

DO NOT
SCALE FROM
THIS PRINT

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

SOLDER TAIL LEAD STYLE
-01: 1.57[.062] OR
2.36[.093] BOARD
(SEE NOTE 9)

PACKAGING

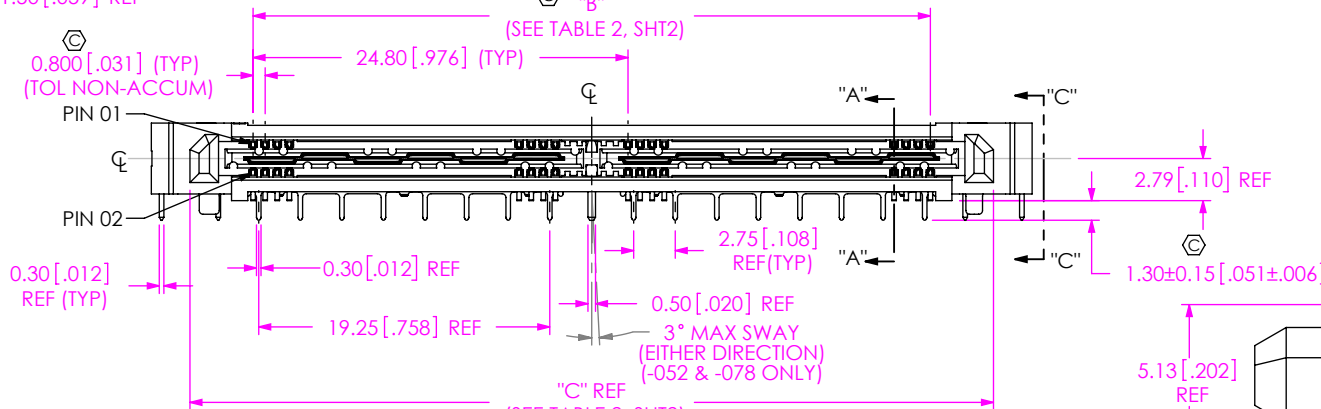
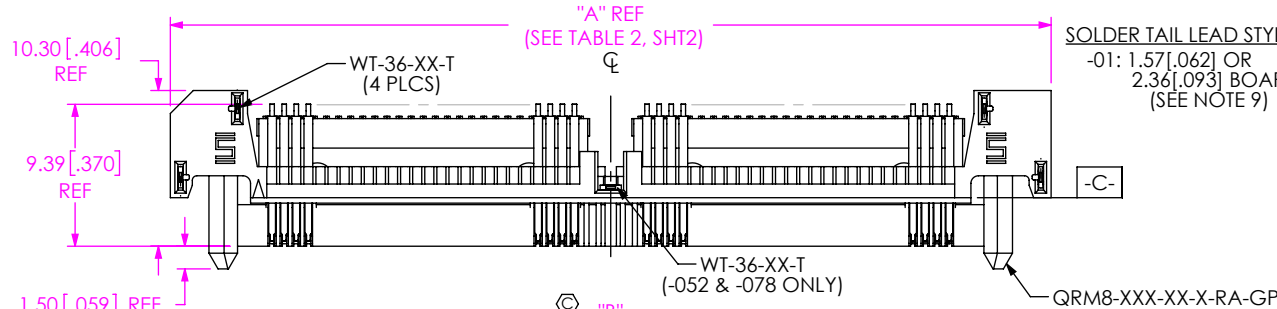
BLANK: TRAY(SEE NOTE 16)
-TR: TAPE & REEL
(SEE NOTE 17 & 18)
(NOT AVAILABLE FOR -78 POS)
-FR: FULL REEL QTY TAPE & REEL
(SEE NOTE 17 & 18)
PICK & PLACE OPTION
-K: POLYIMIDE FILM
(NOT AVAILABLE FOR
-026 & -078)
(USE K-DOT-.276-.375-.005,
SEE FIG. 2, SHT 6)

GUIDE POSTS

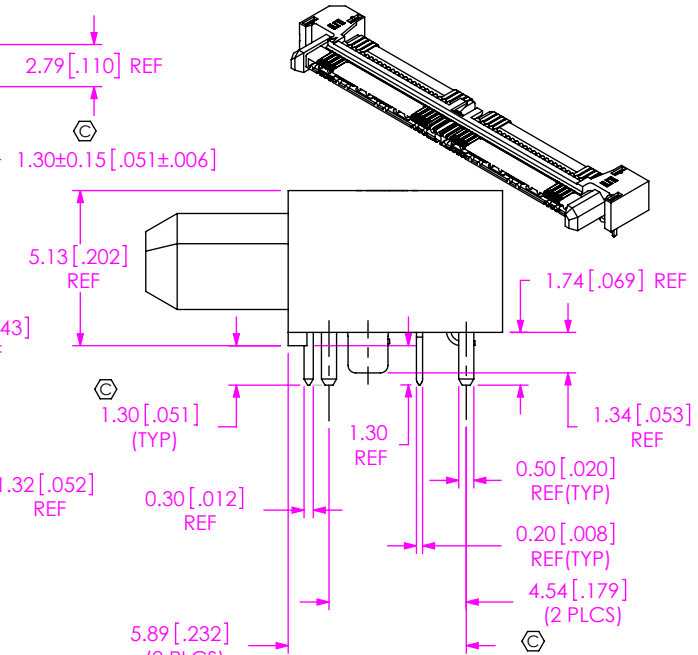
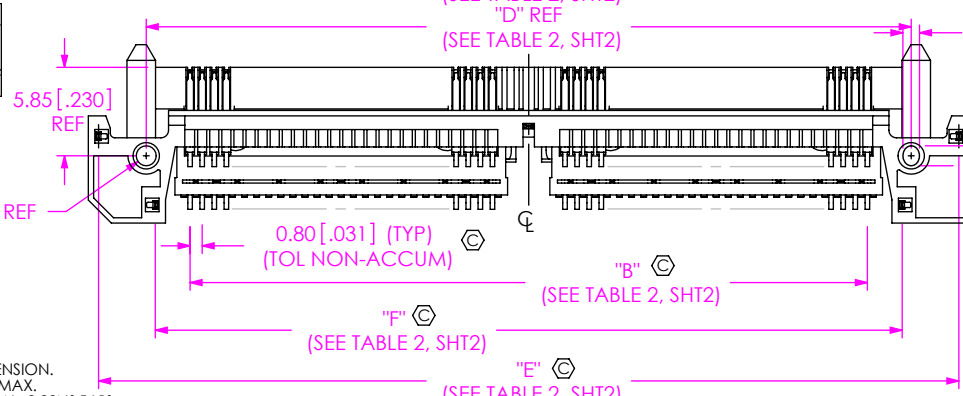
-GP
RIGHT ANGLE

PLATING SPECIFICATION

-S: 30µ" SELECTIVE GOLD IN CONTACT AREA
MATTE TIN ON TAIL
(USE T-1M52-XX-S & IM-T-1G35-XX-S)
-L: 10µ" SELECTIVE GOLD IN CONTACT AREA
MATTE TIN ON TAIL
(USE T-1M52-XX-L & IM-T-1G35-XX-L)



LEAD STYLE	"OVER MOLDED GROUND PLANE"	"WELD TAB"
-01	IM-T-1G35-01-X	WT-36-01-T



SECTION "C"- "C"
SCALE 4 : 1

NOTES:
1. Ⓞ REPRESENTS A CRITICAL DIMENSION.
2. BURR ALLOWANCE: 0.038[.0015] MAX.
3. MINIMUM PUSHOUT FORCE: SIGNAL: 2.22N[.5 LB].
GROUND PLANE: 4.45N[1 LB].
4. MEASURE AT BEND TANGENCY.
5. MEASURE ON PINS ONLY, STANDOFFS NOT INCLUDED
IN MEASUREMENT.
6. POST HEIGHT VARIATION BETWEEN ANY TWO PINS: 0.05[.002] MAXIMUM.
7. NOTE DELETED.
8. NOTE DELETED.
9. 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.
10. DIMENSIONS MUST BE MEASURED BOTH ENDS OF COMB OR CONNECTOR.
11. NOTE DELETED.
12. NOTE DELETED.
13. NOTE DELETED.
14. NOTE DELETED.
15. SHEAR BURR ALLOWANCE: .15 [.006] MAX ON THIS EDGE.
16. TRAY IS STANDARD PACKAGING.
17. ORDERS WILL BE PACKAGED ACCORDING TO THE SAMTEC PACKAGING
EFFICIENCY STANDARDS (SPES) FOUND ON WWW.SAMTEC.COM.
18. ATTACH LABEL TO EACH REEL.

F:\DWG\MISC\WMTG\QRM8-XXX-XX-X-RA-GP-X-XX-MKT.SLDRW

UNLESS OTHERWISE SPECIFIED,
DIMENSIONS ARE IN
MILLIMETERS [INCHES].
TOLERANCES ARE:
DECIMALS ANGLES
X.X: ±0.3 [.01] 2°
X.XX: ±0.13 [.005]
X.XXX: ±0.050 [.0020]

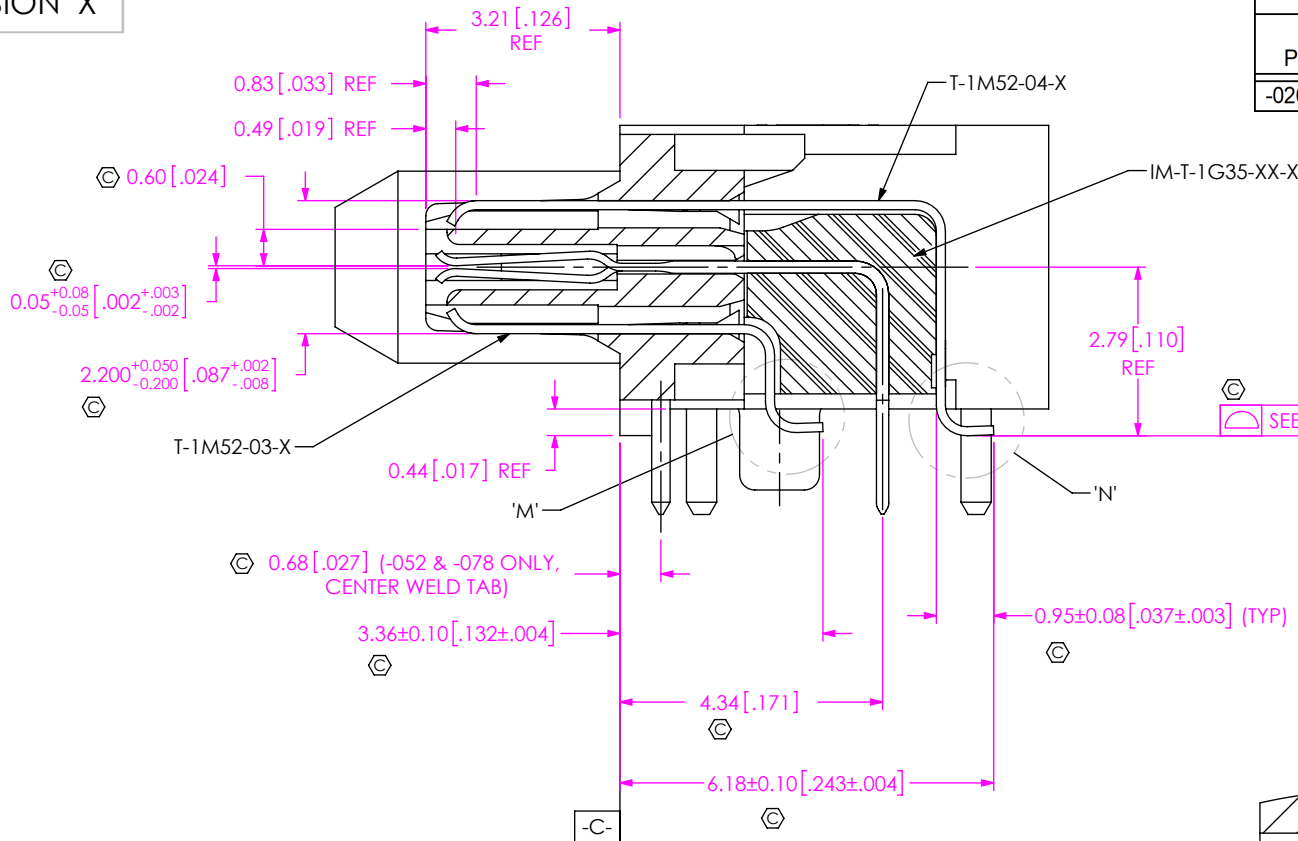
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MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 2:1
INSULATORS: LCP UL94V-0; COLOR: BLACK
CONTACT: PHOS BRONZE
GROUND PLANE: PHOS BRONZE

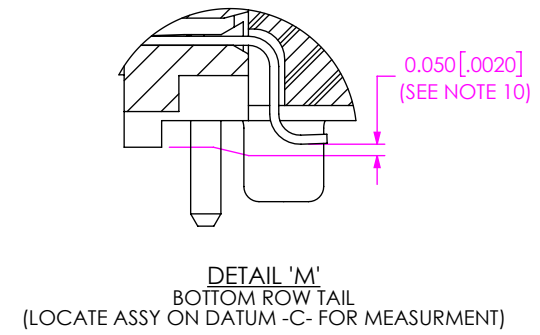


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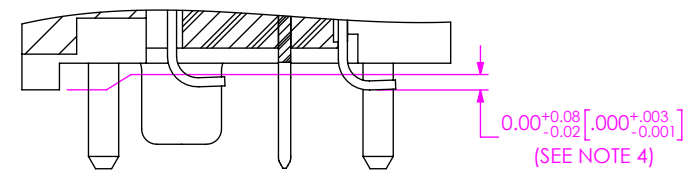
DESCRIPTION:
0.8mm Q-RATE RIGHT ANGLE TERMINAL ASSEMBLY
DWG. NO.
QRM8-XXX-XX-X-RA-GP-X-XX
BY: R MUSSER 10/02/2008 SHEET 1 OF 6



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]



SECTION "A"- "A"
SCALE 8 : 1



No OF POSITIONS	"A"	"B"	"C"	"D"	"E"	"F"
-026	33.46 [1.317]	20.00 [0.787]	28.35 [1.116]	25.80 [1.016]	32.11 [1.264]	24.61 [0.969]
-052	58.26 [2.294]	44.80 [1.764]	53.15 [2.093]	50.60 [1.992]	56.91 [2.240]	49.41 [1.945]
-078	83.06 [3.270]	69.60 [2.740]	77.95 [3.069]	75.40 [2.969]	81.71 [3.217]	74.21 [2.921]

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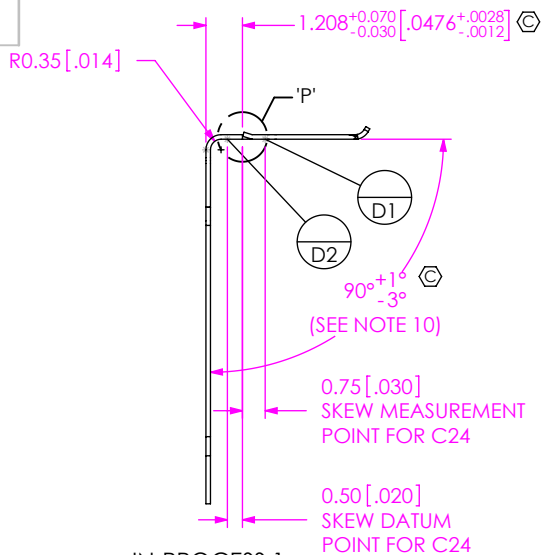
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SHEET SCALE: 2:1

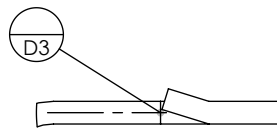
DESCRIPTION:
0.8mm Q-RATE RIGHT ANGLE TERMINAL ASSEMBLY

DWG. NO.
QRM8-XXX-XX-X-RA-GP-X-XX

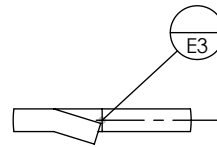
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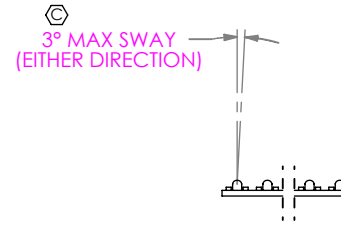
IN-PROCESS 1
(FORM 1 CONTACT T-1M52-03-X)
(RIGHT SIDE SHOWN)



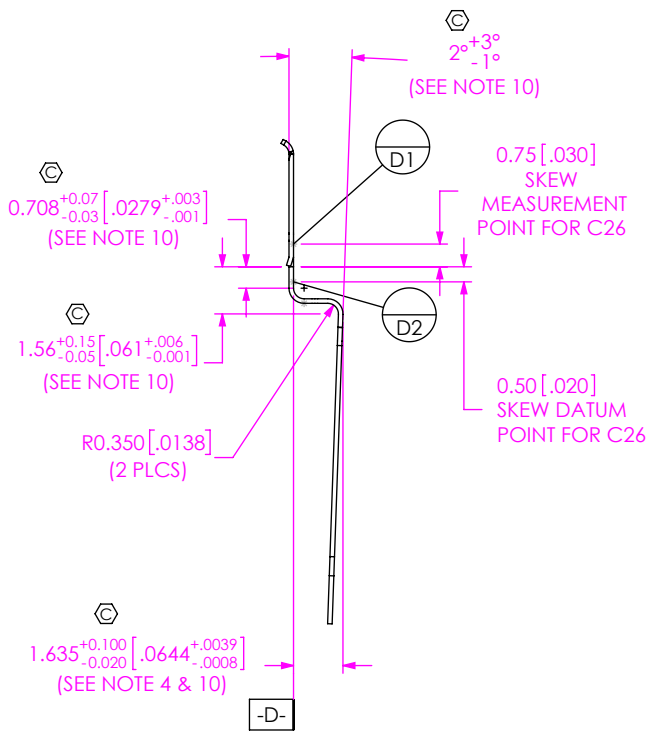
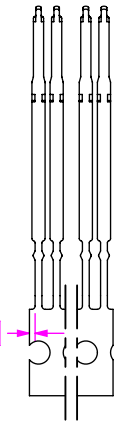
DETAIL 'P'
SCALE 20 : 1



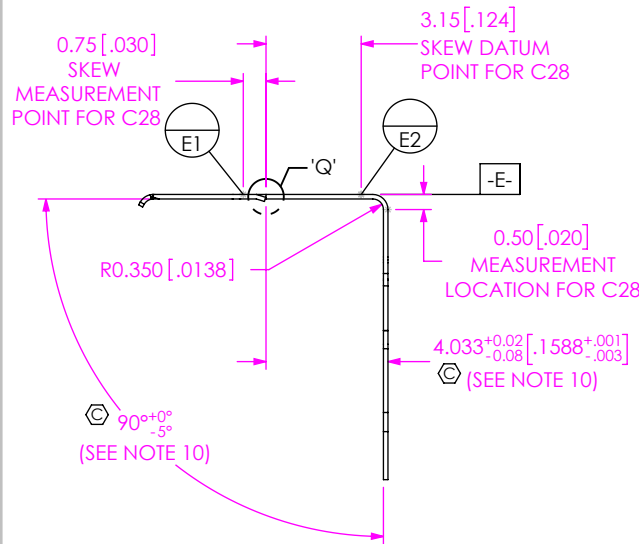
DETAIL 'Q'
SCALE 20 : 1



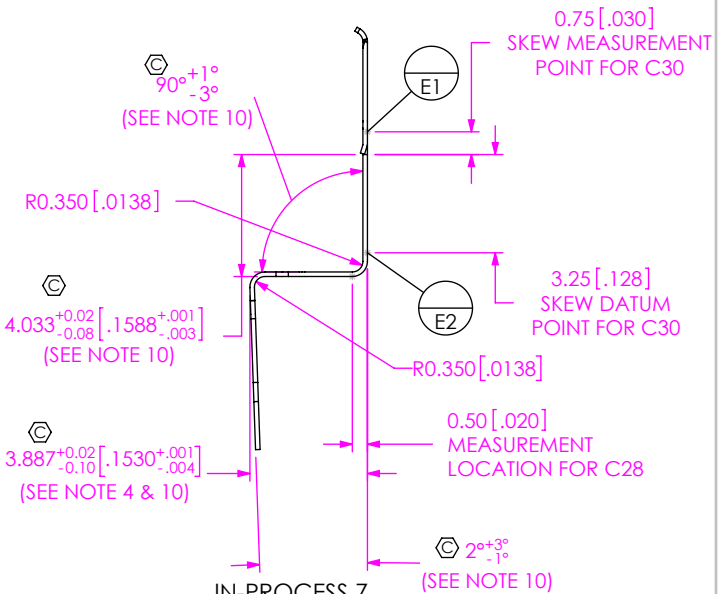
T-1M52-XX-X IN-PROCESS VIEW



IN-PROCESS 2
(FORM 2 CONTACT T-1M52-03-X)
(RIGHT SIDE SHOWN)



IN-PROCESS 6
(FORM 1 CONTACT T-1M52-04-X)
(LEFT SIDE SHOWN)



IN-PROCESS 7
(FORM 2 CONTACT T-1M52-04-X)
(LEFT SIDE SHOWN)

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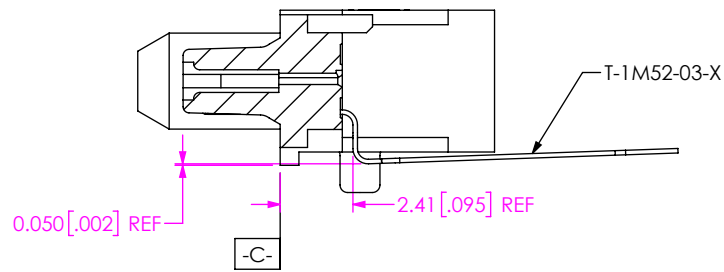
DO NOT SCALE DRAWING

SHEET SCALE: 4:1

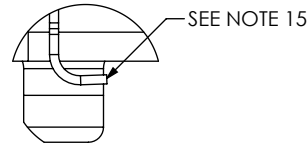
DESCRIPTION:
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DWG. NO.
QRM8-XXX-XX-X-RA-GP-X-XX

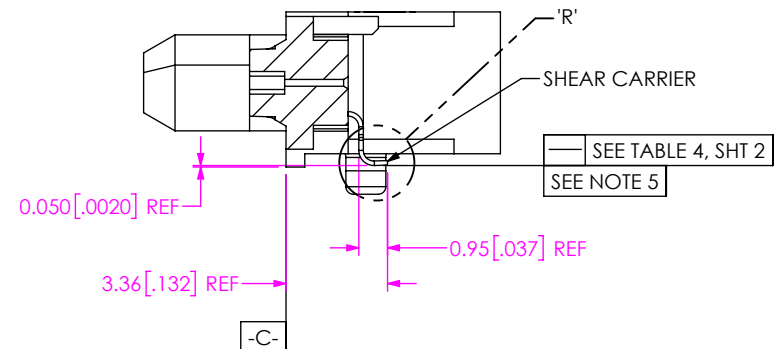
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IN-PROCESS 3
(FILL BOTTOM ROW)
(SEE INSPECTION VIEW 1 FOR ASSEMBLY ORIENTATION AND CPC'S)

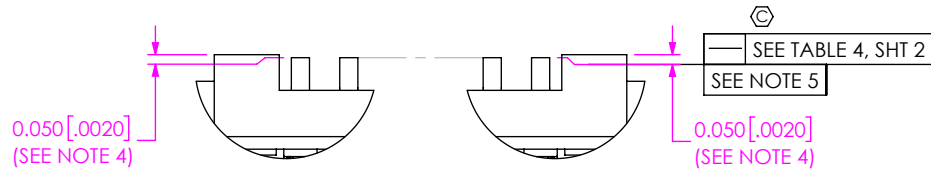
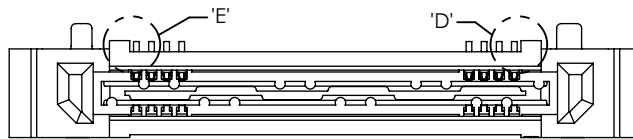


DETAIL 'R'
SCALE 8 : 1



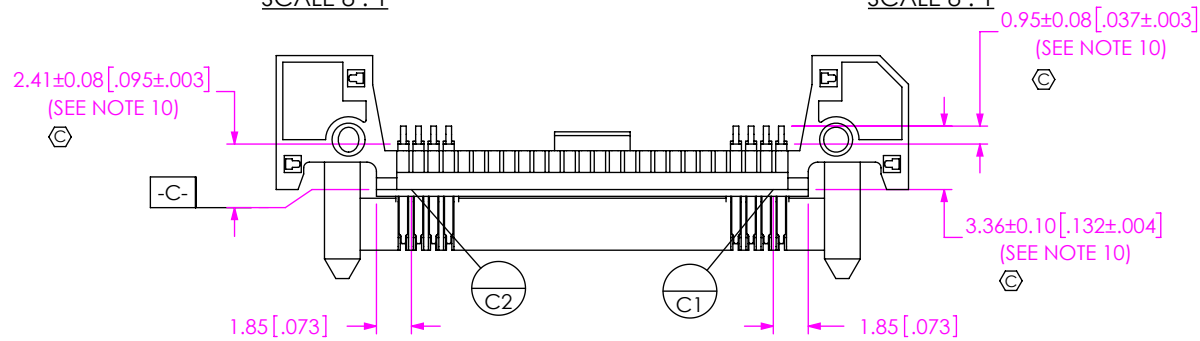
IN-PROCESS 4
(CUTOFF OF CARRIER)
(SEE INSPECTION VIEW 1 FOR ASSEMBLY ORIENTATION AND CPC'S)

INSPECTION VIEW 1

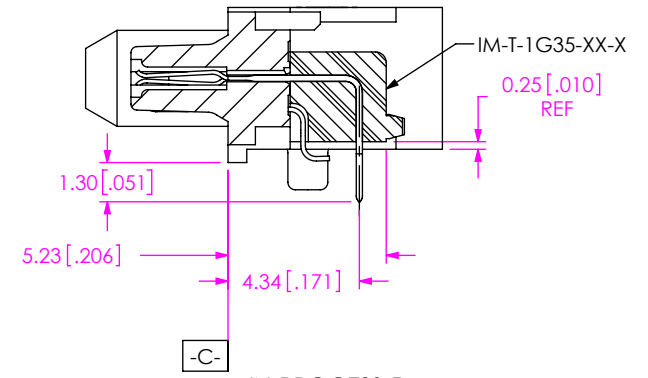


DETAIL 'E'
SCALE 8 : 1

DETAIL 'D'
SCALE 8 : 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-1G35-XX-X)

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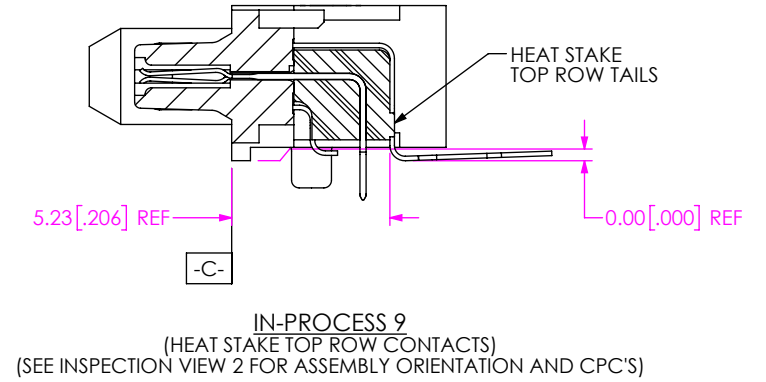
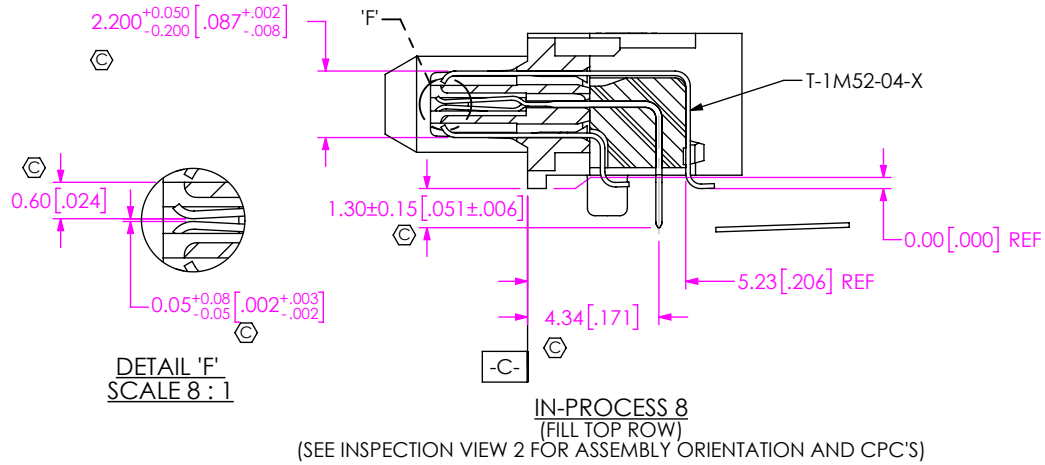
SHEET SCALE: 4:1

DESCRIPTION:
0.8mm Q-RATE RIGHT ANGLE TERMINAL ASSEMBLY

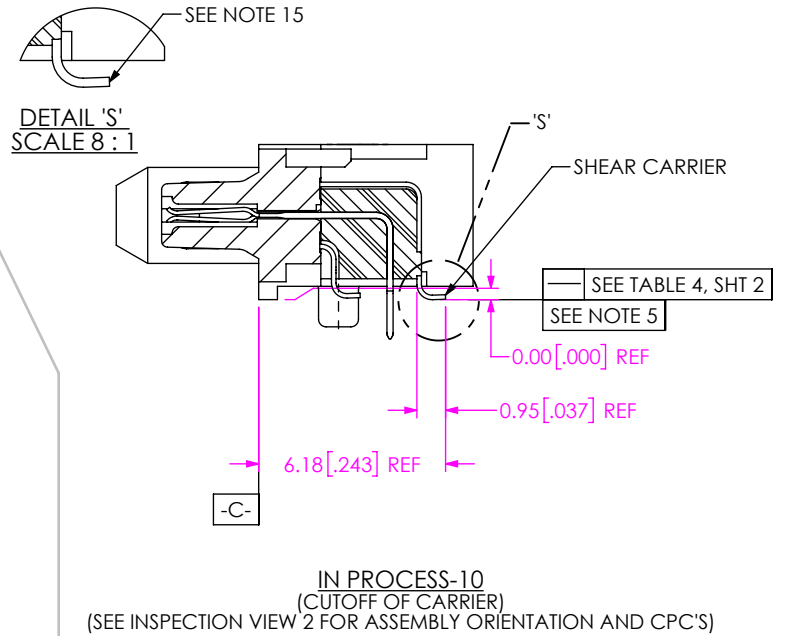
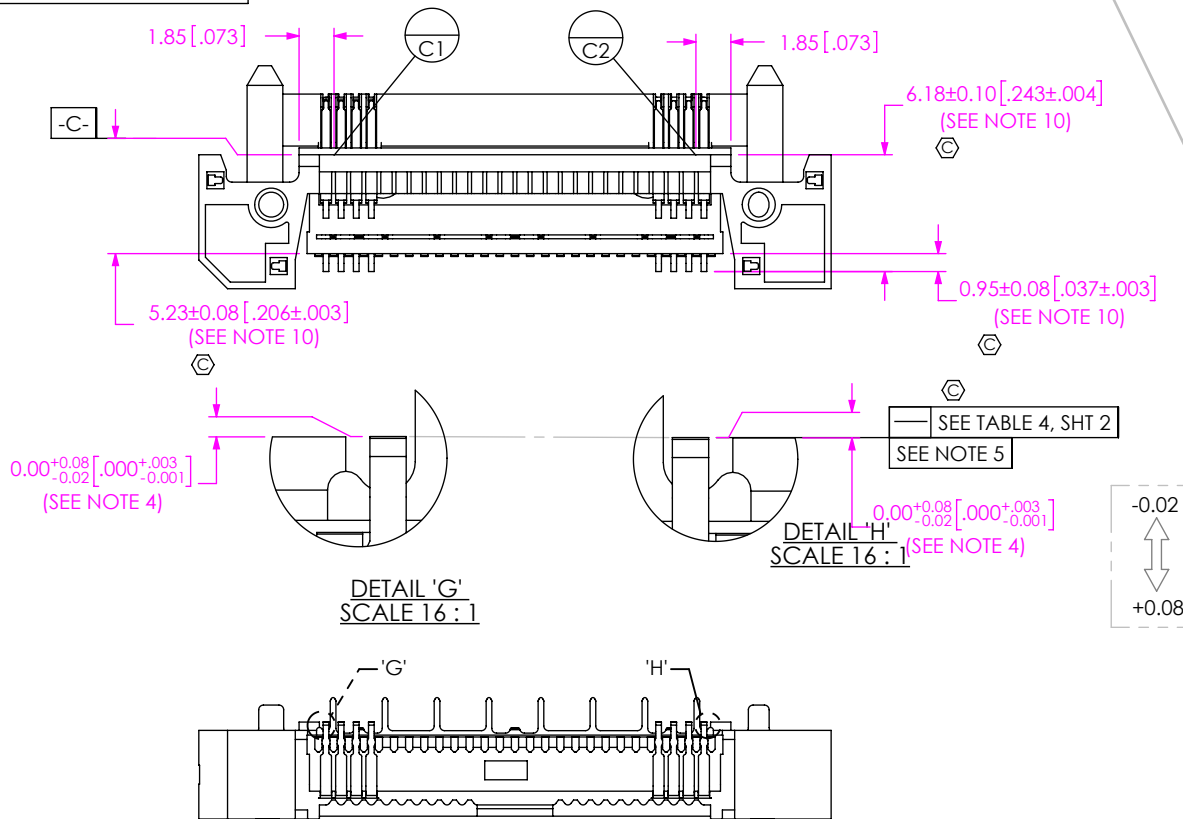
DWG. NO.
QRM8-XXX-XX-X-RA-GP-X-XX

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REVISION X



INSPECTION VIEW 2



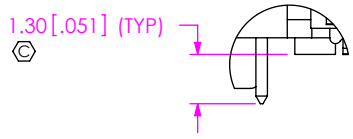
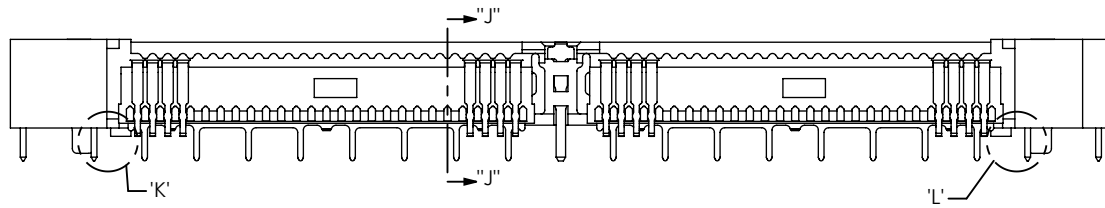
INSPECTION FOR IN-PROCESS 8, 9 & 10
 (CARRIER NOT SHOWN FOR IN-PROCESS 8 INSPECTIONS)

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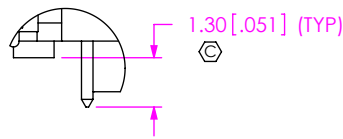
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 SHEET SCALE: 4:1

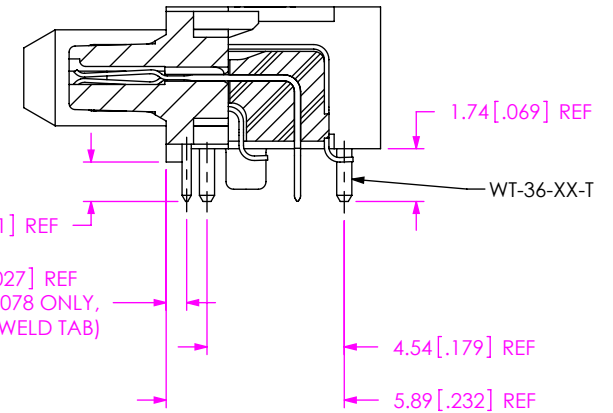
DESCRIPTION:
 0.8mm Q-RATE RIGHT ANGLE TERMINAL ASSEMBLY
 DWG. NO.
QRM8-XXX-XX-X-RA-GP-X-XX
 BY: R MUSSER 10/02/2008 SHEET 5 OF 6



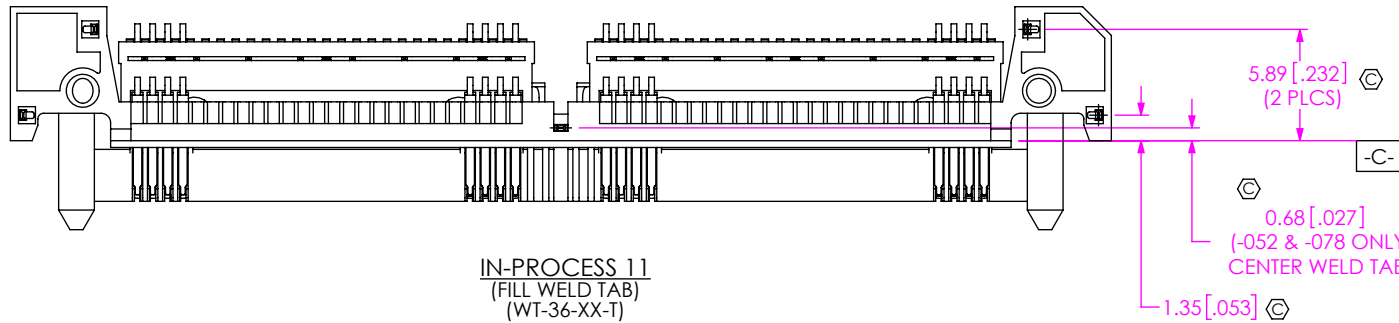
DETAIL 'K'
SCALE 5:1



DETAIL 'L'
SCALE 5:1



SECTION "J"-"J"



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

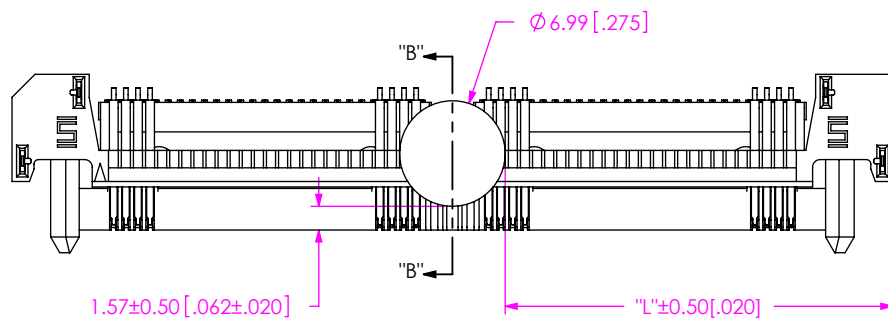
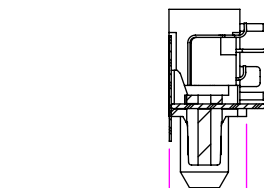


FIG 2
-K OPTION
(USE K-DOT-.276-.375-.005)
(QRM8-052-01-X-RA-GP-K SHOWN)
(SOME DETAIL REMOVED FOR CLARITY)

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



No OF POSITIONS	"L"
-026	13.24 [0.521]
-052	25.64 [1.009]
-078	38.04 [1.498]

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0.8mm Q-RATE RIGHT ANGLE TERMINAL ASSEMBLY

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QRM8-XXX-XX-X-RA-GP-X-XX

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