

DESIGNED & DIMENSIONED
IN MILLIMETERS [INCHES]

QRF8-XXX-XX-X-RA-GP-XX

DO NOT
SCALE FROM
THIS PRINT

No. OF POSITIONS
-026, -052, -078
(PER ROW)

SOLDER TAIL LEAD STYLE
-01: 1.57[.062] BOARD OR
2.36[.093] BOARD
(SEE NOTE 17)

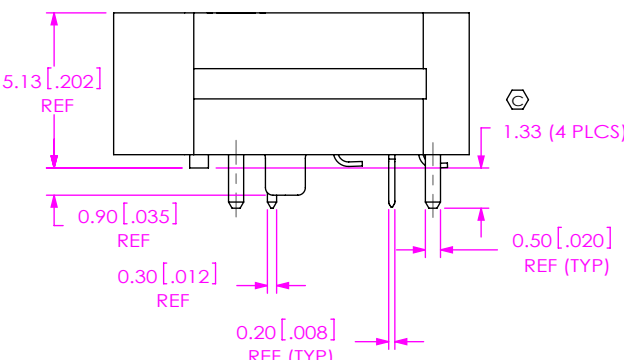
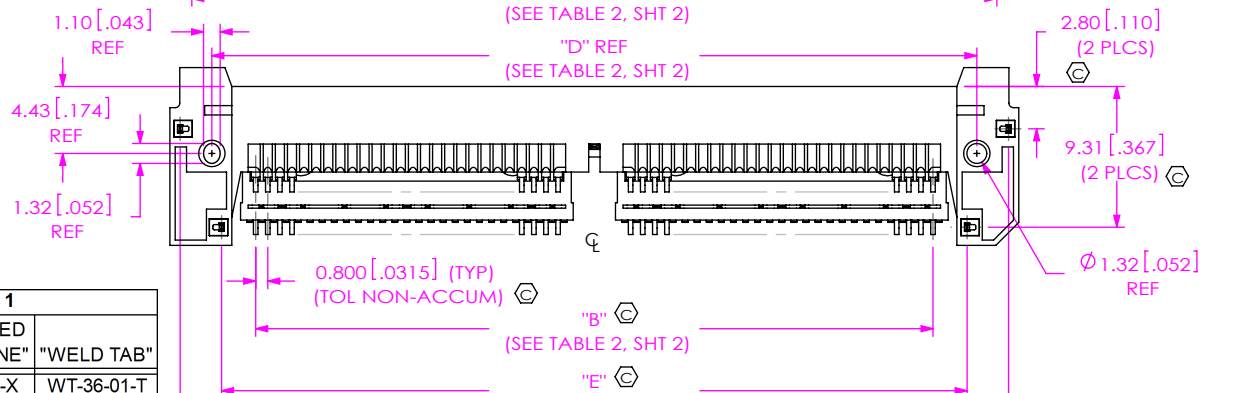
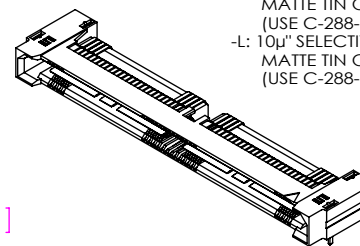
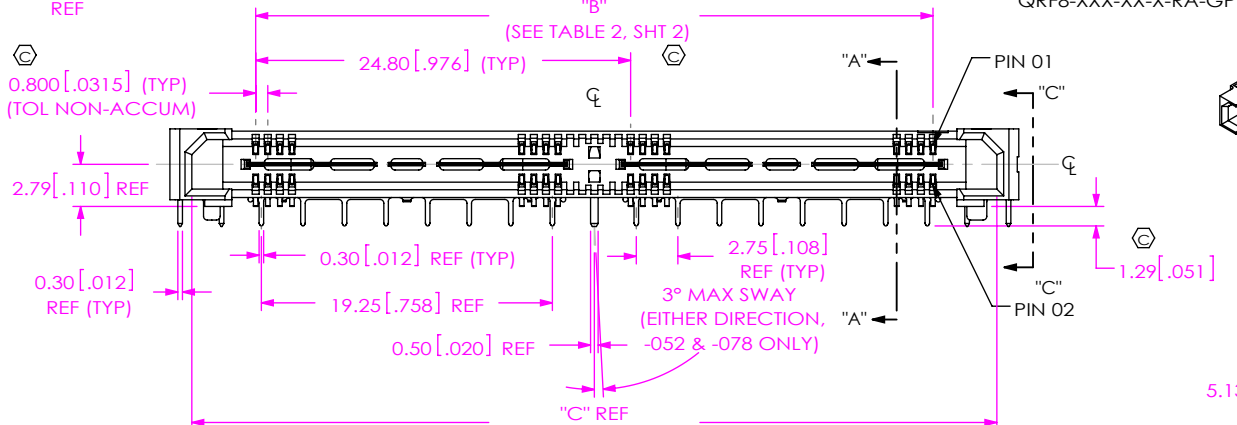
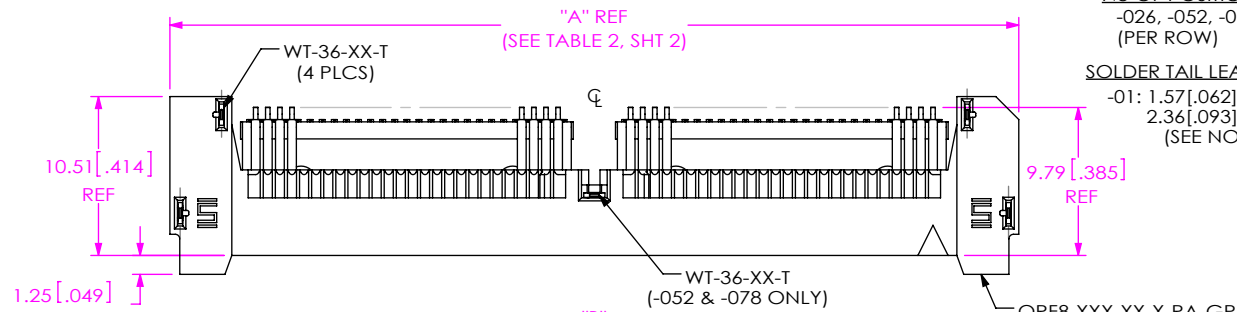
OPTION
-K: POLYIMIDE FILM
(NOT AVAILABLE FOR
-026 & -078)
(USE K-DOT-276-.375-.005
SEE FIG 2, SHT 6)
-TR: TAPE & REEL
(SEE NOTE 10)

GUIDE POSTS REQUIREMENT
-GP (SEE NOTE 9)

RIGHT ANGLE
-RA

PLATING SPECIFICATION

-S: 30μ" SELECTIVE GOLD IN CONTACT AREA,
MATTE TIN ON TAIL
(USE C-288-XX-S & IM-T-1G36-XX-S)
-L: 10μ" SELECTIVE GOLD IN CONTACT AREA,
MATTE TIN ON TAIL
(USE C-288-XX-L & IM-T-1G36-XX-L)



VIEW "C"- "C"
SCALE 4 : 1

TABLE 1

LEAD STYLE	"OVER MOLDED GROUND PLANE"	"WELD TAB"
-01	IM-T-1G36-01-X	WT-36-01-T

- NOTES:
- ⊕ REPRESENTS A CRITICAL DIMENSION.
 - BURR ALLOWANCE: 0.038[.0015].
 - MINIMUM PUSHOUT FORCE: SIGNAL: 2.22N[.5 LB]. GROUND PLANE: 4.45N[1 LB].
 - NOTE DELETED.
 - MEASURE AT BEND TANGENCY.
 - MEASURE ON PINS ONLY, STANDOFFS NOT INCLUDED IN MEASUREMENT.
 - POST HEIGHT VARIATION BETWEEN ANY TWO PINS: 0.05[.002] MAXIMUM.
 - NOTE DELETED.
 - PARTS WITH THE -GP OPTION MUST MATE TO -GP OPTIONED QRM8 PARTS.
 - PARTS TO BE PACKAGED IN TRAYS, UNLESS -TR OPTION IS SPECIFIED.
 - 078 POSITION IS NOT AVAILABLE IN TAPE AND REEL.
 - DIMENSIONS MUST BE MEASURED BOTH ENDS OF COMB OR CONNECTOR.
 - NOTE DELETED.
 - NOTE DELETED.
 - USE INSPECTION FIXTURE # AT-2321-801-XX TO CHECK THIS DIMENSION.
 - SHEAR BURR ALLOWANCE: 0.15[.006] MAX ON THIS EDGE.
 - THIS SURFACE MUST BE PARALLEL TO WITHIN 1.5° OF -F-.
 - THE -01 SOLDER TAIL LEAD STYLE CAN BE USED FOR A 1.57[.062] OR A 2.36[.093] THICK PCB IF SAMTEC'S RECOMMENDED STENCIL APERTURE IS UTILIZED.

FIG 1
(QRF8-052-01-X-RA-GP SHOWN)
(SOME DETAIL REMOVED FOR CLARITY)

c:\enterprise\dwg\MISC\MKTG\QRF8-XXX-XX-X-RA-GP-XX-MKT.SLDDRW

UNLESS OTHERWISE SPECIFIED,
DIMENSIONS ARE IN
MILLIMETERS [INCHES].
TOLERANCES ARE:
DECIMALS ANGLES
X.X: ±0.3 [0.1]
X.XX: ±0.13 [0.05]
X.XXX: ±0.050 [0.020]

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520 PARK EAST BLVD, NEW ALBANY, IN 47150
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MATERIAL: DO NOT SCALE DRAWING
INSULATORS: LCP UL94V-0; COLOR BLACK
CONTACT : PHOS BRONZE
GROUND PLANE: PHOS BRONZE

SHEET SCALE: 2:1

DESCRIPTION:
0.8mm Q-RATE RIGHT ANGLE SOCKET ASSEMBLY
DWG. NO.

QRF8-XXX-XX-X-RA-GP-XX

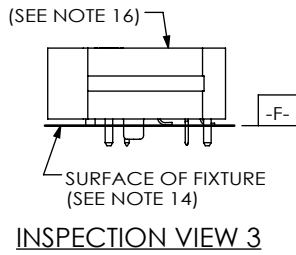
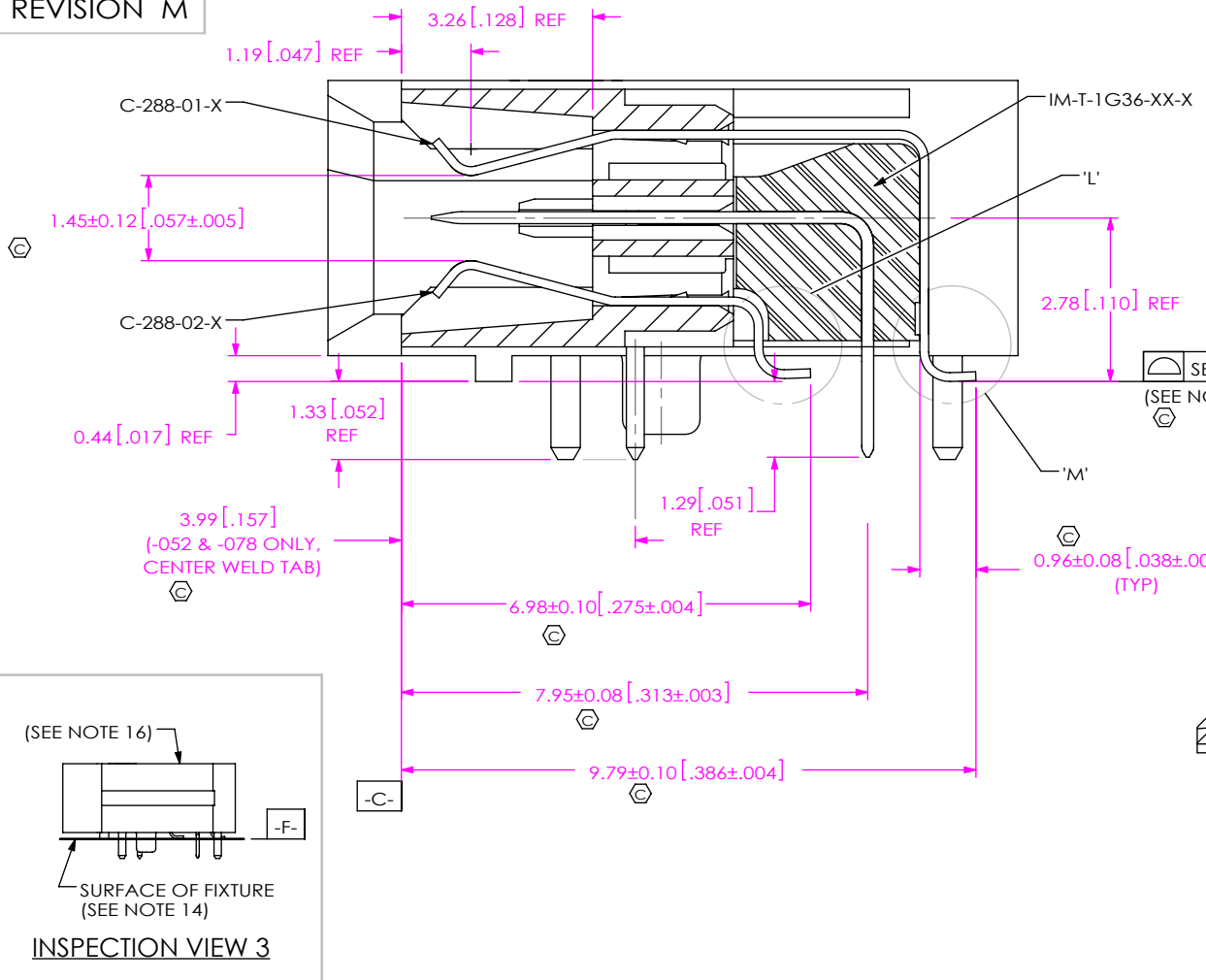
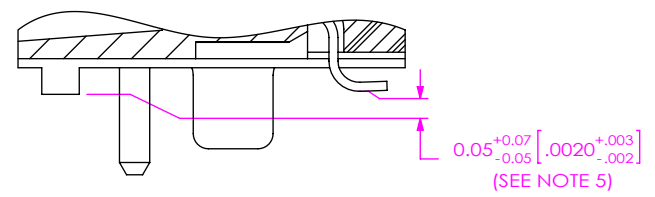
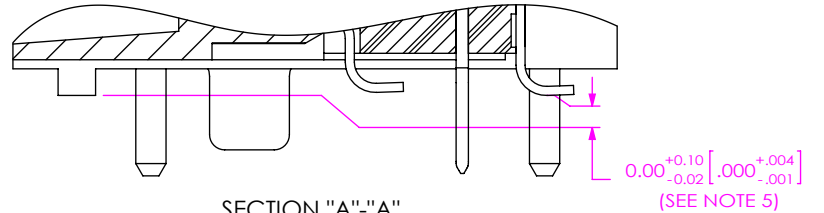


TABLE 4

No OF POSITIONS	BOTTOM ROW STRAIGHTNESS	TOP ROW STRAIGHTNESS	COPLANARITY
-026, -052, -078	0.10 [0.004]	0.10 [0.004]	0.15 [0.006]



DETAIL 'L'
 BOTTOM ROW TAIL
 (LOCATE ASSY ON DATUM -C- FOR MEASUREMENTS)



SECTION 'A'-'A'
 SCALE 8 : 1
DETAIL 'M'
 TOP ROW TAIL
 (LOCATE ASSY ON DATUM -C- FOR MEASUREMENTS)

TABLE 2

No OF POSITIONS	"A"	"B"	"C"	"D"	"E"	"F"
-026	31.35 [1.234]	20.00 [0.787]	28.45 [1.120]	25.80 [1.016]	24.52 [0.965]	30.00 [1.181]
-052	56.15 [2.211]	44.80 [1.764]	53.25 [2.096]	50.60 [1.992]	49.32 [1.942]	54.80 [2.157]
-078	80.95 [3.187]	69.60 [2.740]	78.05 [3.073]	75.40 [2.969]	74.12 [2.918]	79.60 [3.134]

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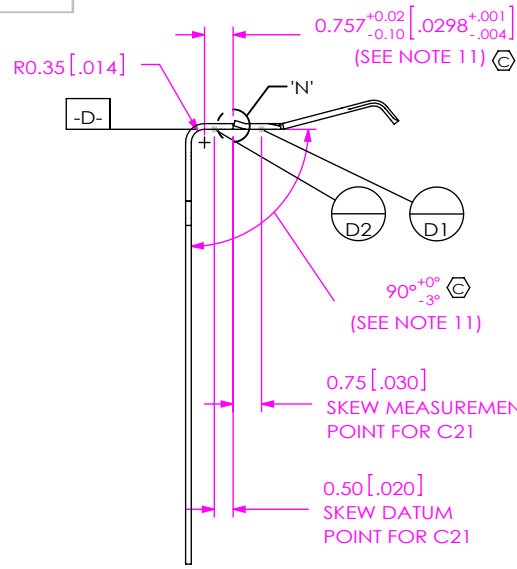
DO NOT SCALE DRAWING
 SHEET SCALE: 2:1

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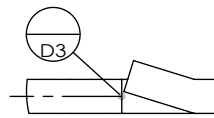
DESCRIPTION:
 0.8mm Q-RATE RIGHT ANGLE SOCKET ASSEMBLY

DWG. NO.
QRF8-XXX-XX-X-RA-GP-XX

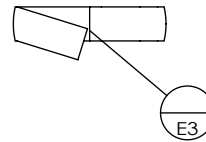
BY: R MUSSER 09/19/2008 SHEET 2 OF 6



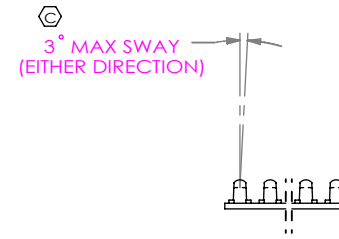
IN-PROCESS 1
(FORM 1 CONTACT C-288-02-X)
(RIGHT SIDE SHOWN)



DETAIL 'N'
SCALE 30 : 1

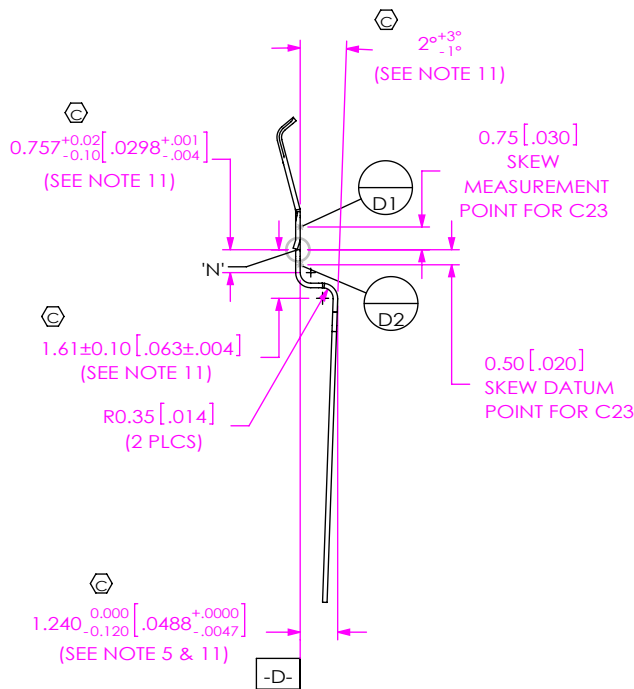
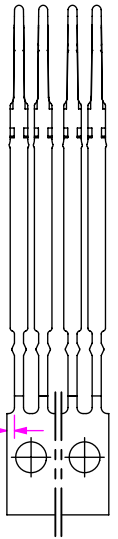


DETAIL 'P'
SCALE 30 : 1

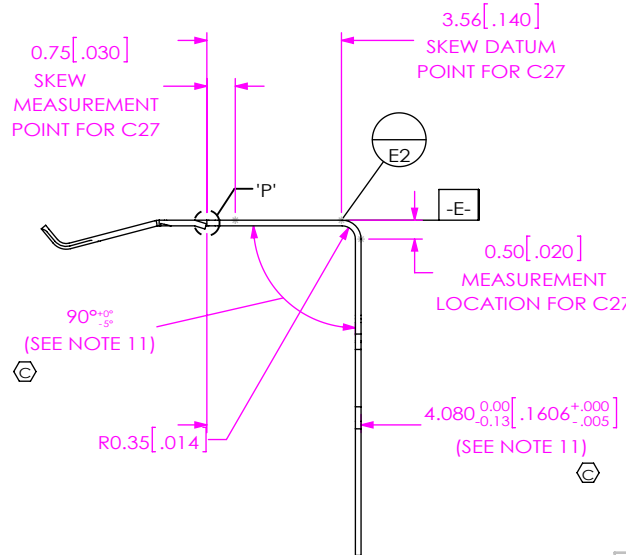


0.25±0.08 [0.010±0.003]

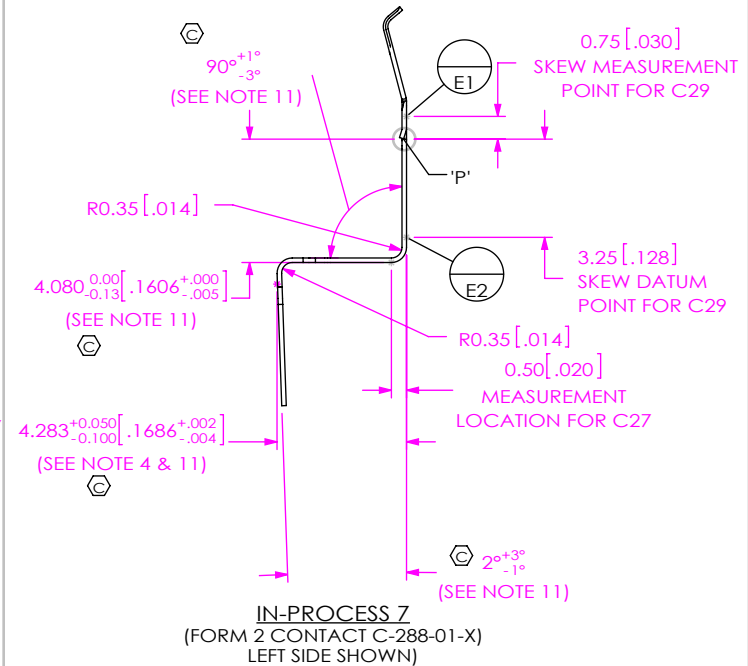
C-288-XX-X IN-PROCESS VIEW



IN-PROCESS 2
(FORM 2 CONTACT C-288-02-X)
(RIGHT SIDE SHOWN)



IN-PROCESS 6
(FORM 1 CONTACT C-288-01-X)
(LEFT SIDE SHOWN)



IN-PROCESS 7
(FORM 2 CONTACT C-288-01-X)
(LEFT SIDE SHOWN)

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SHEET SCALE: 4:1

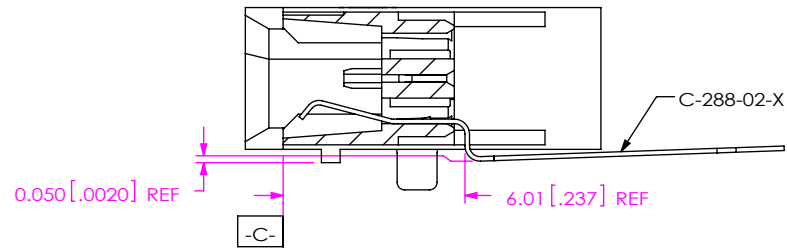


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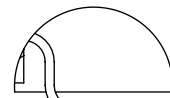
DESCRIPTION:
0.8mm Q-RATE RIGHT ANGLE SOCKET ASSEMBLY

DWG. NO.
QRF8-XXX-XX-X-RA-GP-XX

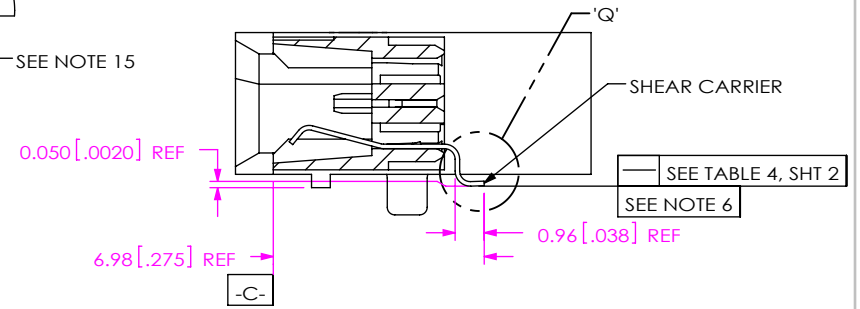
BY: R MUSSER 09/19/2008 SHEET 3 OF 6



IN-PROCESS 3
(FILL BOTTOM ROW)
(SEE INSPECTION VIEW 1 FOR ASSEMBLY ORIENTATION AND CPC'S)

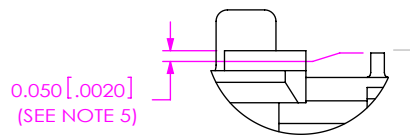
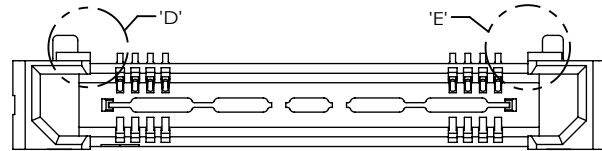


DETAIL 'Q'
SCALE 8:1

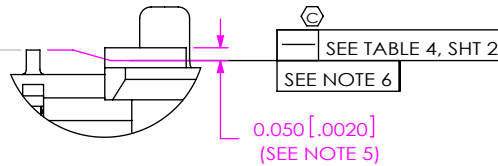


IN-PROCESS 4
(CUTOFF OF CARRIER)
(SEE INSPECTION VIEW 1 FOR ASSEMBLY ORIENTATION AND CPC'S)

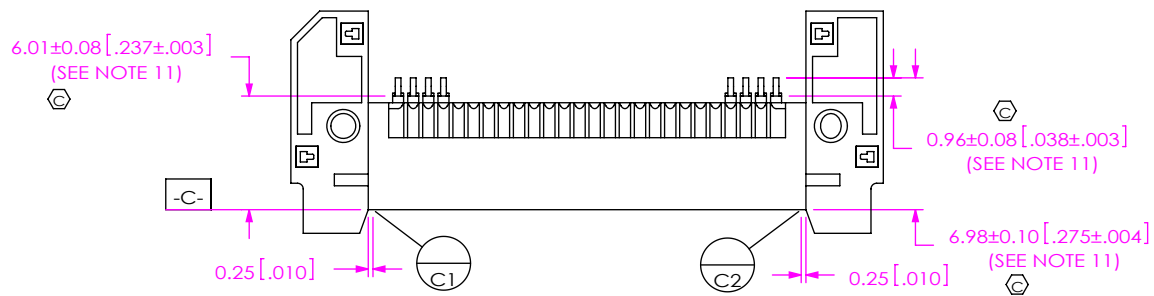
INSPECTION VIEW 1



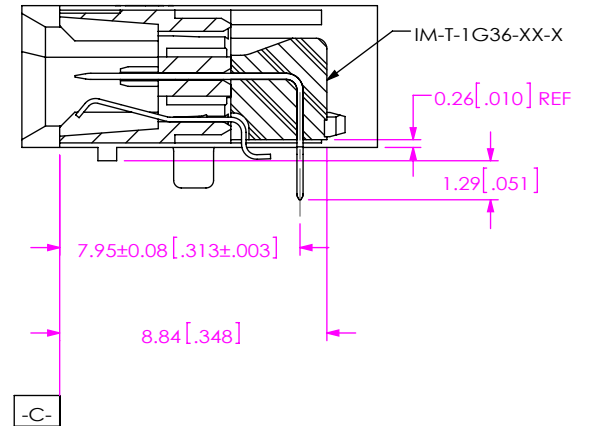
DETAIL 'D'
SCALE 6:1



DETAIL 'E'
SCALE 6:1



INSPECTION FOR IN-PROCESS 3 & 4
(CARRIER NOT SHOWN FOR IN-PROCESS 3 INSPECTIONS)



IN-PROCESS 5
(FILL OVER MOLDED GROUND PLANE)
(IM-T-1G36-XX-X)

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SHEET SCALE: 4:1

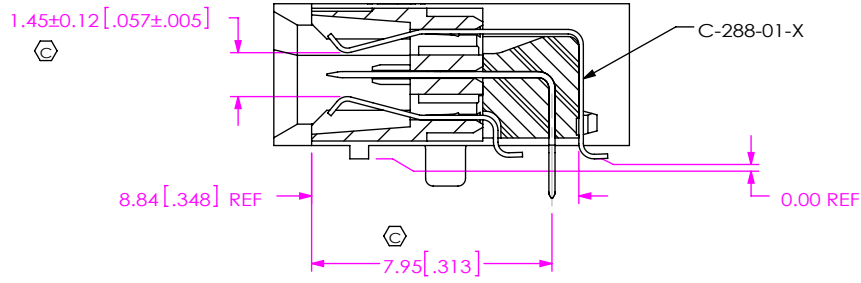


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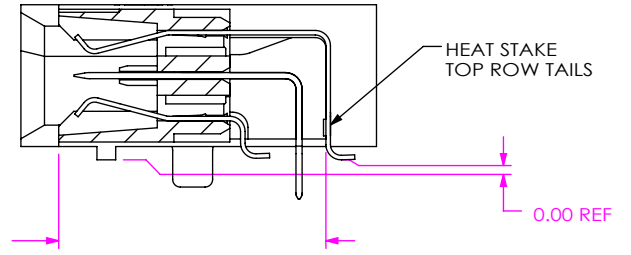
DESCRIPTION:
0.8mm Q-RATE RIGHT ANGLE SOCKET ASSEMBLY

DWG. NO.
QRF8-XXX-XX-X-RA-GP-XX

BY: R MUSSER 09/19/2008 SHEET 4 OF 6

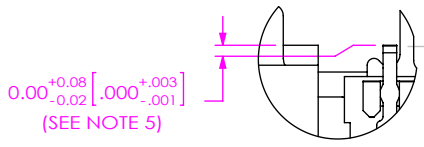
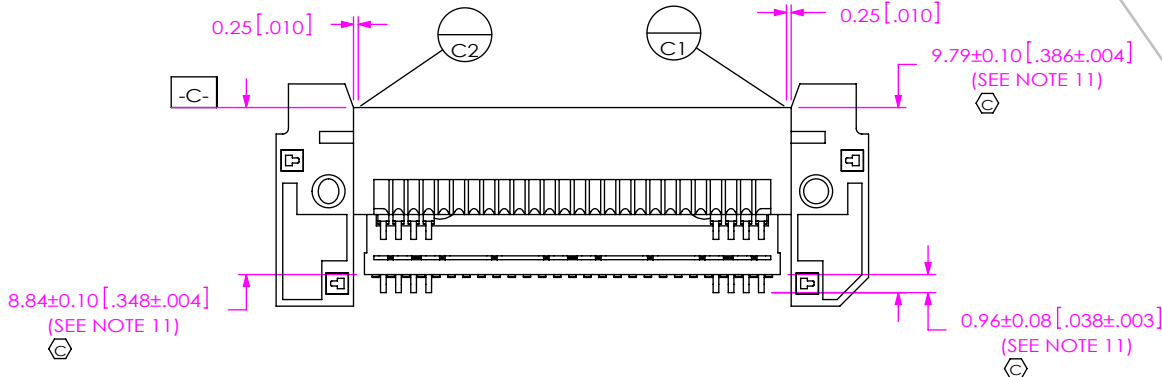


IN-PROCESS 8
(FILL TOP ROW)
(SEE INSPECTION VIEW 2 FOR ASSEMBLY ORIENTATION AND CPC'S)

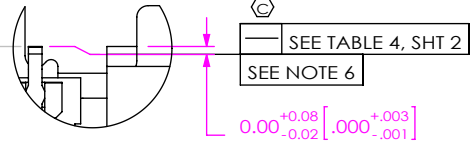


IN-PROCESS 9
(HEAT STAKE TOP ROW CONTACTS)
(SEE INSPECTION VIEW 2 FOR ASSEMBLY ORIENTATION AND CPC'S)

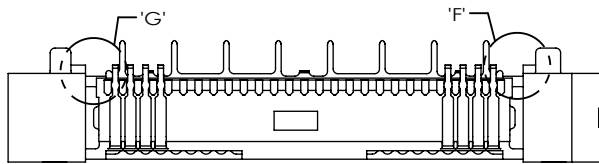
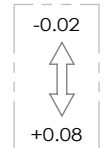
INSPECTION VIEW 2



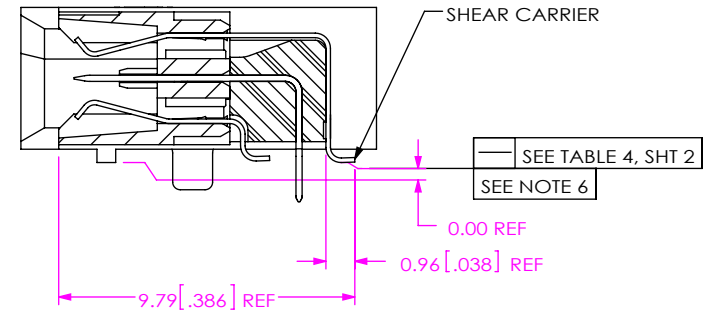
DETAIL 'G'
SCALE 6:1



DETAIL 'F'
SCALE 6:1



INSPECTION FOR IN-PROCESS 8, 9 & 10
(CARRIER NOT SHOWN FOR IN-PROCESS 8 INSPECTIONS)



IN-PROCESS 10
(CUTOFF OF CARRIER)
(SEE INSPECTION VIEW 2 FOR ASSEMBLY ORIENTATION AND CPC'S)

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SHEET SCALE: 4:1

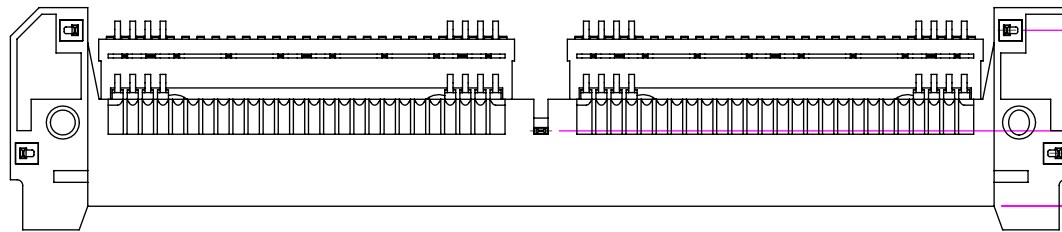
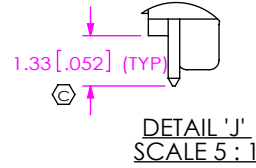
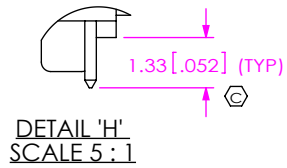
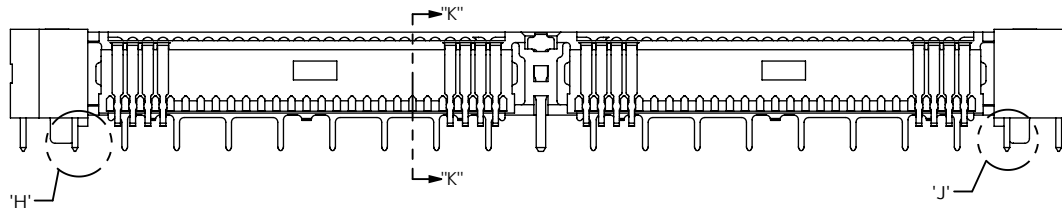


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0.8mm Q-RATE RIGHT ANGLE SOCKET ASSEMBLY

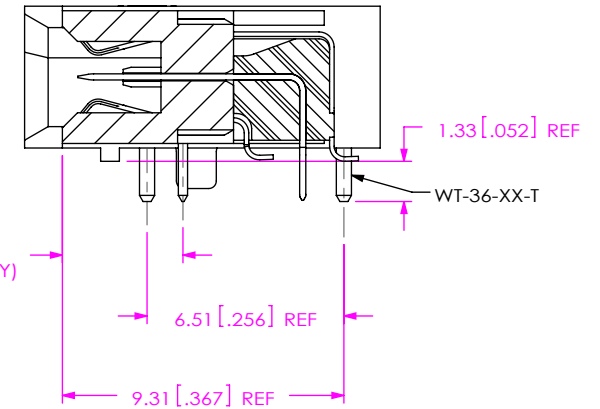
DWG. NO.
QRF8-XXX-XX-X-RA-GP-XX

BY: R MUSSER 09/19/2008 SHEET 5 OF 6



IN-PROCESS 11
(FILL WELD TAB)
(WT-36-XX-T)

3.99 [.157]
(-052 & -078 ONLY,
CENTER WELD TAB)



SECTION "K"-"K"
SCALE 4 : 1

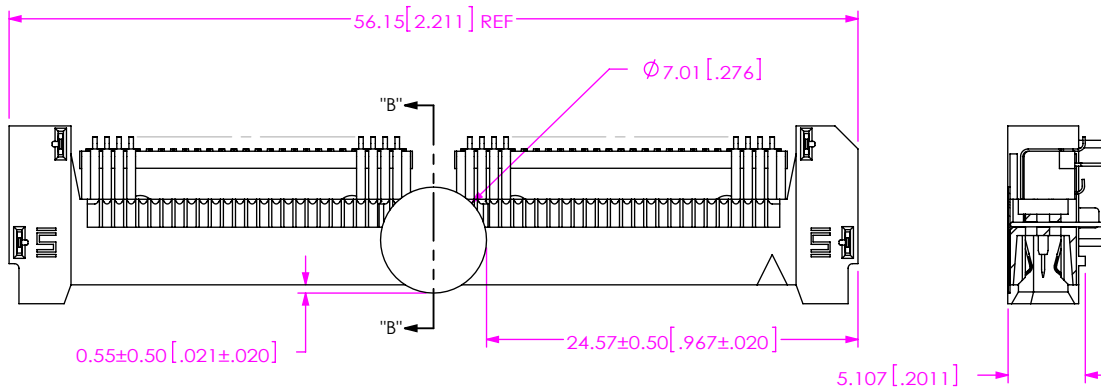


FIG 2
-K OPTION
(USE K-DOT-.276-.375-.005)
(ONLY FOR QRF8-052-01-X-RA-GP-K SHOWN)
(SOME DETAIL REMOVED FOR CLARITY)

SECTION "B"-"B"
SCALE 2 : 1

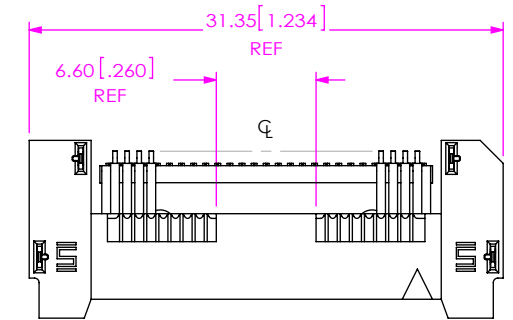


FIG 3
(QRF8-026-01-X-RA-GP SHOWN)
(SOME DETAIL REMOVED FOR CLARITY)

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SHEET SCALE: 4:1



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0.8mm Q-RATE RIGHT ANGLE SOCKET ASSEMBLY

DWG. NO.
QRF8-XXX-XX-X-RA-GP-XX

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