

NOTES:

1.  $\text{\textcircled{C}}$  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.

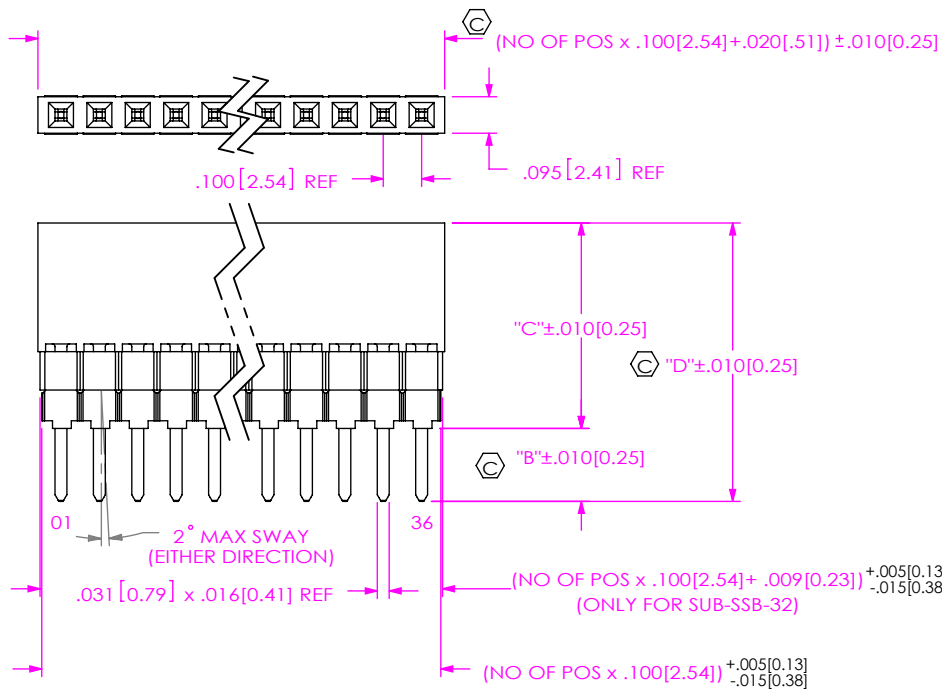


FIG 1  
ESW-1XX-XX-X-S SHOWN

TABLE 1

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

ESW-1XX-XX-X-X-XX-XX

CONTACT STYLE

SOLDER TAIL  
STANDARD INSERTION USE C-8-X-X  
LOW INSERTION USE C-17-X-X  
(SEE TABLE 1)

BODY LENGTH SPEC

POSITIONS 01 THRU 36 (SEE FIG 1)  
(SEE NOTE 4 FOR ONE POSITION SINGLE ROW)  
(FOR 33 POS, SEE NOTE 6)

LEAD STYLE SPECIFICATION

(SEE TABLE 1)

POLARIZING OPTION

INDICATES POS  
(SEE FIG 3, SHT 2)

LOCKING LEAD OPTION

-LL (SEE FIG 4, SHT 2)  
(N/A ON 1 OR 2 POSITION SINGLE ROW)

ROW SPECIFICATION

-S: SINGLE (USE SSW-50-S)  
-D: DOUBLE (USE SSW-50-D)

PLATING SPECIFICATION

- 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.

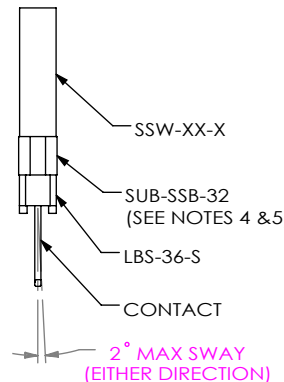
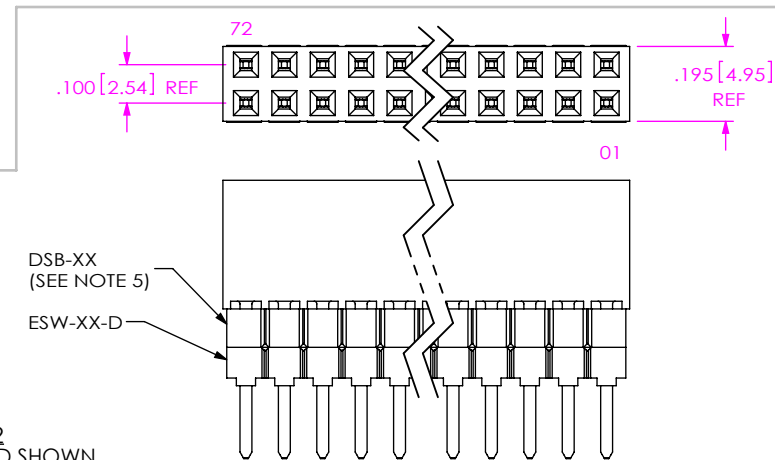


FIG 2  
ESW-1XX-XX-X-D SHOWN



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

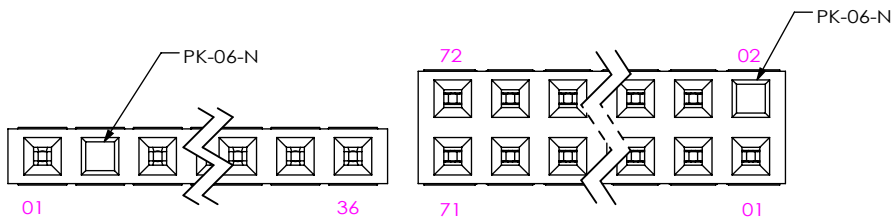
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**MATERIAL:** DO NOT SCALE DRAWING SHEET SCALE: 2:1  
SSW: LCP, UL 94 V0, COLOR: BLACK  
SSB, ESS, DSB: PBT, UL 94 V0, COLOR: BLACK  
LBS: HTN, UL 94 V0, COLOR: BLACK  
CONTACT: PHOS BRONZE

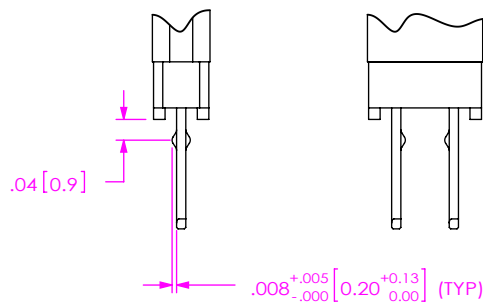


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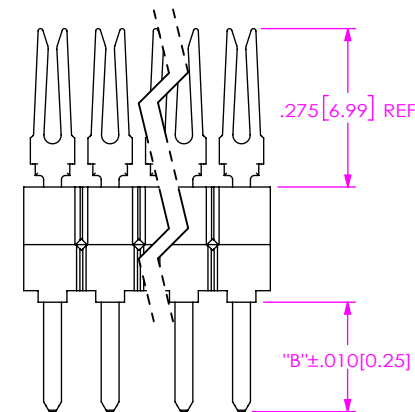
DESCRIPTION:  
ESW STRIP ASM.  
DWG. NO.  
**ESW-1XX-XX-X-X-XX-XX**  
BY: JORDAN 07/16/1985 SHEET 1 OF 2



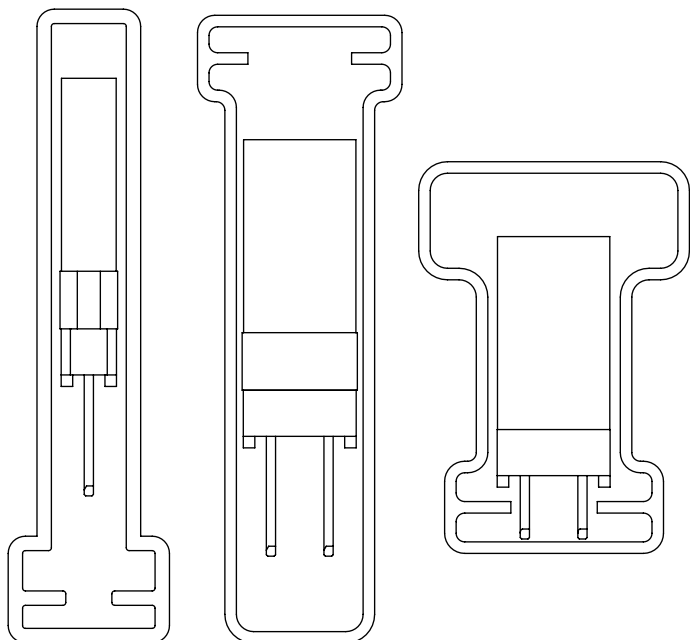
**FIG 3**  
POLARIZATION LOCATION  
INSERT PK-06-N INTO SPECIFIED POS AND BREAK OFF TAB  
(ESW-1XX-XX-X-X-02 SHOWN)  
(SAME AS FIG 1, DIFFERENT AS SHOWN)



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

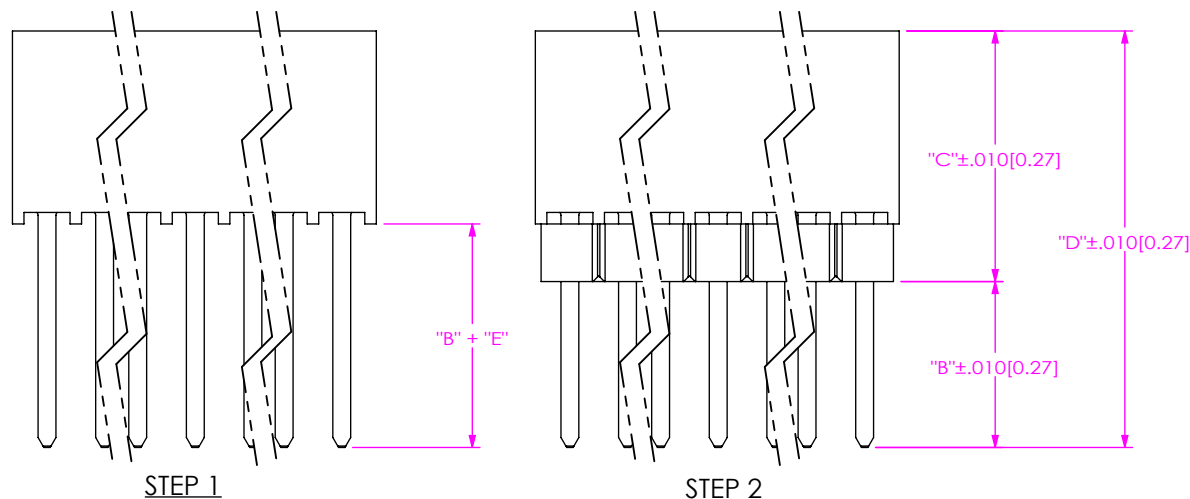


**FIG 5**  
IN PROCESS 'A'  
(LEAD STYLES -13, -14, -23, -24, -33, -34, -44, -38, -39, -48, -49, -58, -59, -69)



**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.



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

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

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-07

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DESCRIPTION:  
ESW STRIP ASM.

DWG. NO.  
**ESW-1XX-XX-X-X-XX-XX**

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