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NOTES:
1. MINIMUM CONTACT PUSHOUT: 1.5 LBS.
2. FOR A 1 POSITION SINGLE ROW ALL SPACERS ARE TO BE TSW-XX-S.
3. NOTE DELETED.
4. MAXIMUM ALLOWABLE BOW .003[0.08] INCH/INCH AFTER ASSMBLY
5. DO NOT USE DSB SPACER BODY FOR THIS OPTION.
6. MAXIMUM CUT FLASH : .010[0.25]; MAXIMUM CUT FLASH ON TAIL SIDE: .020[0.51] NOT TO EXTEND BELOW STANDOFFS.
7. ORDERS WILL BE PACKAGED ACCORDING TO THE SAMTEC PACKAGING EFFICIENCY STANDARDS (SPES) FOUND ON WWW.SAMTEC.COM

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

*SEE NOTE 6

CONTACT STYLE
SQUARE TAIL: USE C-15-X-X
LOW INSERTION FORCE: C-60-X-X
(SEE TABLE 1, SHT 2)

NO. OF POSITIONS
POSITIONS 01 THRU 36
(SEE FIG1)
FOR A ONE POSITION
SINGLE ROW SEE NOTE 2

LEAD STYLE
(SEE TABLE 1, SHT 2)

PLATING SPECIFICATION
-G: 20µ" GOLD IN CONTACT AREA, 3µ" GOLD TAIL
-T: MATTE TIN CONTACT AND TAIL
-S: 30µ" SELECTIVE GOLD IN CONTACT AREA, MATTE TIN TAIL
-H: 30µ" HEAVY GOLD IN CONTACT AREA, 3µ" GOLD TAIL
-L: 10µ" SELECTIVE LIGHT GOLD IN CONTACT AREA, MATTE TIN TAIL

METAL WASHER OPTION
#* -H-MW: (SEE FIG 3, SHT 2)
(N/A ON TRIPLE ROW)
(.300 [7.62] MAX TAIL)
(AVAILABLE ON POS
-02 THRU -32 ONLY)

LOCKING LEAD OPTION
-LL (SEE FIG 2, SHT 2)
[N/A ON 1 OR 2 POSITION
SINGLE ROW]

POLARIZATION OPTION
INDICATES POSITION (SEE FIG 4, SHT 2)

ROW SPECIFICATION (SEE TABLE 1, SHT 2)
-S: SINGLE (USE SSW-50-S)
-D: DOUBLE (USE SSW-50-D)
-T: TRIPLE (USE SSW-50-T)

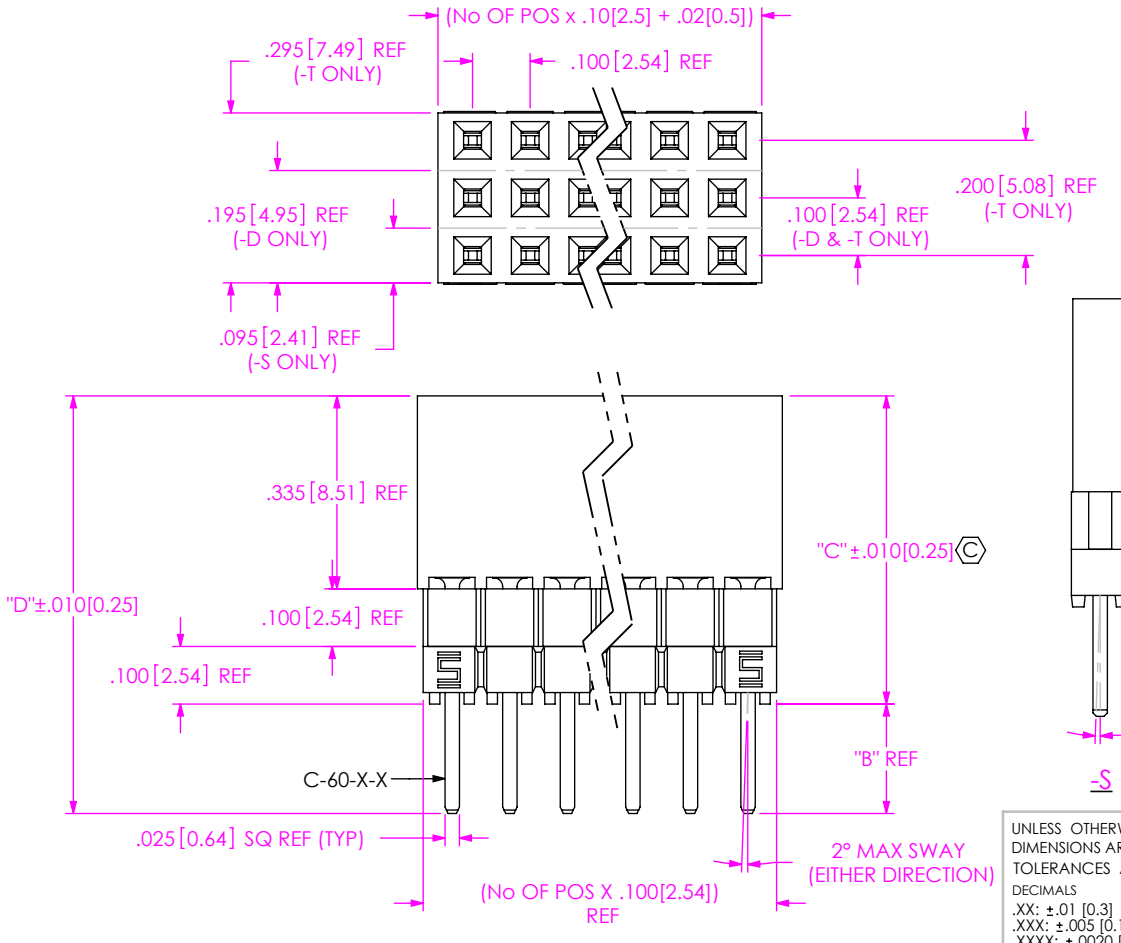
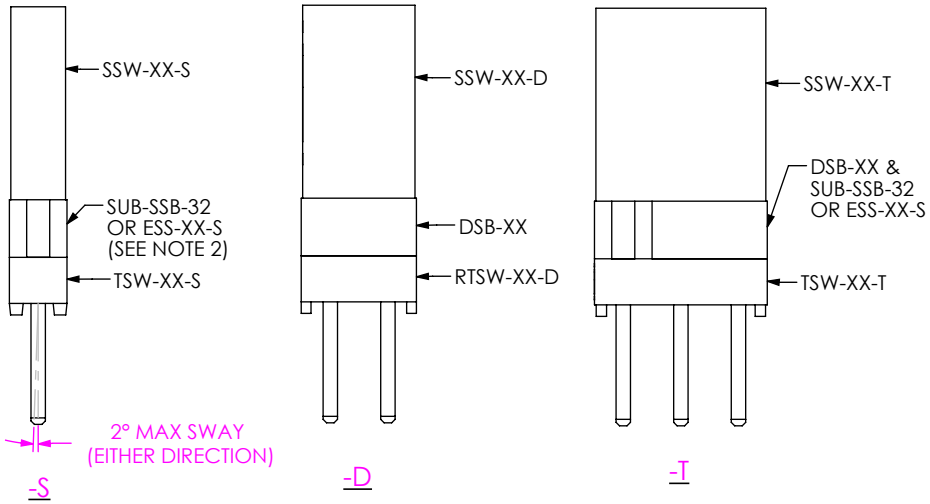


FIG 1
ESQ-110-XX-X-T

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



UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES.
TOLERANCES ARE:
DECIMALS ANGLES
.XX: ±.01 [0.3] 2°
.XXX: ±.005 [0.13]
.XXXX: ±.0020 [0.051]

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e-Mail info@SAMTEC.com code 55322

MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 3:1
INSULATOR: LCP, UL 94 V0
COLOR: BLACK
CONTACT : PHOS BRONZE

DESCRIPTION: ESQ STRIP ASM

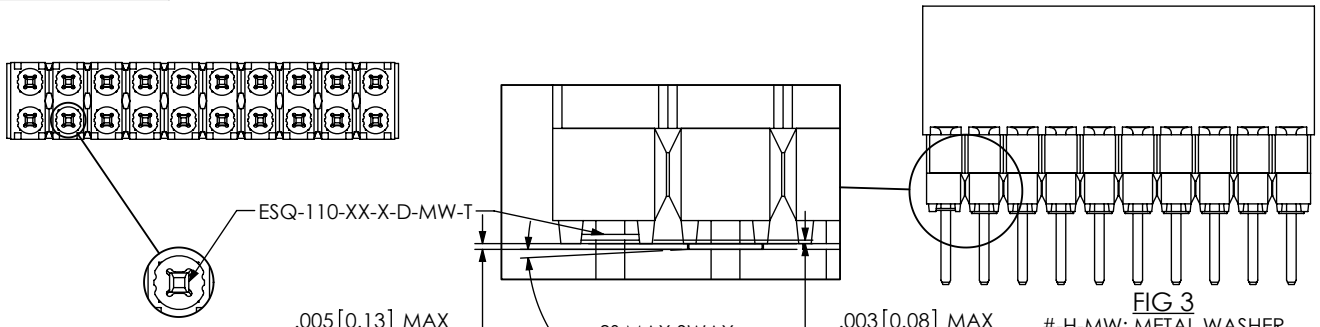
DWG. NO. ESQ-1XX-XX-X-X-XXX-XX-X-XX

BY: JORDAN 7-16-85 SHEET 1 OF 4

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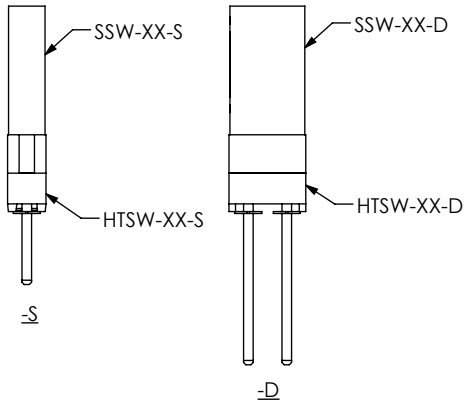
#-MW OPTION, DO NOT DESIGN IN. SAMTEC WILL ONLY SUPPORT EXISTING BUSINESS 2/12/02



DETAIL A
SCALE 4 : 1

DETAIL B
SCALE 6 : 1

FIG 3
#-H-MW: METAL WASHER
ESQ-110-XX-X-X-MWT
(ONE PER POSITION)
(-S & -D BODY SPECS ONLY)
(SEE NOTE 5)
(SAME AS FIG 1 UNLESS OTHERWISE NOTED)



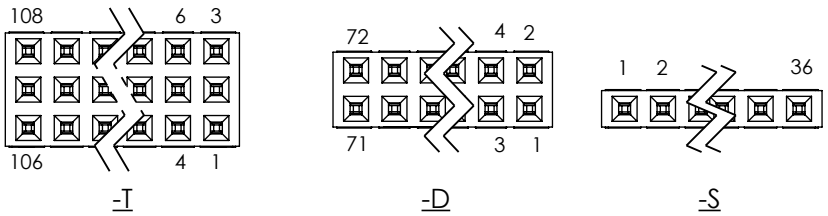


FIG 4
XXX: POLARIZATION LOCATION
INSERT PK-06-N INTO SPECIFIED POS
AND BREAK OFF TAB

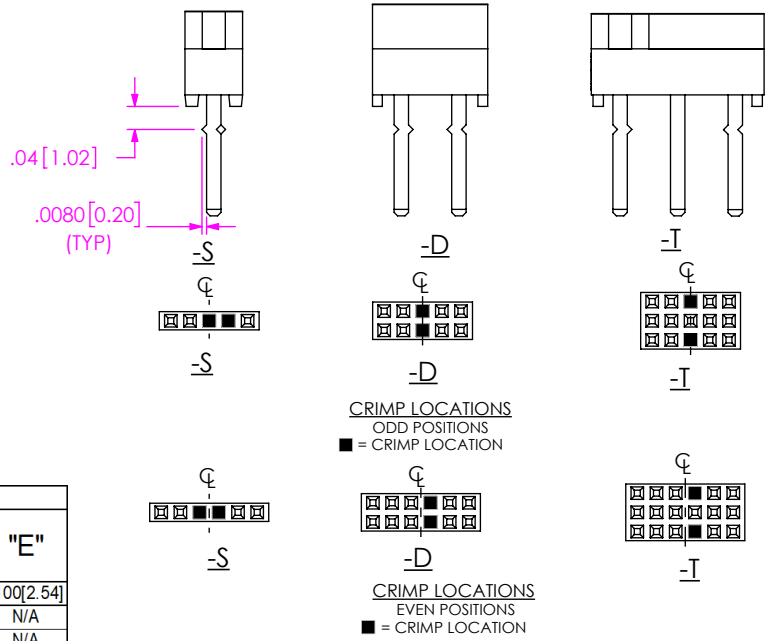


FIG 2
-LL: LOCKING LEAD OPTION
LOCATED ON OR ABOUT CENTERLINE
[N/A IN 1 OR 2 POSITION SINGLE ROW]

TABLE 1

STANDARD INSERTION FORCE	CONTACT	SPACER SPECIFICATION (FOR A ONE POSITION SINGLE SEE NOTE 2) ESQ-S	ESQ-D	ESQ-T	"B" (SEE TABLE 3)	"C"	"D"	"E"
-12	C-15-2-X	N/A	N/A	N/A	.09[2.29]	.435[11.05]	.525[13.33]	.100[2.54]
-13	C-15-3-X	N/A	N/A	N/A	.29[7.37]	.435[11.05]	.725[18.41]	N/A
-14	C-15-4-X	N/A	N/A	N/A	.48[12.2]	.435[11.05]	.915[23.24]	N/A
-23	C-15-3-X	(1) SUB-SSB-32	(1) DSB-XX	(1) SUB-SSB-32 (1) DSB-XX	.19[4.83]	.535[13.59]	.725[18.41]	N/A
-24	C-15-4-X	(1) SUB-SSB-32	(1) DSB-XX	(1) SUB-SSB-32 (1) DSB-XX	.38[9.65]	.535[13.59]	.915[23.24]	N/A
-33	C-15-3-X	(2) SUB-SSB-32	(2) DSB-XX	(2) SUB-SSB-32 (2) DSB-XX	.09[2.87]	.635[16.13]	.725[18.41]	N/A
-34	C-15-4-X	(2) SUB-SSB-32	(2) DSB-XX	(2) SUB-SSB-32 (2) DSB-XX	.28[7.11]	.635[16.13]	.915[23.24]	N/A
-44	C-15-4-X	(1) ESS-XX-S	(3) DSB-XX	(1) ESS-XX-S (3) DSB-XX	.18[4.57]	.735[18.67]	.915[23.24]	N/A
LOW INSERTION FORCE	CONTACT	SPACER SPECIFICATION (FOR A ONE POSITION SINGLE SEE NOTE 2) ESQ-S	ESQ-D	ESQ-T	"B" (SEE TABLE 3)	"C"	"D"	"E"
-37	C-60-2-X	N/A	N/A	N/A	.09[2.87]	.435[11.05]	.525[13.33]	.100
-38	C-60-3-X	N/A	N/A	N/A	.29[7.37]	.435[11.05]	.725[18.41]	N/A
-39	C-60-4-X	N/A	N/A	N/A	.48[12.2]	.435[11.05]	.915[23.24]	N/A
-48	C-60-3-X	(1) SUB-SSB-32	(1) DSB-XX	(1) SUB-SSB-32 (1) DSB-XX	.19[4.83]	.535[13.59]	.725[18.41]	N/A
-49	C-60-4-X	(1) SUB-SSB-32	(1) DSB-XX	(1) SUB-SSB-32 (1) DSB-XX	.38[9.65]	.535[13.59]	.915[23.24]	N/A
-58	C-60-3-X	(2) SUB-SSB-32	(2) DSB-XX	(2) SUB-SSB-32 (2) DSB-XX	.09[2.87]	.635[16.13]	.725[18.41]	N/A
-59	C-60-4-X	(2) SUB-SSB-32	(2) DSB-XX	(2) SUB-SSB-32 (2) DSB-XX	.28[7.11]	.635[16.13]	.915[23.24]	N/A
-69	C-60-4-X	(1) ESS-XX-S	(3) DSB-XX	(1) ESS-XX-S (3) DSB-XX	.18[4.57]	.735[18.67]	.915[23.24]	N/A

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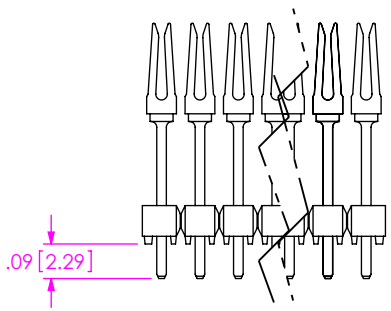
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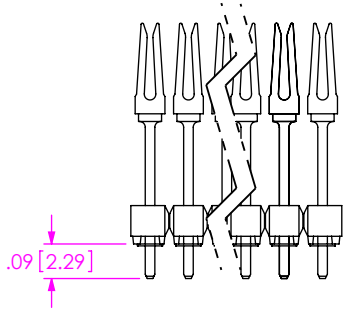
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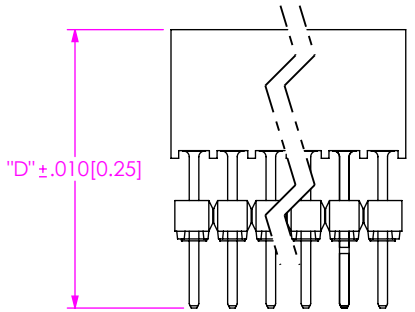
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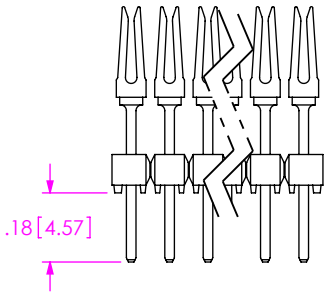


PRESS ON -MW

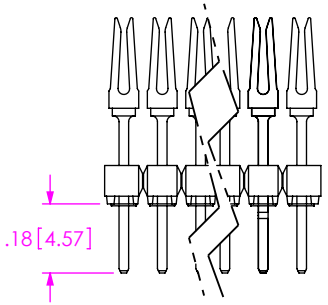


PRESS ON
SSW BODY

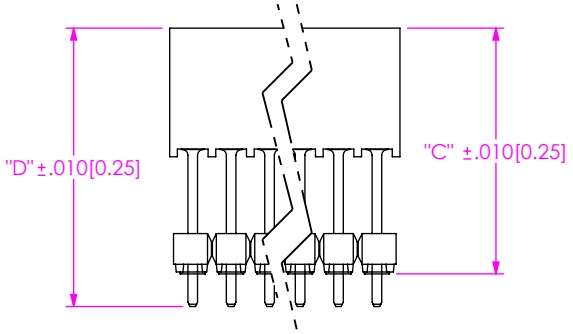
IN-PROCESS
-12, -33, -37, -58



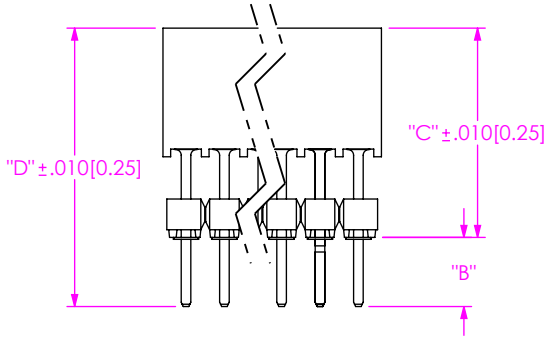
LOAD CONTACT



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

TABLE 3							
LEAD STYLE	"B" IN PROCESS FOR 1 POSITION SINGLE ROW (SEE NOTE 2)						
	FILL (1)	FILL (2)	REPRESS (1)	FILL (3)	REPRESS (2)	FILL (4)	REPRESS (3)
-23/-48	.290[7.37]	.150[3.81]	.190[4.83]	N/A	N/A	N/A	N/A
-24/-49	.480[12.19]	.340[8.64]	.380[9.65]	N/A	N/A	N/A	N/A
-33/-58	.290[7.37]	.150[3.81]	.190[4.83]	.050[1.27]	.090[2.29]	N/A	N/A
-34/-59	.480[12.19]	.340[8.64]	.380[9.65]	.240[6.10]	.280[7.11]	N/A	N/A
-44/-69	.480[12.19]	.340[8.64]	.380[9.65]	.240[6.10]	.280[7.11]	.140[3.56]	.180[4.57]

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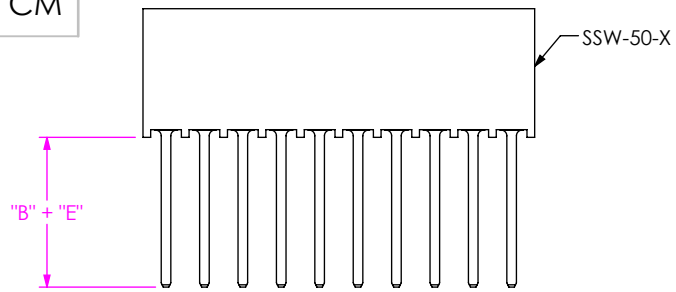
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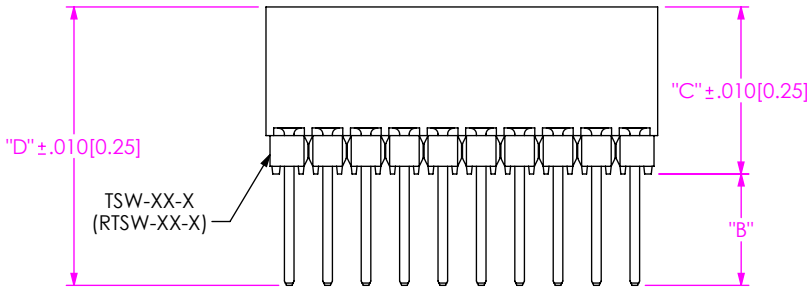
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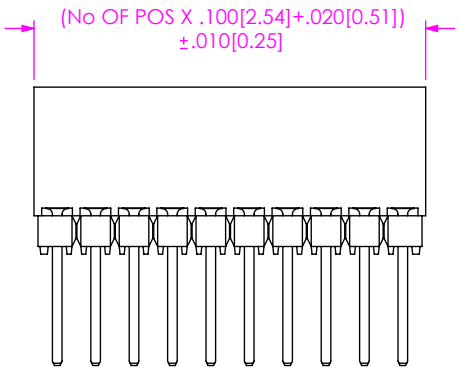
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STEP 1
MACHINE FILL SSW-50-X



STEP 2
MULTI-CUT TSW-50-X TO POS (RTSW-50-D FOR DOUBLE ROW)
AND MOUNT AS SHOWN.
(IF RTSW-50-D NOT AVAILABLE, TSW-50-D MAY BE USED)



STEP 3
ROTO CUT TO POS

FIG 5
ESQ-110-XX-X-S
IN PROCESS "B"
(LEAD STYLE -12 & -37)
(-S & -D ONLY)

TABLE 2			
LEAD STYLE	ROW	TUBE	PLUG (2)
-12, -13, -14, -37, -38, -39	-S	PT-ESQ002	TP-03
-23, -24, -48, -49		PT-ESQ001	TP-03
-33, -34, -44, -58, -59, -69		PT-1-24-01-47	TP-03
-12, -37	-D	PT-1-24-03-44	TP-07
-14, -24, -34, -44, -39, -49, -59, -69		PT-1-24-02-47	TP-26
-13, -23, -33, -38, -48, -58		PT-1-24-01-51	TP-13
-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 PAC KAGE -04 THRU -36 POSITION 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 -05 THRU -36 POSITIONS ONLY.

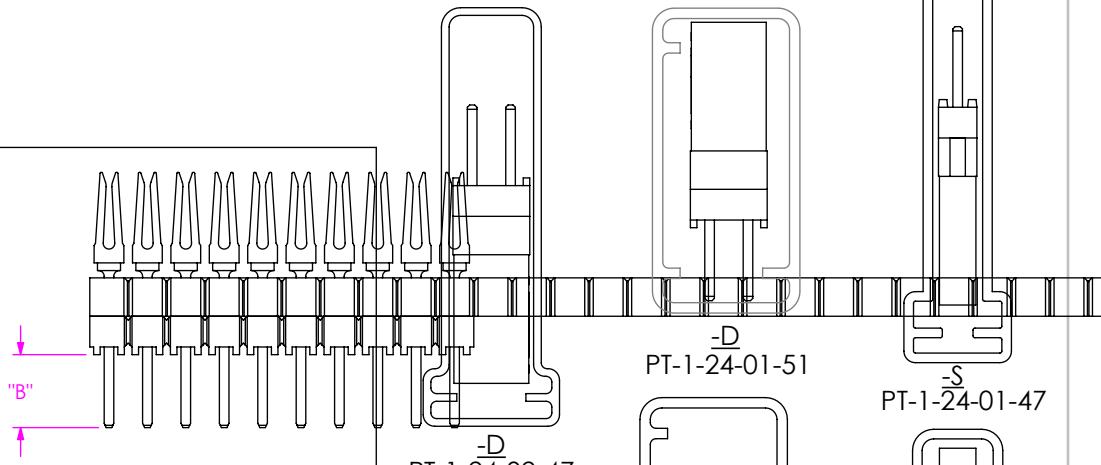
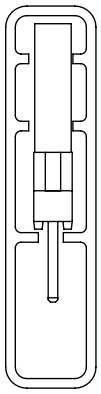
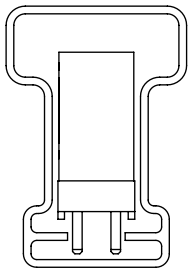


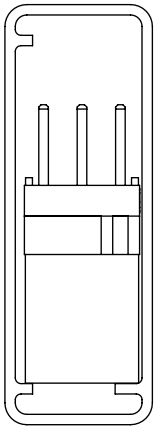
FIG 6
ESQ-110-XX-X-D
IN PROCESS "A"
(LEAD STYLE -12-T, -13, -14, -23, -24, -33, -34, -44, -37-T, -38, -48, -49, -58, -59, -69)



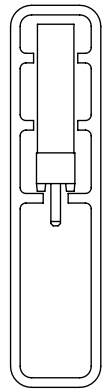
-S
PT-ESQ001



-D
PT-1-24-03-44



-T
PT-1-24-03-51



-S
PT-ESQ002

-D
PT-1-24-02-47

-D
PT-1-24-01-51

-S
PT-1-24-01-47

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BY: WHITTAKER 9-11-98

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