

DO NOT SCALE FROM THIS PRINT

TABLE 2	
BODY SPECIFICATION	
ROW/OPTION	USE BODY
-S, -S-NA/-NE	HTSW-50-S-LCP
-S-RA/-S-RE	HTSW-50-SRA-LCP
-D, -D-NA/-NE	HTSW-50-D-LCP
-D-RA	HTSW-50-DRA-LCP
-T, -T-NA/-NE	HTSW-50-T-LCP
-T-RA, -Q-RA	HTSW-50-TRA-LCP
-Q	HTSW-50-T-LCP

HTSW-XXX-XX-XXX-X-XX-XX-XX

TERMINAL SPACE SPEC
 -1= .100 [2.54] (FILL EVERY POSITION)
 -2= .200 [5.08] (FILL EVERY OTHER POSITION STARTING WITH THE 1st AND ENDING WITH THE LAST POSITION IN BODY)

NUMBER OF POSITIONS
 -1: -01 THRU -50
 "A"= NUMBER OF POS x .100[2.54]
 -2: -.02 THRU -.25
 "A"= (NUMBER OF POS x .200[5.08])-.100[2.54]

LEAD STYLE
 SEE TABLE 1, SHT 6

OPTION 3
 *-MW: METAL WASHER (STRAIGHT TAIL OPTION ONLY) (AVAILABLE ON 05, 06, 07, 08, 16, 17, 18, 22, 23,24, 25, 41 & 42 LEAD STYLES ONLY) (N/A WITH -LC OPTION. 20 POS MIN, 30 POS MAX. SEE FIG 6, SHT 5)

OPTION 2
 -POLARIZING SPECIFICATION
 XXX INDICATES POS TO BE OMITTED

OPTION 1
 -BLANK: STRAIGHT (SEE FIG 1, SHT 2)
 -RA: RIGHT ANGLE (SEE TABLE 3 & 4, FIG 5, SHT 4)
 -RE: EXTENDED RIGHT ANGLE (SEE TABLE 3 & 4, FIG 5, SHT 4) (SINGLE ROW ONLY)
 -NA: RA OPTION WITH STRAIGHT OPTION BODY (SEE TABLE 3 & 4, FIG 5, SHT 4)
 -NE: RE OPTION WITH STRAIGHT OPTION BODY (SEE TABLE 3 & 4, FIG 5, SHT 4)
 -LC: LOCKING CLIP (4 POS MINIMUM; ONLY AVAILABLE ON: LEAD STYLES -08 THRU -13 & -22, WITH ROW OPTIONS -S & -D; N/A WITH -MW, -RA OR -RE OPTIONS; SEE FIG 2, SHT 2)
 -LA: -RA OPTION WITH -LL OPTION (SEE SHT 3)
 -LL: LOCKING LEAD (SEE FIG 4, SHT 3) (N/A WITH -RE OR -NE OPTIONS) (N/A IN SINGLE ROW, 1 OR 2 POSITIONS)

ROW SPECIFICATION (SEE TABLE 2)
 -S: SINGLE
 -D: DOUBLE
 -T: TRIPLE
 -Q: TRIPLE ROW, FILL OUTER ROWS ONLY

PLATING SPECIFICATIONS
 -G: 10µ" GOLD IN CONTACT AREA, 3µ" GOLD ON TAIL
 -T: MATTE TIN CONTACT AND TAIL
 -S: 30µ" SELECTIVE GOLD IN CONTACT AREA, MATTE TIN ON TAIL
 -H: 30µ" HEAVY GOLD IN CONTACT AREA, 3µ" GOLD ON TAIL
 -L: 10µ" LIGHT SELECTIVE GOLD IN CONTACT AREA, MATTE TIN ON TAIL
 -F: 3µ" FLASH SELECTIVE GOLD IN CONTACT AREA, MATTE TIN ON TAIL
 -E: 50µ" EXTRA HEAVY GOLD IN CONTACT AREA, 3µ" GOLD ON TAIL (AVAILABLE ON LEAD STYLES -07, -08, -09 STRAIGHT AND -08-D-RA)
 -TL: TIN/LEAD (90/10 ±5%) CONTACT AND TAIL, (AVAILABLE ONLY ON LEAD STYLES -07, -08 & -09)
 -TM: MATTE TIN CONTACT AND TAIL
 -SM: 30µ" SELECTIVE GOLD IN CONTACT AREA, MATTE TIN ON TAIL
 -LM: 10µ" LIGHT SELECTIVE GOLD IN CONTACT AREA, MATTE TIN ON TAIL
 -FM: 3µ" FLASH SELECTIVE GOLD IN CONTACT AREA, MATTE TIN ON TAIL
 -STL: 30µ" SELECTIVE GOLD IN CONTACT AREA, TIN/LEAD (90/10 ±5%) TAIL
 -LTL: 10µ" LIGHT SELECTIVE GOLD IN CONTACT AREA, TIN/LEAD (90/10 +/-5%) TAIL, (AVAILABLE ONLY ON LEAD STYLE -15)
 -SS: 30µ" STRIPE SELECTIVE GOLD IN CONTACT AREA, MATTE TIN ON TAIL, (SEE NOTE 9)

*** - MW OPTION, DO NOT DESIGN IN. SAMTEC WILL ONLY SUPPORT EXISTING BUSINESS 2/12/02.**

CRITICAL DIMENSION INSPECTION INSTRUCTION TABLE	
ASSEMBLY OPERATION	IN-PROCESS INSPECTION
FILL	C1
MULTI-CUT	C2
RIGHT ANGLE	C4
RIGHT ANGLE	C5
RIGHT ANGLE	C6
CRIMP	C7
CPCs INTENTIONALLY DELETED:	C3

NOTES:

- ⊙ REPRESENTS CRITICAL DIMENSION FOR STATISTICAL PROCESS CONTROL.
- MINIMUM TERMINAL PUSHOUT FORCE: 3 LBS.
- MAXIMUM HEIGHT VARIATION: .005[.127] (N/A ON -RA TAIL).
- ASSEMBLE GOLD PLATE END AS SHOWN IN FIG 1.
- STYLE -26: ROUND END OF PIN TO APPEAR ON BOTTOM (SEE FIG 7, SHT 6).
- MINIMUM GOLD PLATED CONTACT AREA: .165[4.19] REF; PINS -18, -21 & -25: .050[1.27] REF.
- CRIMP TWO PINS CLOSEST TO CENTER OF THE PART IF THERE IS A POLARIZED POSITION IN THE MIDDLE/CENTER.
- MAXIMUM CUT FLASH: .010 [.25].
- SS PLATING OPTION ONLY AVAILABLE ON -07, -08, -09 STRAIGHT AND -08 -RA LEAD STYLES. MATES WITH SSQ, SSW, SSM, BCS, ESQ & ESW.
- MEASURE FROM THE BEND RADIUS OF THE TERMINALS.
- ORIENTATE PINS TO PREVENT BANDOLIER MARKS FROM SHOWING IN THE POST AREA. (SEE TABLE 6, SHT 7).

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE:
 DECIMALS ANGLES
 .XX: ±.01 [.25] 2°
 .XXX: ±.005 [.13]
 .XXXX: ±.0020 [.051]

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 e-Mail: info@SAMTEC.com code 55322

MATERIAL: DO NOT SCALE DRAWING
 INSULATOR: LCP, UL-94-V-0
 COLOR: NATURAL

SHEET SCALE: 3.5:1

DESCRIPTION:
 .025 SQ POST HI-TEMP TERMINAL STRIP ASSEMBLY

DWG. NO.
 HTSW-XXX-XX-XXX-X-XX-XX-XX

BY: PURVIS 02/17/87 SHEET 1 OF 7

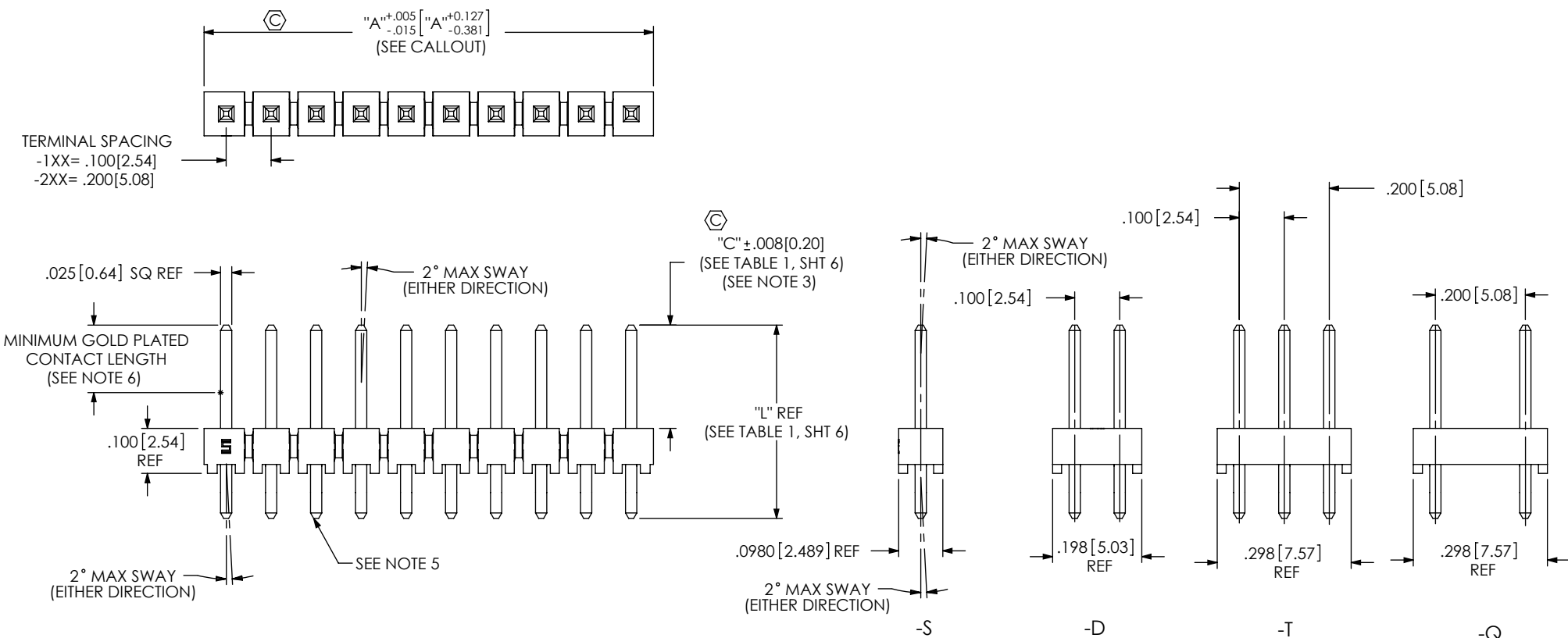


FIG 1
HTSW-110-07-XXX-D SHOWN

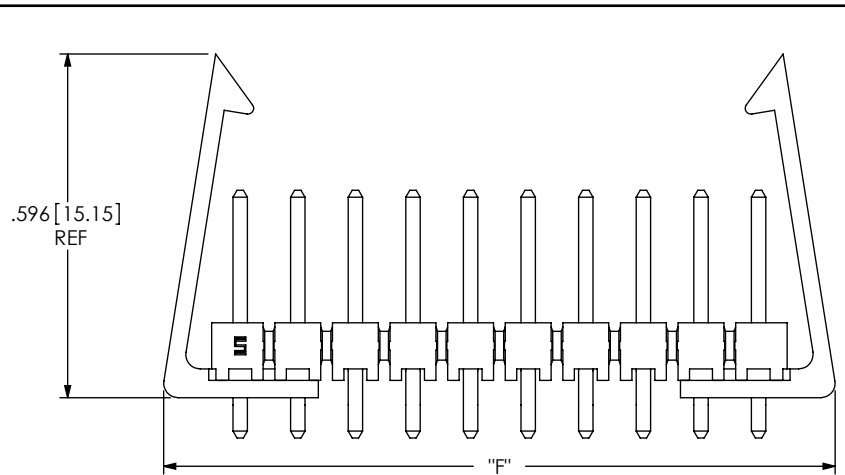


FIG 2: LOCKING CLIP
HTSW-110-07-XXX-D-LC SHOWN
(DIFFERENT AS SHOWN, OTHERWISE
SAME AS FIG 1)

TABLE 5: -LC OPTION

ROW	"F" +/- .015 [.38]	"G"	LATCH
-D	"A" + .210 [2.67]	.198 [5.03]	LTC-02
-S	"A" + .150 [3.81]	.098 [2.49]	LTC-01

F:\DWG\MISC\MKTG\HTSW-XXX-XX-XXX-X-XX-XX-XX-MKT.SLDDRW

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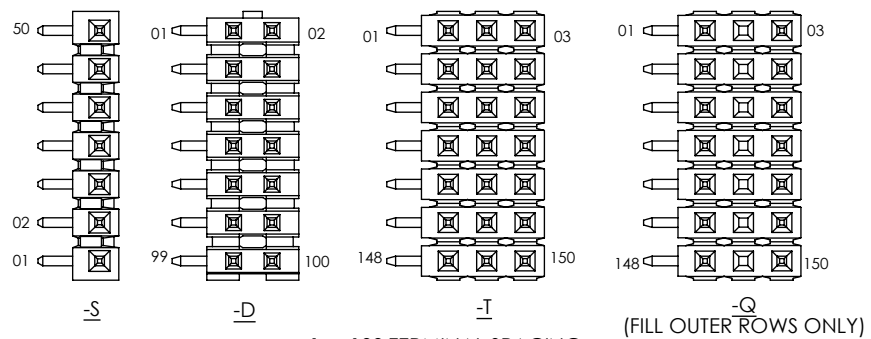
SHEET SCALE: 3:1



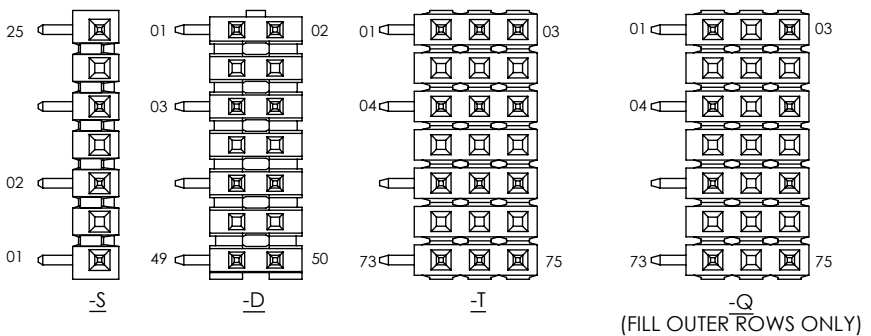
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.025 SQ POST HI-TEMP TERMINAL STRIP ASSEMBLY
DWG. NO.
HTSW-XXX-XX-XXX-X-XX-XX-XX
BY: PURVIS 02/17/87 SHEET 2 OF 7

FIG 3
TERMINAL SPACING
(DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG 1)

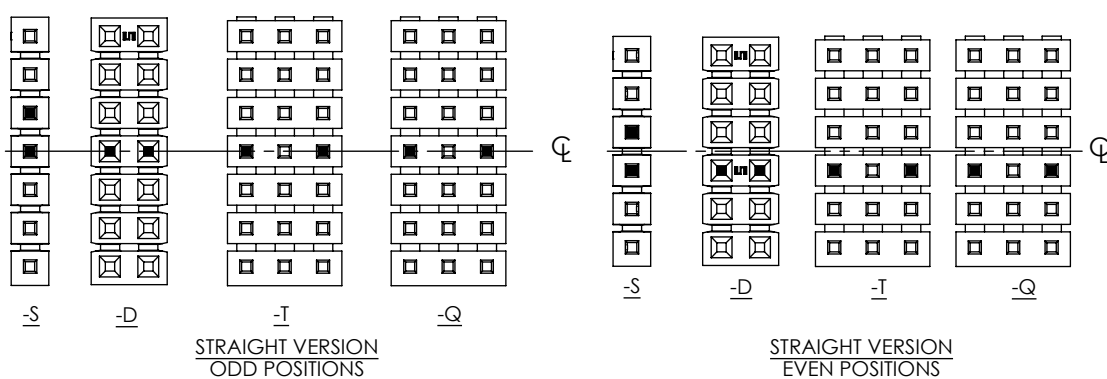
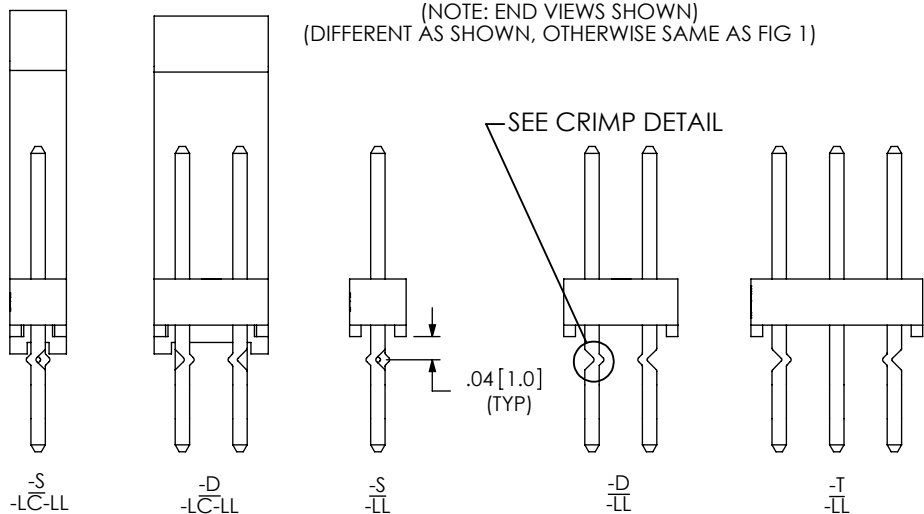


-1 = .100 TERMINAL SPACING



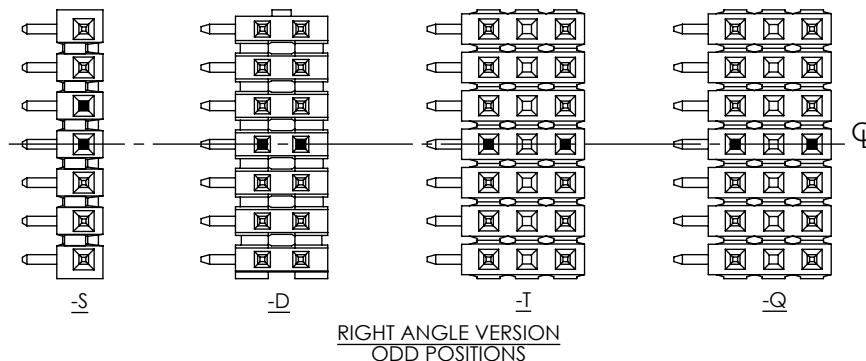
-2 = .200[5.08] TERMINAL SPACING

FIG 4
-LL: LOCKING LEAD
(NOTE: END VIEWS SHOWN)
(DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG 1)

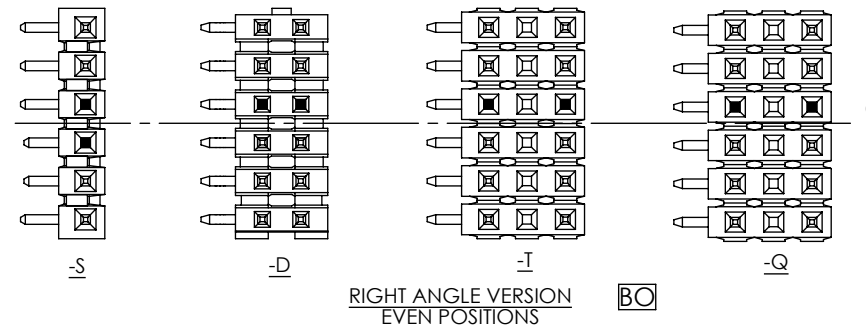


STRAIGHT VERSION
ODD POSITIONS

STRAIGHT VERSION
EVEN POSITIONS



RIGHT ANGLE VERSION
ODD POSITIONS



RIGHT ANGLE VERSION
EVEN POSITIONS

BO -LL: LOCKING LEAD

■ = CRIMP LOCATION

TWO CENTER MOST PINS TO BE CRIMPED AS SHOWN.

CRIMP DETAIL
SCALE: 2X
[TYP- ALL CRIMPS]

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HTSW-XXX-XX-XXX-X-XX-XX-XX

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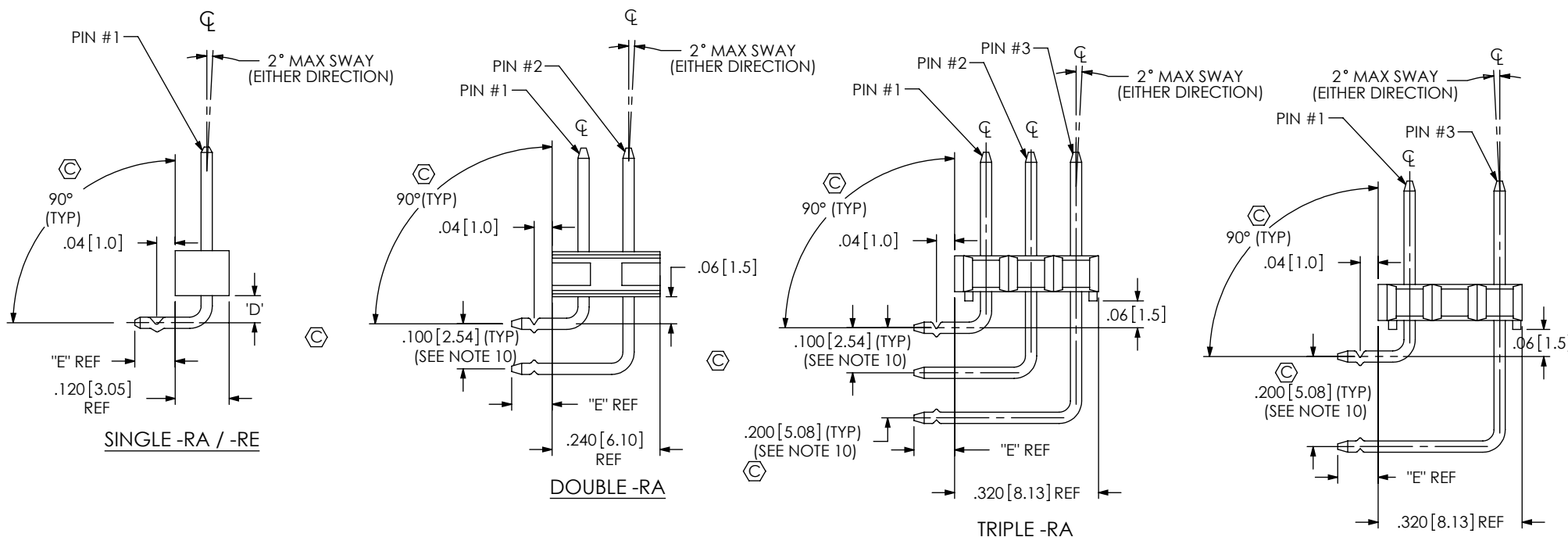


FIG 5
 -RA: RIGHT ANGLE
 (-LA OPTION IS SHOWN ON ALL -RA VIEWS FOR DIMENSIONAL PURPOSES) (SEE CRIMP DETAIL VIEW, SHT 3)
 (DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG 1)

TABLE 4 - "E"

LEAD STYLE	RA SINGLE	RE SINGLE	RA DOUBLE	RA TRIPLE	NA SINGLE	NE SINGLE	NA DOUBLE	NA TRIPLE
08	.090 [2.29]	N/A	.090 [2.29]	.090 [2.29]	.109 [2.77]	N/A	.109 [2.77]	.109 [2.77]
09	.290 [7.37]	.190 [4.83]	.290 [7.37]	.290 [7.37]	.309 [7.85]	.209 [5.31]	.309 [7.85]	.309 [7.85]
10	.390 [9.91]	.290 [7.37]	.390 [9.91]	.390 [9.91]	.409 [10.39]	.309 [7.85]	.409 [10.39]	.409 [10.39]
11	.490 [12.45]	.390 [9.91]	.490 [12.45]	.490 [12.45]	.509 [12.93]	.409 [10.39]	.509 [12.93]	.509 [12.93]
12	.590 [14.99]	.490 [12.45]	.590 [14.99]	.590 [14.99]	.609 [15.47]	.509 [12.93]	.609 [15.47]	.609 [15.47]
13	.790 [20.07]	.690 [17.53]	.790 [20.07]	N/A	.809 [20.55]	.709 [18.01]	.809 [20.55]	N/A
16	.200 [5.08]	.100 [2.54]	.200 [5.08]	.200 [5.08]	.219 [5.56]	.119 [3.02]	.219 [5.56]	.219 [5.56]
21	.990 [25.15]	.890 [22.61]	N/A	N/A	1.009 [25.63]	.909 [23.09]	N/A	N/A
22	.190 [4.83]	.090 [2.29]	.190 [4.83]	.190 [4.83]	.209 [5.31]	.109 [2.77]	.209 [5.31]	.209 [5.31]
25	.100 [2.54]	N/A	.100 [2.54]	.100 [2.54]	.119 [3.02]	N/A	.119 [3.02]	.119 [3.02]
27	.890 [22.61]	.790 [20.07]	N/A	N/A	.909 [23.09]	.809 [20.55]	N/A	N/A
28	.690 [17.53]	.590 [14.99]	.690 [17.53]	N/A	.709 [18.01]	.609 [15.47]	.709 [18.01]	N/A
29	.800 [20.32]	N/A	N/A	N/A	.819 [20.80]	N/A	N/A	N/A
30	.600 [15.24]	N/A	.600 [15.24]	N/A	.619 [15.72]	N/A	.619 [15.72]	N/A

TABLE 3

-XX	"D"
-RA / -NA	.06 [1.5]
-RE / -NE	.16 [4.1]

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 .025 SQ POST HI-TEMP TERMINAL STRIP ASSEMBLY
 DWG. NO.
HTSW-XXX-XX-XXX-X-XX-XX-XX
 BY: PURVIS 02/17/87 SHEET 4 OF 7

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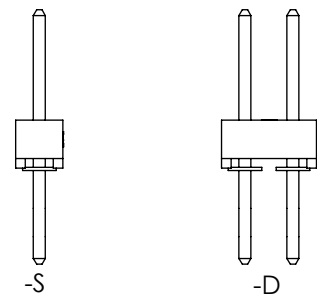
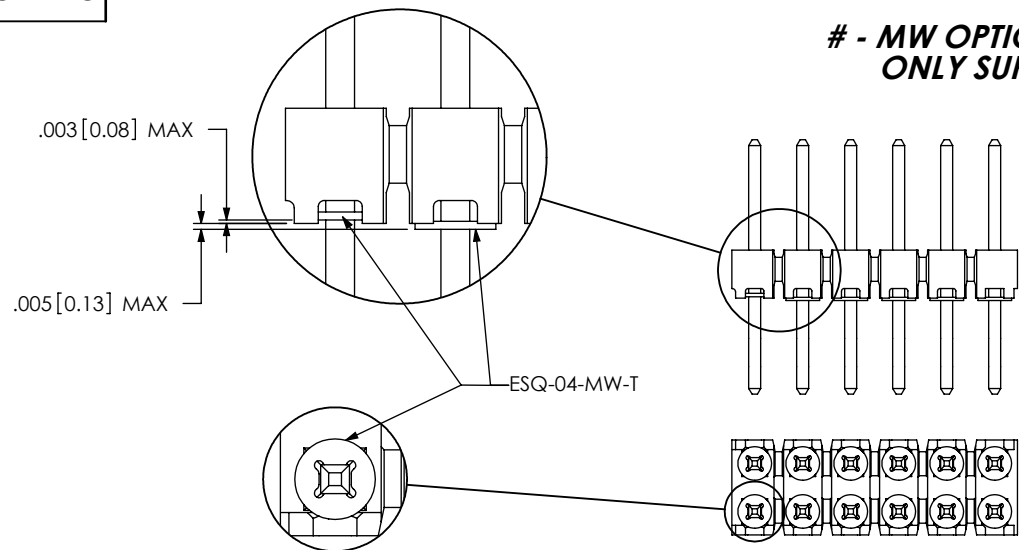
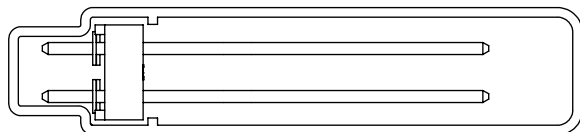
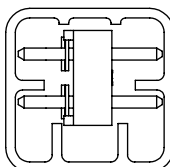


FIG 6
*-MW: METAL WASHER
(ONE PER POSITION)

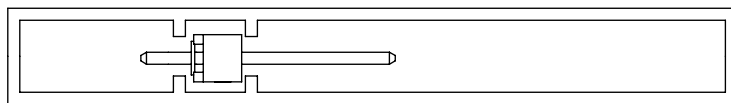
-MW OPTION TUBE TABLE			
STYLE	ROW	TUBE	PLUG
-XX	-S	PT-1-24-02-04	TP-24
-08 -16 -22 -25	-D	PT-1-24-03-29	TP-07
-05 -17 -18 -23 -24 -41 -42	-D	PT-1-24-08-03	TP-03
-06	-D	PT-1-24-01-63	TP-24-02
-07	-D	PT-1-24-01-22	TP-03
-XX	-T/-Q	PT-1-24-07-51	TP-07



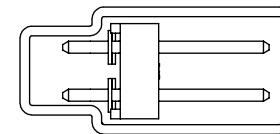
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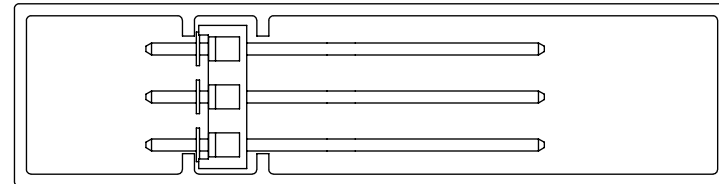
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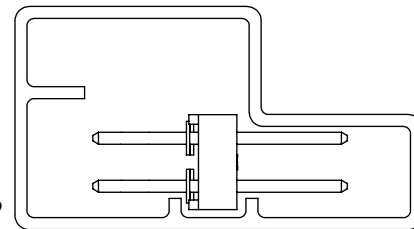
PT-1-24-02-04



PT-1-24-01-22



PT-1-24-07-51



PT-1-24-03-29

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.025 SQ POST HI-TEMP TERMINAL STRIP ASSEMBLY

DWG. NO.
HTSW-XXX-XX-XXX-X-XX-XX-XX

BY: PURVIS 02/17/87 SHEET 5 OF 7

TABLE 1
TERMINAL SPECIFICATIONS

TERMINAL SPEC	PN #1	"L"	PN #2 (2)	PN #3	"C"
-05 (3)	T-1S6-21-XXX-2	.335 [8.51]	N/A	N/A	.105 [2.67] (5)
-06 (3)	T-1S6-18-XXX-2	.300 [7.62]	N/A	N/A	.105 [2.67] (5)
-07 (3)	T-1S6-07-XXX-2	.430 [10.92]	N/A	N/A	.230 [5.84] (5)
-08 (4)	T-1S6-08-XXX-2	.530 [13.46]	T-1S6-09-XXX-2	T-1S6-11-XXX-2	.230 [5.84] (5) (6) (7)
-09	T-1S6-09-XXX-2	.730 [18.54]	T-1S6-11-XXX-2	T-1S6-20-XXX-2	.230 [5.84] (6)
-10	T-1S6-10-XXX-2	.830 [21.08]	T-1S6-12-XXX-2	T-1S6-13-XXX-2	.230 [5.84]
-11	T-1S6-11-XXX-2	.930 [23.62]	T-1S6-20-XXX-2	T-1S6-19-XXX-2	.230 [5.84]
-12	T-1S6-12-XXX-2	1.030 [26.16]	T-1S6-13-XXX-2	T-1S6-14-XXX-2	.230 [5.84]
-13	T-1S6-13-XXX-2	1.230 [31.24]	T-1S6-14-XXX-2	N/A	.230 [5.84]
-14 (3)	T-1S6-08-XXX-2	.530 [13.46]	N/A	N/A	.320 [8.13] (5)
-15 (3)	T-1S6-09-XXX-2	.730 [18.54]	N/A	N/A	.520 [13.21] (5)
-16	T-1S6-09-XXX-2	.730 [18.54]	T-1S6-11-XXX-2	T-1S6-20-XXX-2	.320 [8.13] (5) (6)
-17 (3)	T-1S6-10-XXX-2	.830 [21.08]	N/A	N/A	.620 [15.75] (5)
-18 (3)	T-1S6-11-XXX-2	.930 [23.62]	N/A	N/A	.720 [18.29] (5)
-19 (3)	T-1S6-12-XXX-2	1.030 [26.16]	N/A	N/A	.820 [20.83] (5)
-20 (3)	T-1S6-13-XXX-2	1.230 [31.24]	N/A	N/A	1.020 [25.91] (5)
-21	T-1S6-14-XXX-2	1.430 [36.32]	N/A	N/A	1.220 [30.99] (5)
-21 (1)	T-1S6-14-XXX-2	1.430 [36.32]	N/A	N/A	.230 [5.84]
-22	T-1S6-15-XXX-2	.630 [16.00]	T-1S6-10-XXX-2	T-1S6-12-XXX-2	.230 [5.84] (5) (6)
-23 (3)	T-1S6-16-XXX-2	.445 [11.30]	N/A	N/A	.230 [5.84] (5)
-24 (3)	T-1S6-17-XXX-2	.480 [12.19]	N/A	N/A	.265 [6.73] (5)
-25 (4)	T-1S6-15-XXX-2	.630 [16.00]	T-1S6-10-XXX-2	T-1S6-12-XXX-2	.320 [8.13] (5) (6)
*-26 (3)	T-1RS7-01-XXX-2	.456 [11.58]	N/A	N/A	.230 [5.84]
-27	T-1S6-19-XXX-2	1.330 [33.78]	N/A	N/A	.230 [5.84]
-28	T-1S6-20-XXX-2	1.130 [28.70]	T-1S6-19-XXX-2	N/A	.230 [5.84]
-29 (4)	T-1S6-19-XXX-2	1.330 [33.78]	N/A	N/A	.320 [8.13]
-30 (4)	T-1S6-20-XXX-2	1.130 [28.70]	T-1S6-19-XXX-2	N/A	.320 [8.13]
-41	T-1S6-25-XXX-2	.365 [9.27]	N/A	N/A	.230 [5.84]
-42	T-1S6-26-XXX-2	.470 [11.94]	N/A	N/A	.320 [8.13]

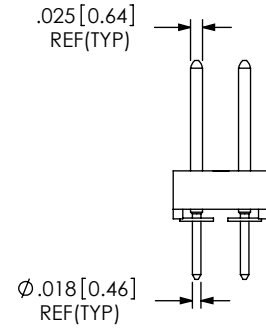


FIG 7
-26 LEAD STYLE
(SAME AS FIG 1, DIFFERENT AS SHOWN)

- (1) WITH -RA or -RE OPTION
 - (2) OMIT WITH -Q ROW SPECIFICATION
 - (3) NOT AVAILABLE IN -RA OR -RE OPTION.
 - (4) NOT AVAILABLE IN -RE OPTION.
 - (5) AVAILABLE IN -LL OPTION.
 - (6) AVAILABLE IN -LA OPTION.
 - (7) ON STYLE -08 -RA & -LA OPTIONS ONLY; 'C' = .230+.005/-.008 [5.84+.13/-.20]
- *SQUARE END OF PIN(T-1RS7-01-XXX-2)SHOULD BE LOCATED AT "C" DIMENSION DURING FILL PROCESS. (SEE FIG 7)


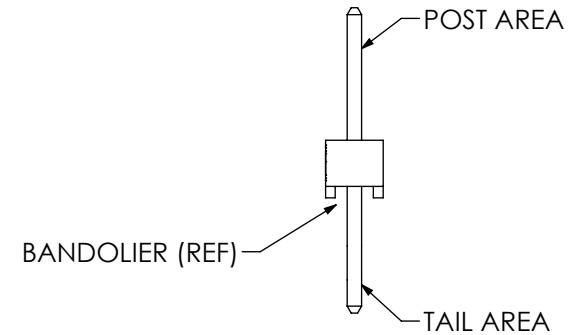
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	<p>520 PARK EAST BLVD, NEW ALBANY, IN 47150 PHONE: 812-944-6733 FAX: 812-948-5047 e-Mail info@SAMTEC.com code 55322</p>
	<p>DESCRIPTION: .025 SQ POST HI-TEMP TERMINAL STRIP ASSEMBLY</p>
	<p>DWG. NO. HTSW-XXX-XX-XXX-X-XX-XX-XX</p>
<p>BY: PURVIS 02/17/87</p>	<p>SHEET 6 OF 7</p>

TABLE 6 (-T PLATING ONLY)

LEAD STYLE	NUMBER OF BAND MARKS ALLOWED IN POST AREA			LEAD STYLE	NUMBER OF BAND MARKS ALLOWED IN POST AREA		
	PIN #1	PIN #2	PIN #3		PIN #1	PIN #2	PIN #3
*-05	*0	N/A	N/A	*-17	2	N/A	N/A
-06	1	N/A	N/A	*-18	2	N/A	N/A
-07	1	N/A	N/A	*-19	2	N/A	N/A
-08	0	0	0	*-20	2	N/A	N/A
-08 RA	0	0	0	*-21	2	N/A	N/A
-09	0	0	0	-21-RA	0	N/A	N/A
-09 RA	0	0	0	-21-RE	0	N/A	N/A
-09-RE	0	0	0	-22	0	0	0
-10	0	0	0	-22-RA	0	0	0
-10-RA	0	0	0	-22-RE	0	0	0
-10-RE	0	0	0	-23	1	N/A	N/A
-11	0	0	0	-24	1	N/A	N/A
-11-RA	0	0	0	-25	1	1	1
-11-RE	0	0	0	*-25-RA	1	0	0
-12	0	0	0	*-26	1	N/A	N/A
-12-RA	0	0	0	*-27	0	N/A	N/A
-12-RE	0	0	0	*-27-RA	0	N/A	N/A
-13	0	0	N/A	*-27-RE	0	N/A	N/A
-13-RA	0	0	N/A	*-28	0	0	N/A
-13-RE	0	0	N/A	*-28-RA	0	0	N/A
-14	1	N/A	N/A	*-28-RE	0	0	N/A
*-15	2	N/A	N/A	*-29	1	N/A	N/A
*-16	1	1	1	*-29-RA	1	N/A	N/A
*-16-RA	1	1	1	*-30	1	1	N/A
*-16-RE	1	1	1	*-30-RA	1	1	N/A

* PINS TO BE FLIPPED OPPOSITE OF SELECTIVE PLATING BEFORE BEING INSERTED



IN PROCESS 1
(SAME AS FIG. 1, DIFFERENT AS SHOWN)
-T PLATING ONLY

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DO NOT SCALE DRAWING

SHEET SCALE: 3:1



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DWG. NO.
HTSW-XXX-XX-XXX-X-XX-XX-XX

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