

TABLE 2					
LEAD STYLE	"A"	"B"	"C"	CONTACT	GROUND PLANE
-01	.638 [16.21]	.212 [5.38]	.600 [15.24]	C-79-02-X	C-127-01-X
-02	.500 [12.70]	.115 [2.92]	.365 [9.27]	C-79-02-X	C-127-02-X
-03	.650 [16.51]	.090 [2.29]	.490 [12.45]	C-79-02-X	C-127-03-X
-04	.760 [19.30]	.090 [2.29]	.600 [15.24]	C-79-02-X	C-127-04-X

UNLESS OTHERWISE NOTED

DIMENSIONS ARE IN INCHES

TOLERANCES ARE:

ONE PLACE DECIMALS $\pm .1[2.5]$ THREE PLACE DECIMALS $\pm .005[.127]$ ANGLES $\pm 2^\circ$
 TWO PLACE DECIMALS $\pm .01[.25]$ FOUR PLACE DECIMALS $\pm .0020[.051]$

TITLE: .0197 SQ 2mm
 QUIET SOCKET
 ASSEMBLY

DWG NO:

QST-1XX-XX-X-X

SHEET 1 OF 1

QST-1XX-XX-X-X

No. OF POSITIONS
 -10 THRU -50
 (PER ROW)

LEAD STYLE SPECIFICATION
 -01: .638 STACK
 -02: .500 STACK
 -03: .650 STACK
 -04: .760 STACK

ROW SPECIFICATION

-T: TRIPLE (USE SQT-50-T & TMMH-50-T)
 -S: FIVE (USE SQT-50-S & TMMH-50-S)

PLATING SPECIFICATION

-F: 3μ " FLASH SELECTIVE GOLD IN CONTACT AREA, MATTE TIN ON TAIL
 -L: 10μ " LIGHT SELECTIVE GOLD IN CONTACT AREA, MATTE TIN ON TAIL
 -G: 10μ " GOLD IN CONTACT AREA, 3 GOLD ON TAIL
 -S: 30μ " SELECTIVE GOLD IN CONTACT AREA, MATTE TIN ON TAIL
 -M: 20μ " MEDIUM SELECTIVE GOLD IN CONTACT AREA, MATTE TIN ON TAIL

CRITICAL DIMENSION INSPECTION INSTRUCTION TABLE	
ASSEMBLY OPERATION	IN-PROCESS INSPECTION
POLARIZE C-127	C8
ROTO CUT SQT	C1
MULTI CUT TMMH	C4
FILL	C5,C8
MOUNT BODY	C2,C3*,C7
SHEAR TAILS	C3*
*IF APPLICABLE	

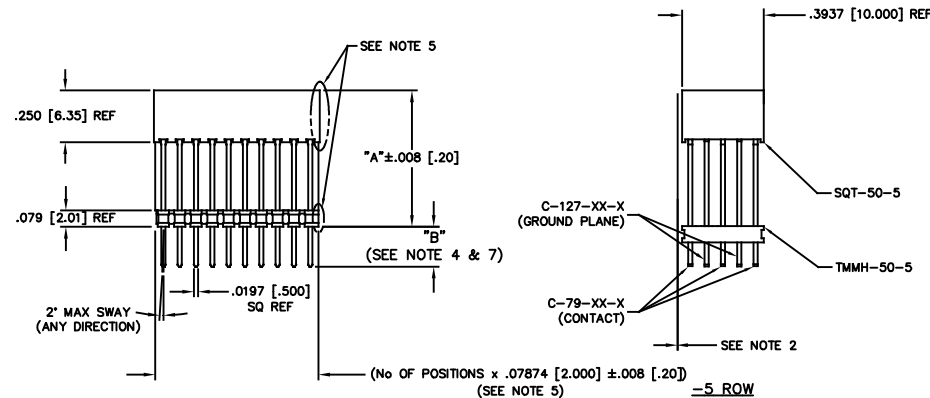
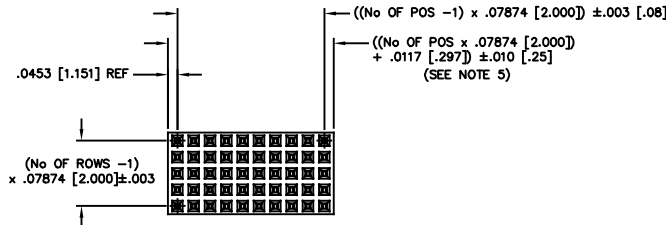
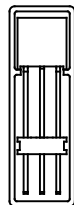


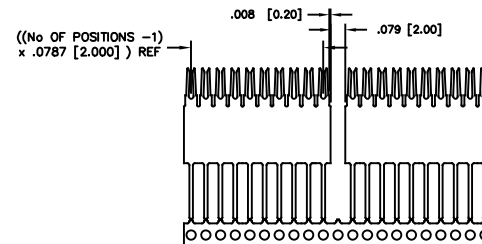
FIG. 1



QST-1XX-XX-X-T-XX
 PT-1-24-01-74
 USE 2 TP-07

PACKAGING VIEW

TUBE TABLE			
ROW SPEC.	LEAD STYLE	TUBE	PLUG
3	ALL	PT-1-24-01-74	TP-07
5	01, 03, 04	PT-1-24-25F-109	TP-29
5	02	ASP-90334-01-S	TP-25



IN-PROCESS VIEW

NOTE:

1. TOOLING TO BE DESIGNED TO PRODUCE UP TO 61 POSITIONS.
2. TMMH BODY NOT TO BE MORE THAN $\pm .005$ [.13] FROM PLANE SET BY SQT BODY.
3. $\odot$ REPRESENTS A CRITICAL DIMENSION.
4. TAILS TO BE SHEARED TO ACHIEVE DIMENSION SHOWN (LEAD STYLE -02 & -03).
5. MAX CUT FLASH TO BE .015 [.38].
6. MAX BURR .005 [.13].
7. MAX HEIGHT VARIATION BETWEEN ROWS: .010 [.25].

MATERIAL:

BODY:
 LIQUID CRYSTAL POLYMER
 COLOR: BLACK

CONTACT:

PHOSPHOR BRONZE

EXISPROD\ASSEMBLY\2MM
QST-ASM

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MADE BY:

PURVIS 09/22/98

QST-1XX-XX-X-X

SHEET 1 OF 1

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