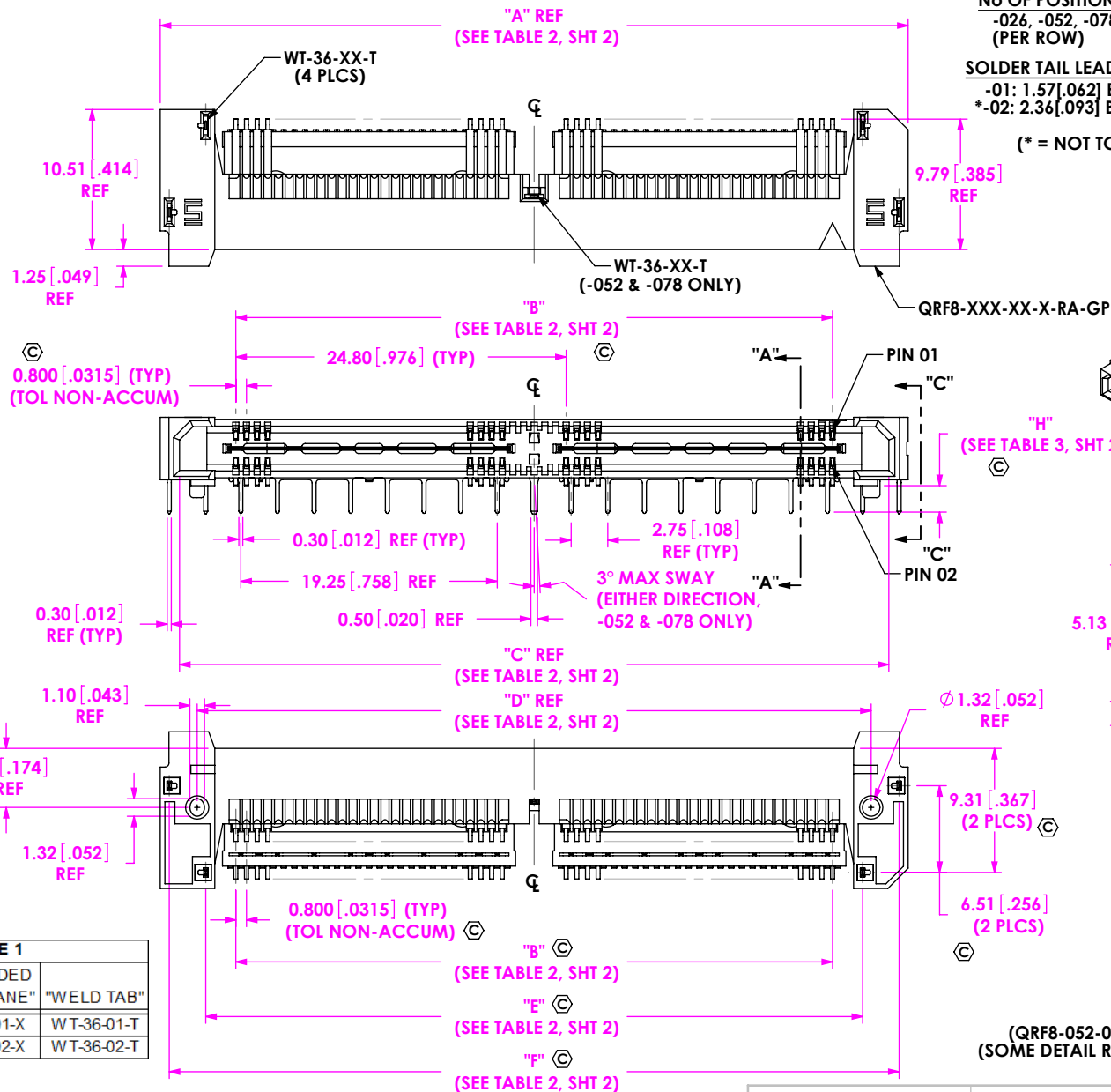


DO NOT
SCALE FROM
THIS PRINT

No OF POSITIONS

-026, -052, -078
(PER ROW)

SOLDER TAIL LEAD STYLE

-01: 1.57 [.062] BOARD
*-02: 2.36 [.093] BOARD

(* = NOT TOOLED)

OPTION

-K: POLYIMIDE FILM
(NOT AVAILABLE FOR
-026 & -078)
(USE K-500-300,
SEE FIG. 2, SHT 4)
-TR: TAPE & REEL
(SEE NOTE 10)

GUIDE POSTS REQUIREMENT

-GP (SEE NOTE 9)

RIGHT ANGLE

-RA

PLATING SPECIFICATION

-S: SELECTIVE, 30Au / 50Ni MIN ON
CONTACT, MATTE TIN ON TAIL
(USE C-288-XX-S & IM-T-1G36-XX-S)
-L: LIGHT SELECTIVE, 30Au / 50Ni MIN ON
CONTACT, MATTE TIN ON TAIL
(USE C-288-XX-L & IM-T-1G36-XX-L)

TABLE 1		
LEAD STYLE	"OVER MOLDED GROUND PLANE"	"WELD TAB"
-01	IM-T-1G36-01-X	WT-36-01-T
*-02	IM-T-1G36-02-X	WT-36-02-T

(* = NOT TOOLED)

NOTES:

- ① REPRESENTS A CRITICAL DIMENSION.
- BURR ALLOWANCE: 0.038 [.0015] MAX.
- 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.
- FIRST ROW TAILS TO BE FLUSH TO .08 ABOVE THE SECOND ROW.
- 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.
- CPC'S MUST BE MEASURED BOTH ENDS OF COMB OR CONNECTOR.
- USE INSPECTION FIXTURE # AT-2298-801-01 TO CHECK CRITICALS.

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: ±0.051 [.0020]	

MATERIAL: DO NOT SCALE DRAWING
INSULATORS: LCP
CONTACT: PHOS BRONZE
GROUND PLANE: PHOS BRONZE

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FIG 1

(QRF8-052-02-X-RA-GP SHOWN)
(SOME DETAIL REMOVED FOR CLARITY)

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PHONE: 812-944-6733 FAX: 812-948-5047
e-Mail info@SAMTEC.com code 55322

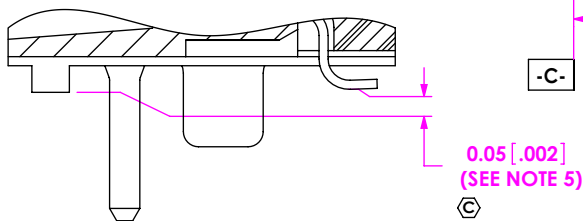
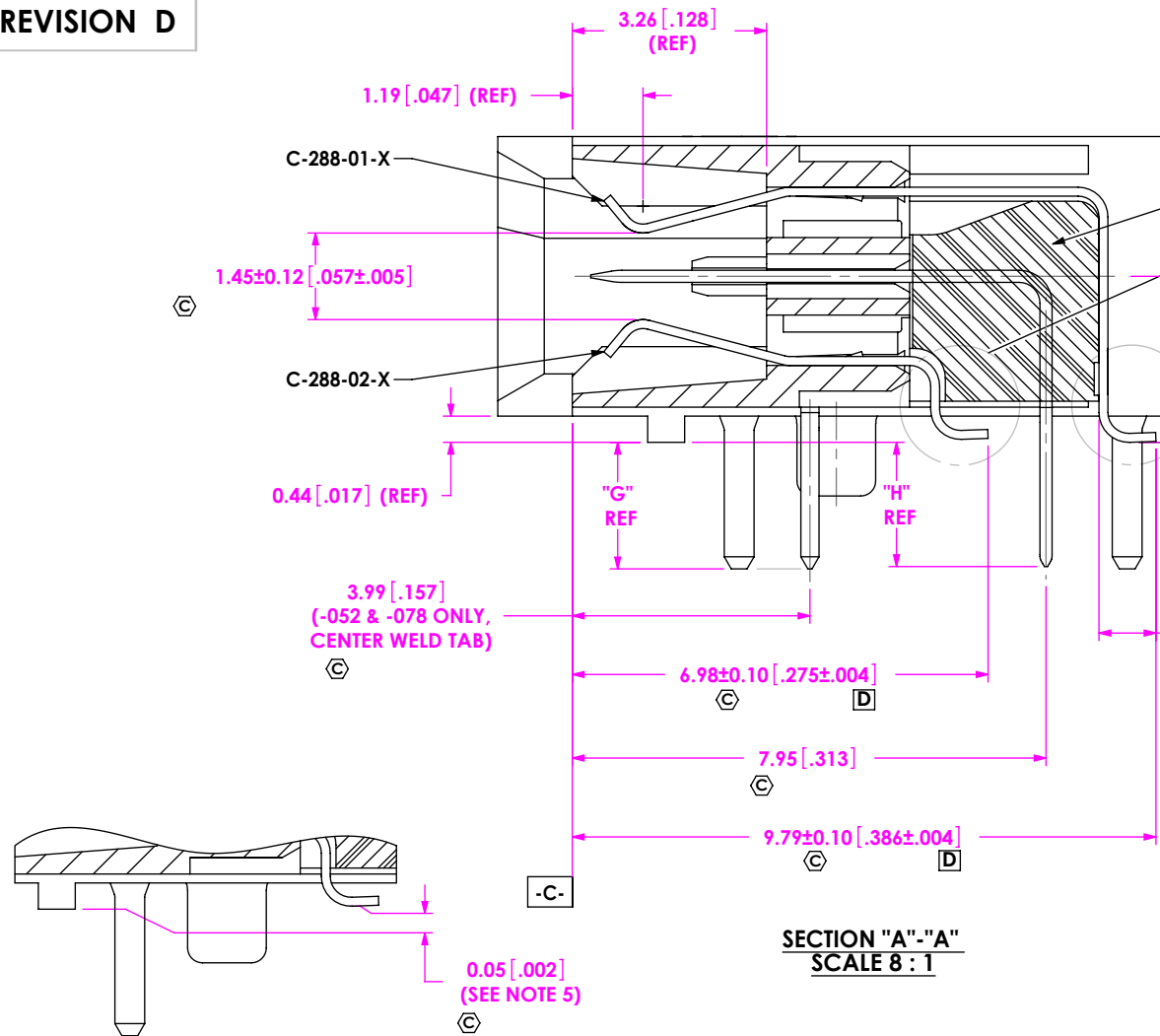
DESCRIPTION:

0.8mm Q-RATE RIGHT ANGLE SOCKET ASSEMBLY

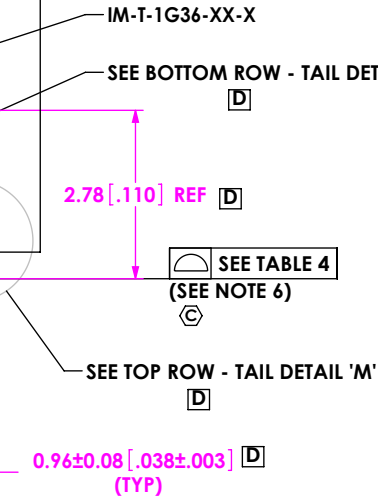
DWG. NO.

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

BY: R MUSSER 09/19/2008 SHEET 1 OF 5



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



TOP ROW - TAIL DETAIL 'M'
(LOCATE ASSY ON DATUM -C- FOR MEASUREMENTS)

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]

TABLE 3		
LEAD STYLE	"G"	"H"
-01	1.33 [0.052]	1.29 [0.051]
*-02	2.12 [0.083]	2.08 [0.082]

(* = NOT TOOLED)

SEE TABLE 4
(SEE NOTE 6)

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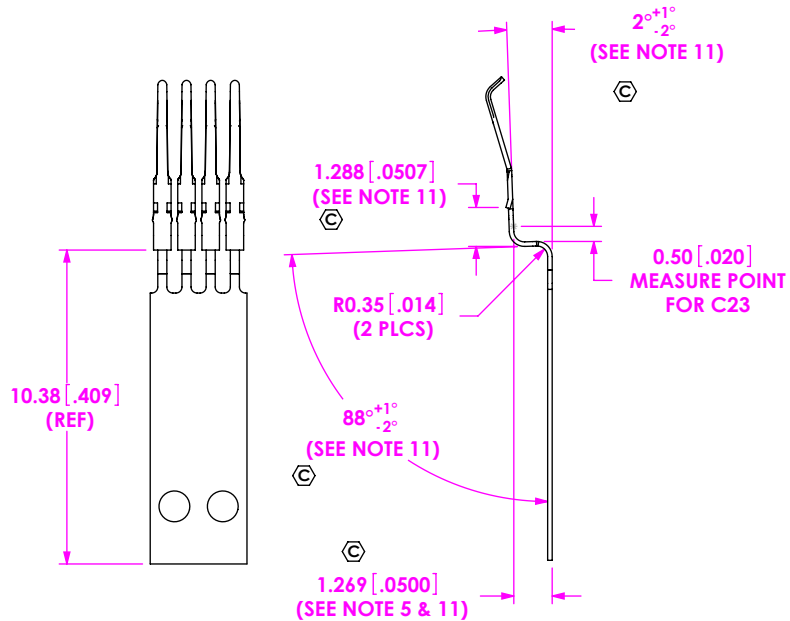
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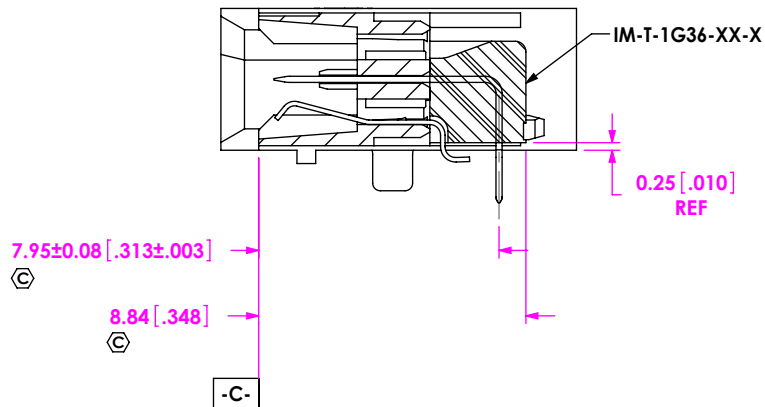
DWG. NO.
QRF8-XXX-XX-X-RA-GP-XX

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REVISION D

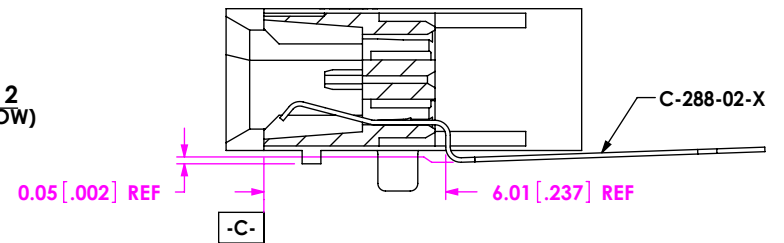


IN PROCESS 1
D (FORM CONTACT C-288-02-X)



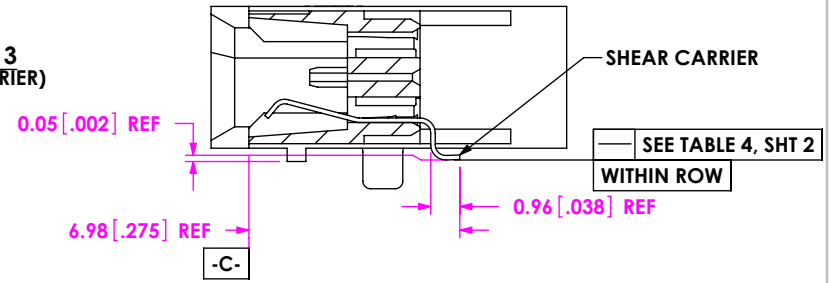
IN PROCESS 4
D (FILL OVER MOLDED GROUND PLANE)
 (IM-T-1G36-XX-X)

IN PROCESS 2
 (FILL BOTTOM ROW)



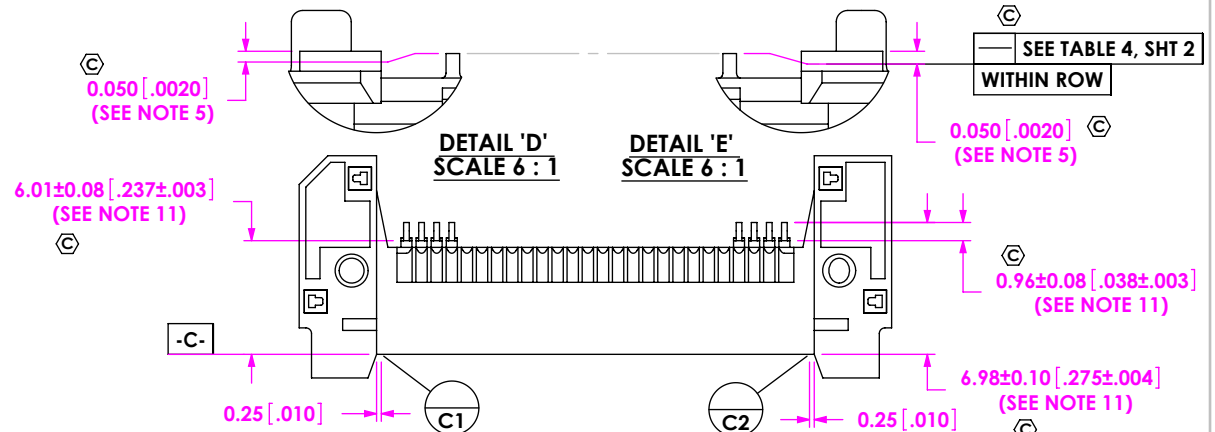
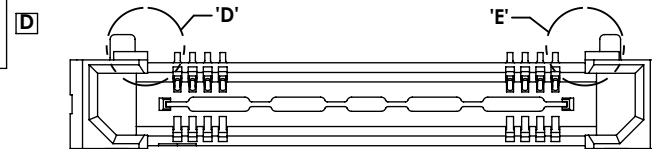
(SEE INSPECTION VIEW 1 FOR ASSEMBLY ORIENTATION AND CPC'S)

IN PROCESS 3
 (CUTOFF OF CARRIER)



(SEE INSPECTION VIEW 1 FOR ASSEMBLY ORIENTATION AND CPC'S)

INSPECTION VIEW 1
 (SEE NOTE 12)



INSPECTION FOR IN PROCESS 2 & 3
 (CARRIER NOT SHOWN FOR IN PROCESS 2 INSPECTIONS)

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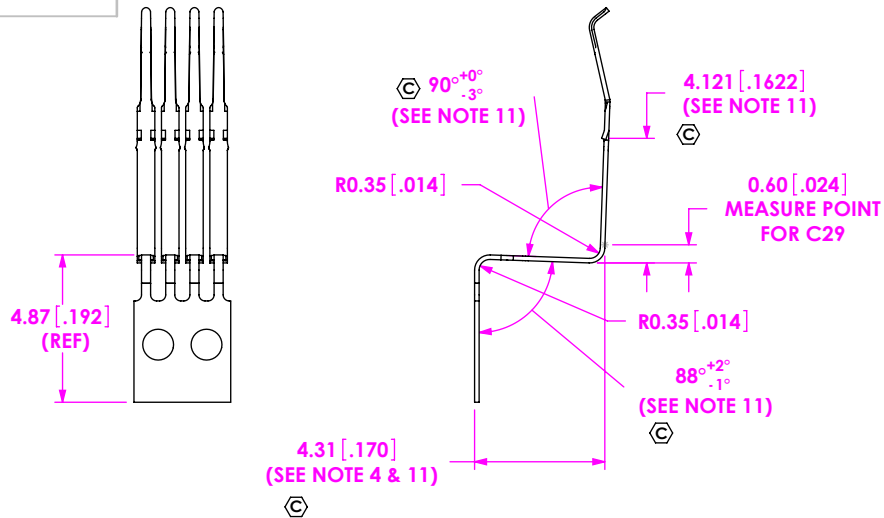
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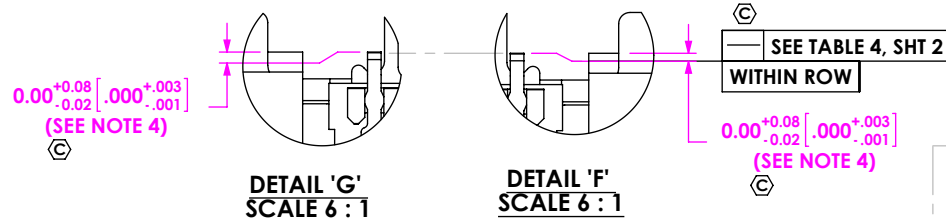
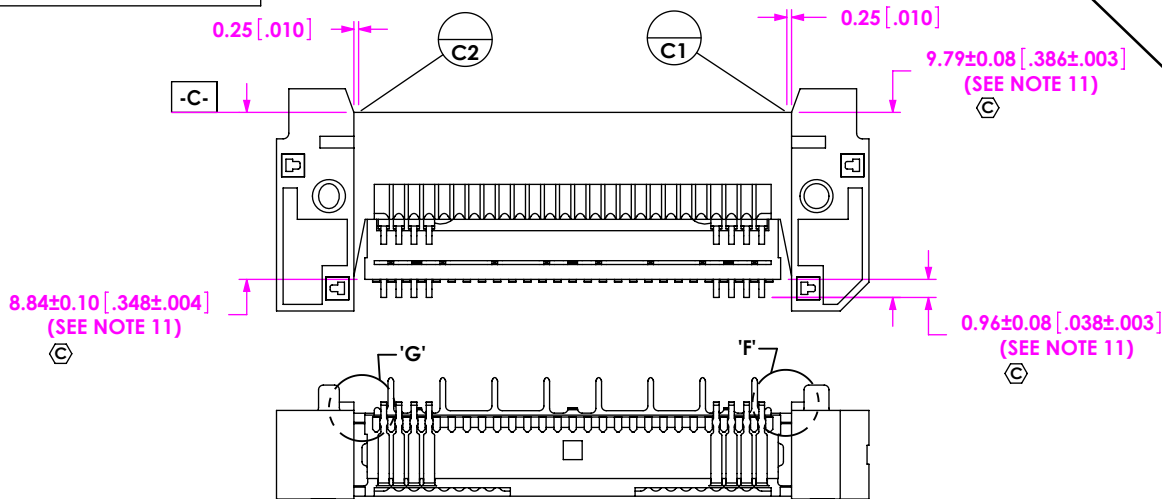
BY: R MUSSER 09/19/2008 SHEET 3 OF 5

REVISION D



IN PROCESS 5
D (FORM CONTACT C-288-01-X)

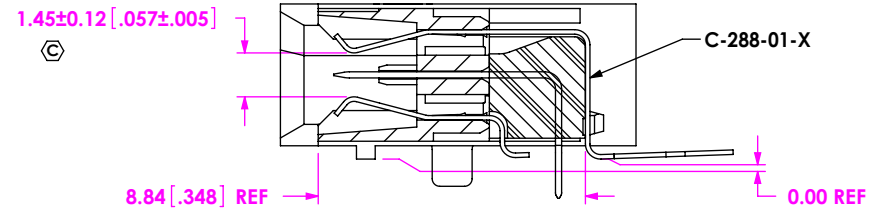
INSPECTION VIEW 2 (SEE NOTE 12)



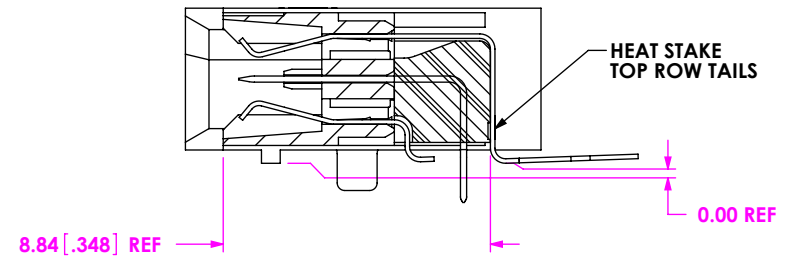
DETAIL 'G'
SCALE 6:1

DETAIL 'F'
SCALE 6:1

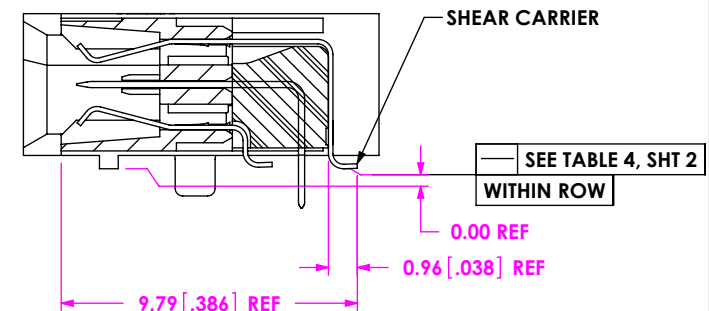
INSPECTION FOR IN PROCESS 6, 7 & 8
(CARRIER NOT SHOWN FOR IN PROCESS 6 INSPECTIONS)



IN PROCESS 6
(FILL TOP ROW)
(SEE INSPECTION VIEW 2 FOR ASSEMBLY ORIENTATION AND CPC'S)



IN PROCESS 7
D (HEAT STAKE TOP ROW CONTACTS)
(SEE INSPECTION VIEW 2 FOR ASSEMBLY ORIENTATION AND CPC'S)



IN PROCESS 8
D (CUTOFF OF CARRIER)
(SEE INSPECTION VIEW 2 FOR ASSEMBLY ORIENTATION AND CPC'S)

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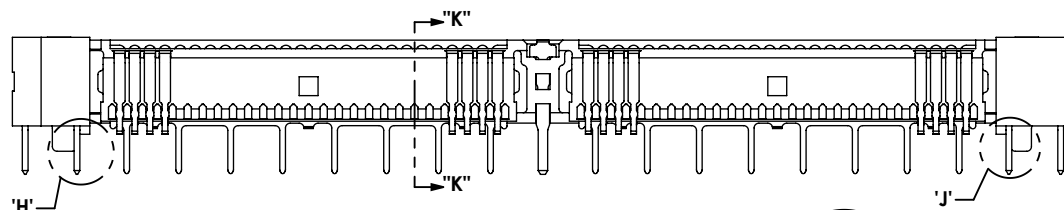
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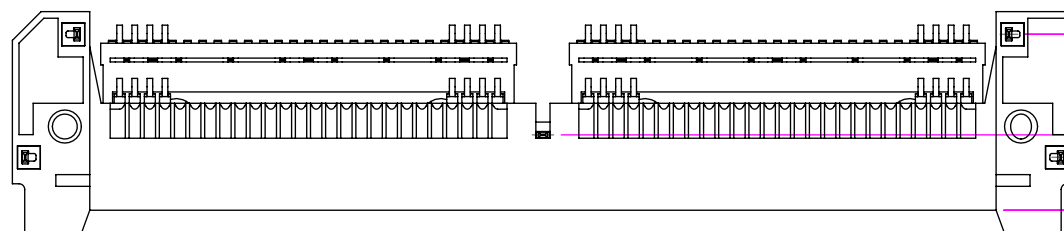
DWG. NO.
QRF8-XXX-XX-X-RA-GP-XX

BY: R MUSSER 09/19/2008 SHEET 4 OF 5

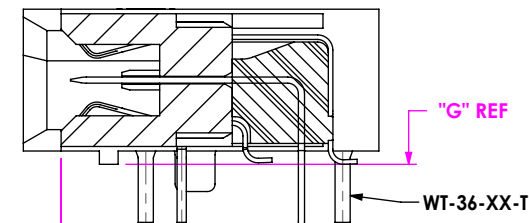


DETAIL 'H'
SCALE 5 : 1

DETAIL 'J'
SCALE 5 : 1



IN PROCESS 9
(FILL WELD TAB)
(WT-36-XX-T)



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

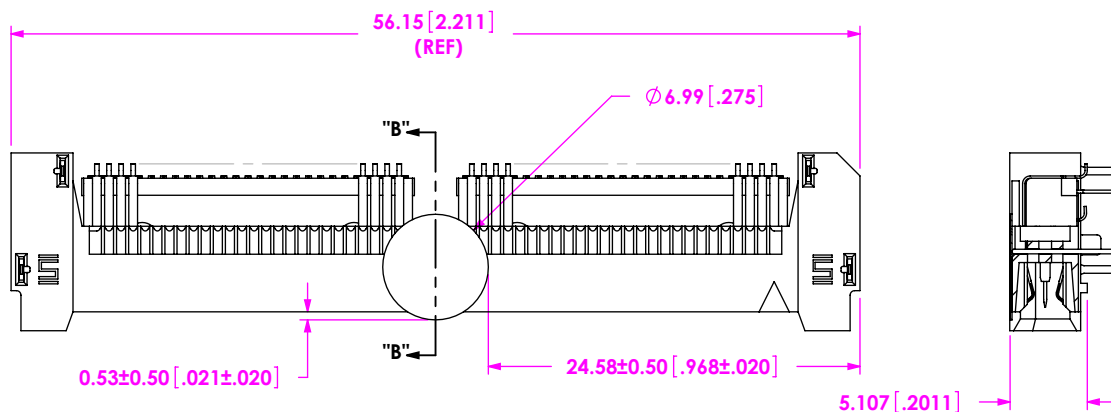


FIG 2
-K OPTION
(USE K-500-300)
(ONLY FOR QRF8-052-02-X-RA-GP-K SHOWN)
(SOME DETAIL REMOVED FOR CLARITY)

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

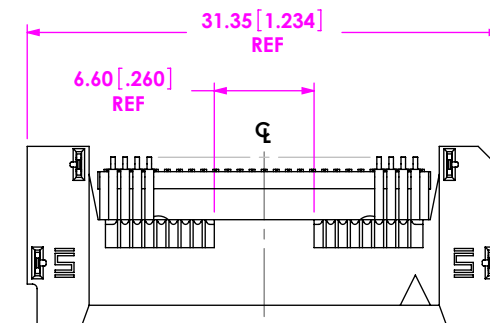


FIG 3
(QRF8-026-02-X-RA-GP SHOWN)
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