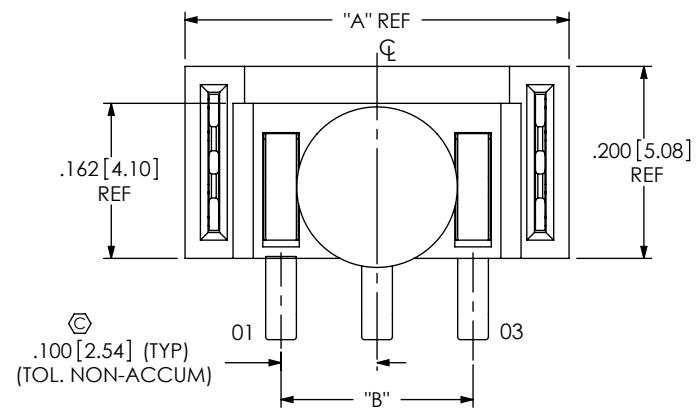


DO NOT SCALE FROM THIS PRINT



DESIGNED & DIMENSIONED IN INCHES[MILLIMETERS]

SIR1-XX-X-S-X-X-XX

No OF POSITIONS
-03, -05, -07, -10, -15,
*20, *25, *30
(PER ROW)

PACKAGING
-TR: TAPE & REEL FOR OPTIONAL

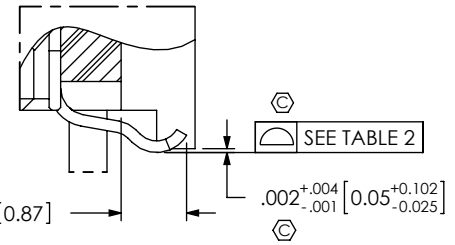
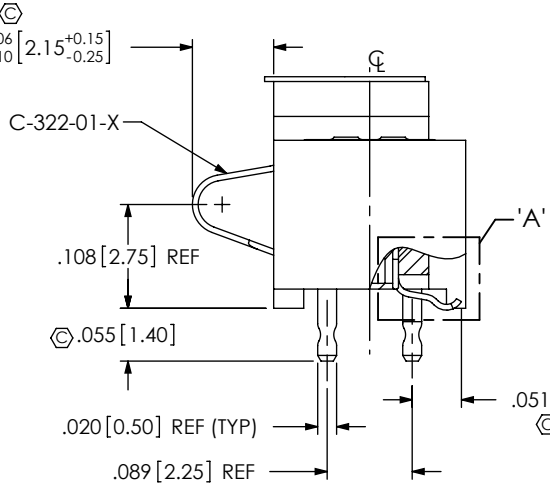
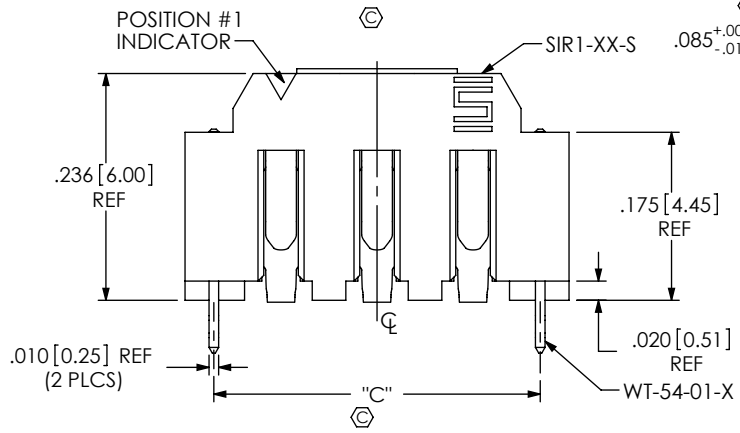
PLATING SPECIFICATION
-L: 10μ" GOLD IN CONTACT AREA,
MATTE TIN ON TAIL
-S: 30μ" GOLD IN CONTACT AREA,
MATTE TIN ON TAIL

OPTION
-A: ALIGNMENT PIN
(USE SIR1-XX-A-X)
-K: POLYAMIDE FILM
(USE K-DOT-.157-.250-.005,
SEE FIG. 3, SHT 2)

ROW SPECIFICATION
-S: SINGLE ROW

THREADED INSERT OPTION
*E: THREADED INSERT (ENGLISH)
(USE INS-14-2-56-115.)
*M: THREADED INSERT (METRIC)
(USE INS-14-M2-115-N)

(* = NOT TOOLED)



DETAIL 'A'
SCALE 10:1

TABLE 2	
No. OF POS	COPLANARITY
-03, -05, -07, -10, -15	.0040 [0.102]
*20, *25, & *30	.0060 [0.152]

(* = NOT TOOLED)

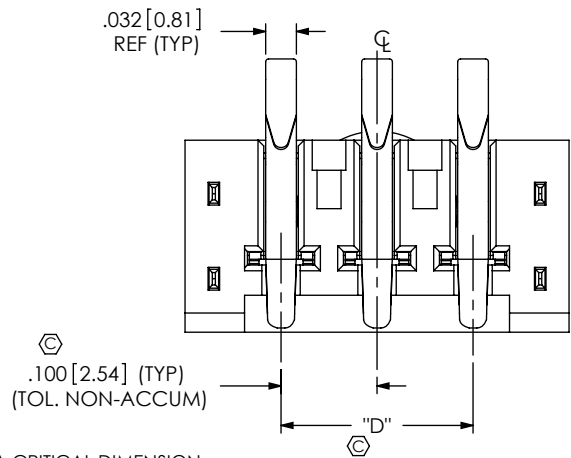


FIG 1
SIR1-03-X-S SHOWN
(FOR POSITIONS -03, -05, -10, & -15)

TABLE 1							
No. OF POS	"A"	"B"	"C"	"D"	"E"	"F"	"G"
-03	.400 [10.16]	2.000 [5.080]	.340 [8.64]	2.000 [5.080]	N/A	N/A	N/A
-05	.600 [15.24]	4.000 [10.160]	.540 [13.72]	4.000 [10.160]	N/A	N/A	N/A
-07	.800 [20.32]	6.000 [15.240]	.740 [18.80]	6.000 [15.240]	N/A	N/A	N/A
-10	1.100 [27.94]	9.000 [22.860]	1.040 [26.42]	9.000 [22.860]	N/A	N/A	N/A
-15	1.600 [40.64]	1.4000 [35.560]	1.540 [39.12]	1.4000 [35.560]	N/A	N/A	N/A
*20	2.200 [55.88]	2.0000 [50.800]	2.140 [54.36]	2.0000 [50.800]	1.0700 [27.178]	1.1000 [27.940]	.9000 [22.860]
*25	2.700 [68.58]	2.5000 [63.500]	2.640 [67.06]	2.5000 [63.500]	1.3700 [34.798]	1.4000 [35.560]	1.2000 [30.480]
*30	3.200 [81.28]	3.0000 [76.200]	3.140 [79.76]	3.0000 [76.200]	1.5700 [39.878]	1.6000 [40.640]	1.4000 [35.560]

(* = NOT TOOLED)

NOTES:

- ⊕ REPRESENTS A CRITICAL DIMENSION.
- BURR ALLOWANCE: .0015[0.038] MAX.
- MINIMUM PUSHOUT FORCE: .5 LB[2.2 N].
- LOAD INSERTS IN DIRECTION OF THE ARROW USING HAND LOAD THERMAL INSERTION PRESS.
- THREADED INSERT MUST BE ABLE TO HANDLE 20 in-oz'S OF TORQUE MIN WITHOUT ROTATING OR "LOOSENING".
- THREADED INSERT RETENSION TO BE 7lbs. MIN.
- THREADED INSERT TO BE FLUSH TO .005[0.13] BELOW HOUSING SURFACE.
- NOTE DELETED.
- ASSEMBLIES TO BE PACKAGED IN TUBES, UNLESS -TR IS SPECIFIED.

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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520 PARK EAST BLVD, NEW ALBANY, IN 47150
PHONE: 812-944-6733 FAX: 812-948-5047
e-Mail: info@SAMTEC.com code 55322

MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 5:1
INSULATOR: LCP, COLOR: BLACK
CONTACT: PHOS BRONZE
WELD TAB: PHOS BRONZE

DESCRIPTION:
ONE PIECE POWER RIGHT ANGLE ASSEMBLY
DWG. NO.
SIR1-XX-X-S-X-X-XX

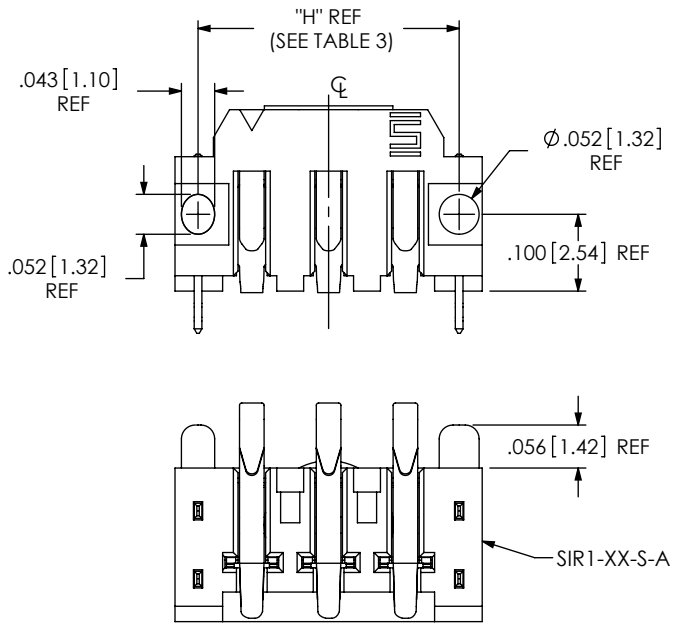
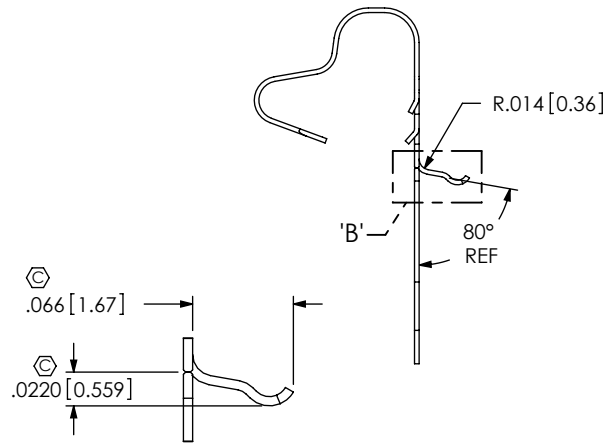
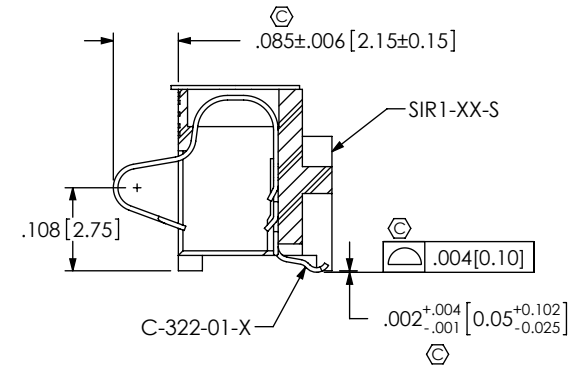


FIG 2
(SIR1-03-X-S-A SHOWN)
(SAME AS FIG 1, EXCEPT AS SHOWN)



DETAIL 'B'
SCALE 8 : 1
IN-PROCESS 1
(FORM CONTACT C-322-01-X)



IN-PROCESS 2
(FILL CONTACT C-322-01-X)

TABLE 3

No. OF POS	"H"	"J"
-03	.3400 [8.636]	.122 [3.10]
-05	.5400 [13.716]	.222 [5.64]
-07	.7400 [18.796]	.322 [8.18]
-10	1.0400 [26.416]	.472 [11.99]
-15	1.5400 [39.116]	.722 [18.34]
*-20	2.1400 [54.356]	1.022 [25.96]
*-25	2.6400 [67.056]	1.272 [32.31]
*-30	3.1400 [79.756]	1.522 [38.66]

(* = NOT TOOLED)

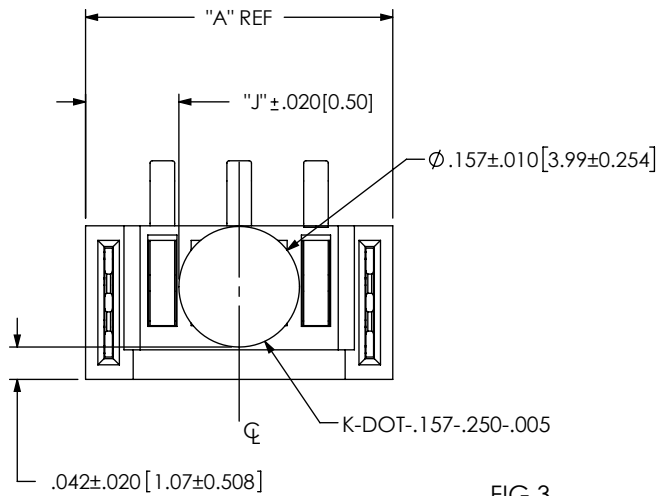
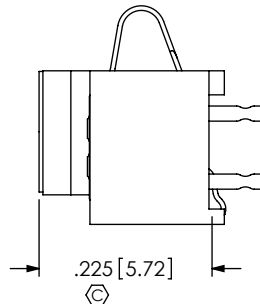


FIG 3
(SIR1-03-X-S-K SHOWN)
(SAME AS FIG 1, EXCEPT AS SHOWN)



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DO NOT SCALE DRAWING
SHEET SCALE: 4:1



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DESCRIPTION:
ONE PIECE POWER RIGHT ANGLE ASSEMBLY

DWG. NO.
SIR1-XX-X-S-X-X-XX

BY: ROY LUO 5/20/2010 SHEET 2 OF 4

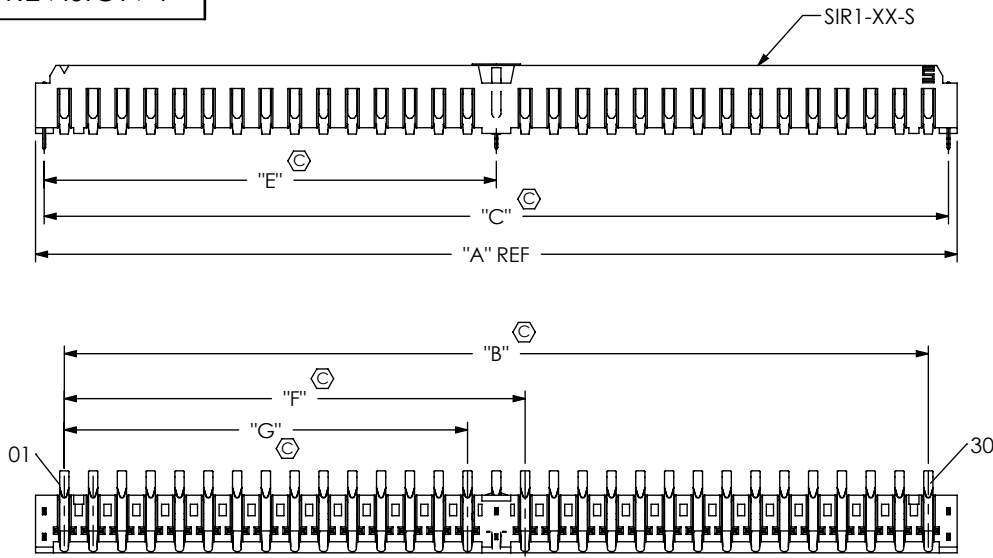


FIG 4
(SIR1-30-X-S SHOWN)
(SAME AS FIG 1, EXCEPT AS SHOWN)
(FOR POSITIONS -20, -25, & -30)
(NOT TOOLED)

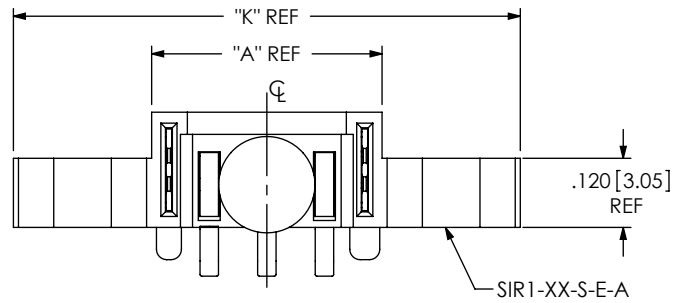
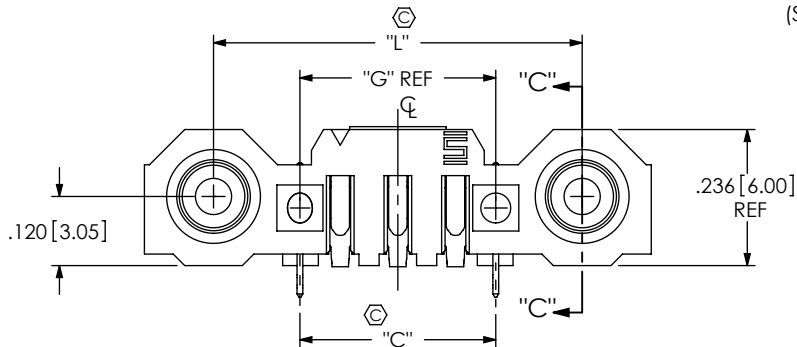


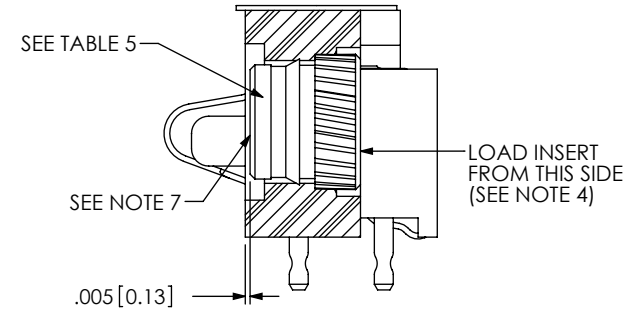
FIG 5
-E & -M OPTION
(SIR1-03-X-S-X-A SHOWN)
(SAME AS FIG 2, EXCEPT AS SHOWN)
(NOT TOOLED)



No. OF POS	"K"	"L"
-03	.880 [22.352]	.640 [16.26]
-05	1.080 [27.432]	.840 [21.34]
-07	1.280 [32.512]	1.040 [26.42]
-10	1.580 [40.132]	1.340 [34.04]
-15	2.080 [52.832]	1.840 [46.74]
-20	2.680 [68.072]	2.440 [61.98]
-25	3.180 [80.772]	2.940 [74.68]
-30	3.680 [93.472]	3.440 [87.38]

OPTION	THREADED INSERT
-E	INS-14-2-56-115
** -M	INS-14-M2-115-N

** = METRIC THREADED INSERTS
TO BE FLASH NICKEL PLATED



SECTION "C"-"C"
SCALE 5 : 1

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SHEET SCALE: 3:1

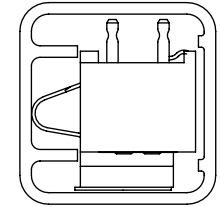
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DESCRIPTION:
ONE PIECE POWER RIGHT ANGLE ASSEMBLY

DWG. NO. SIR1-XX-X-S-X-X-XX

BY: ROY LUO 5/20/2010 SHEET 3 OF 4



PACKAGING VIEW
 TUBE: PT-1-24-11-63
 PLUG: TP-09

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SHEET SCALE: 3:1

DESCRIPTION:
 ONE PIECE POWER RIGHT ANGLE ASSEMBLY

DWG. NO. SIR1-XX-X-S-X-X-XX

BY: ROY LUO 5/20/2010 SHEET 4 OF 4