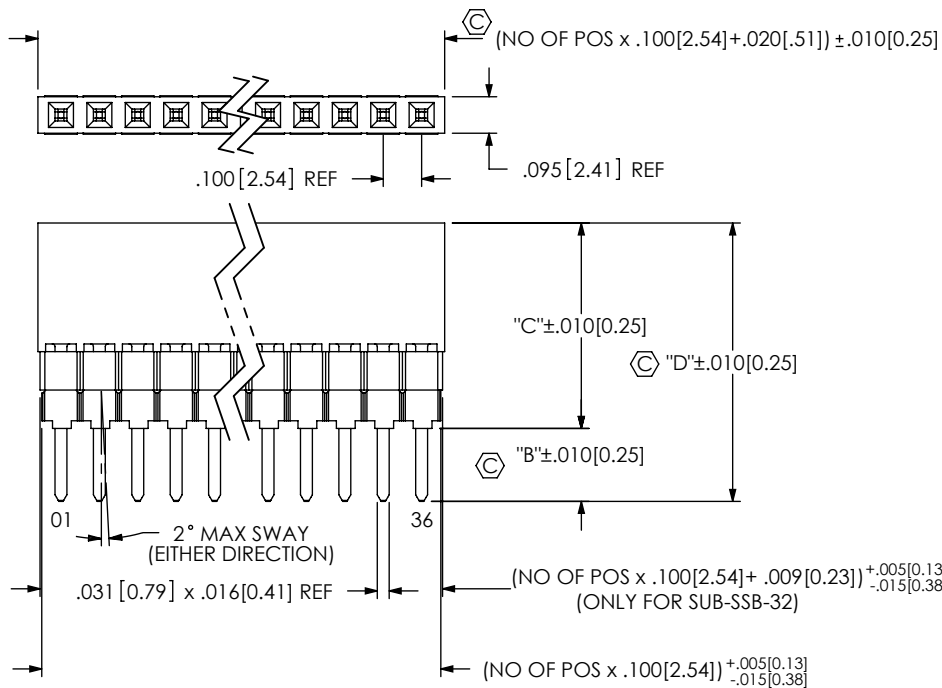
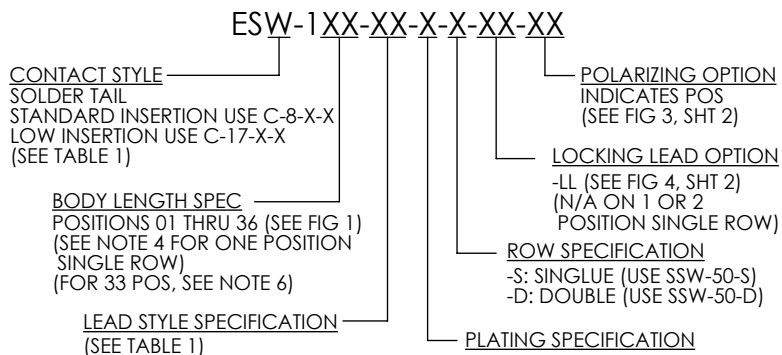


FIG 1  
ESW-1XX-XX-X-S SHOWN

| 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.

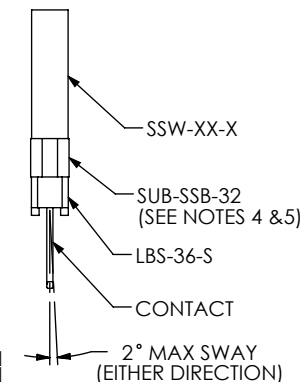


FIG 2  
ESW-1XX-XX-X-D SHOWN

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE:  
DECIMALS ANGLES  
.XX: ±.01 [.3] 2°  
.XXX: ±.005 [.13]  
.XXXX: ±.0020 [.051]

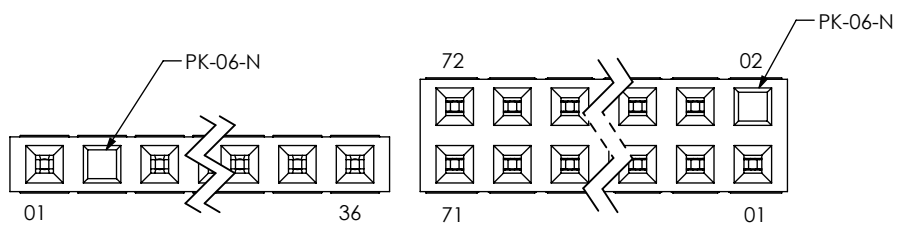
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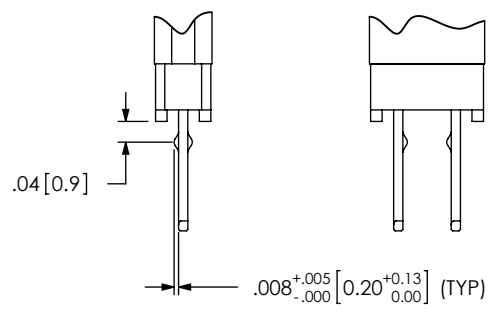
520 PARK EAST BLVD, NEW ALBANY, IN 47150  
PHONE: 812-944-6733 FAX: 812-948-5047  
e-Mail: info@SAMTEC.com code 55322

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

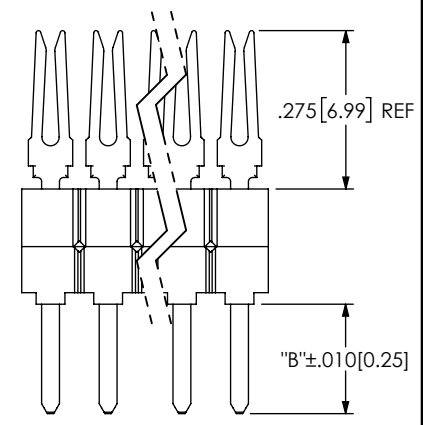
DESCRIPTION: ESW STRIP ASM.  
DWG. NO. ESW-1XX-XX-X-X-XX-XX  
BY: JORDAN 07/16/1985 SHEET 1 OF 2



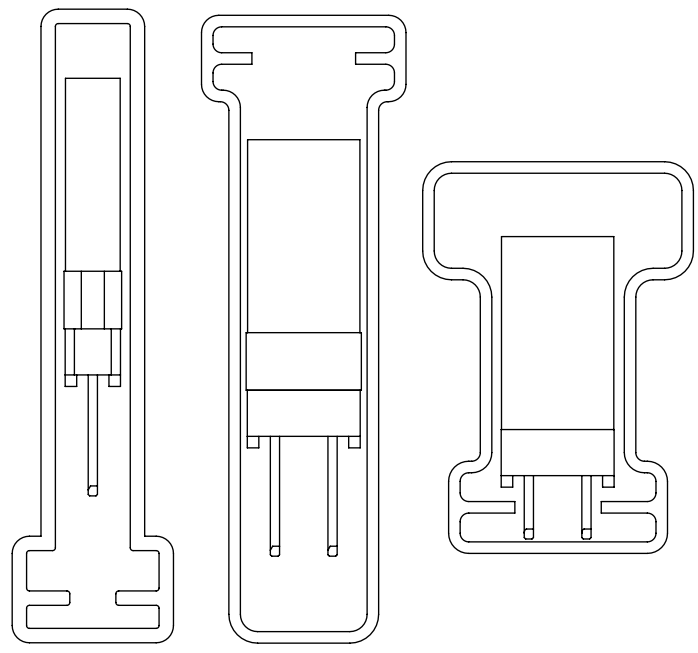
**FIG 3**  
POLARIZATION LOCATION  
INSERT PK-06-N INTO SPECIFIED POS AND BREAK OFF TAB  
(ESW-1XX-XX-X-X-02 SHOWN)  
(SAME AS FIG 1, DIFFERENT AS SHOWN)



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

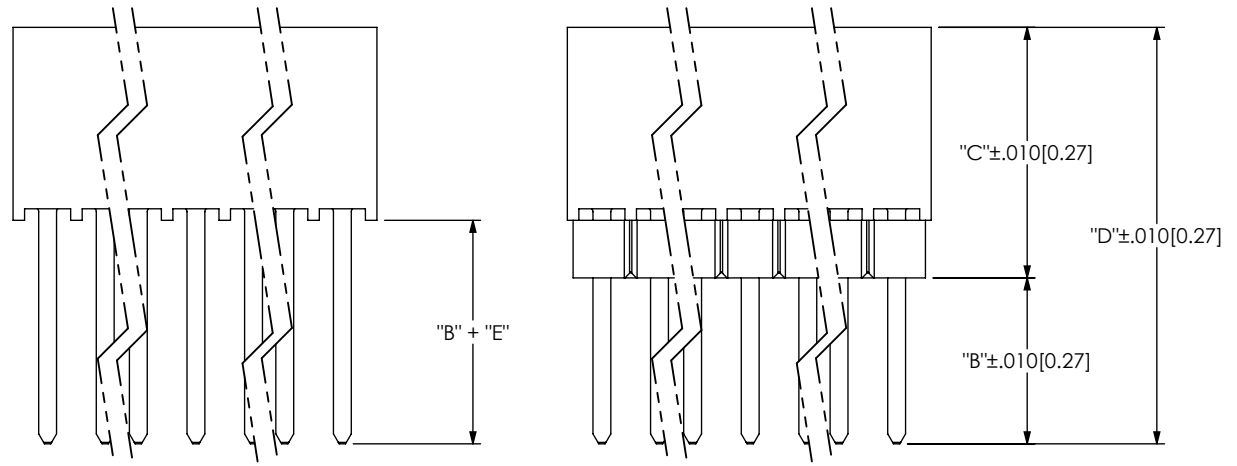


**FIG 5**  
IN PROCESS 'A'  
(LEAD STYLES -13, -14, -23, -24, -33, -34, -44, -38, -39, -48, -49, -58, -59, -69)



**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.



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

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

| 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



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