



Dear Customer,

There has been a recent change to Samtec's order entry system, which necessitates that customers contact Samtec's Interconnect Processing Group (IPG) [IPG@samtec.com](mailto:IPG@samtec.com) prior to ordering certain longer position parts, such as the QTE and QSE 80-position parts.

There is a note on the QTE and QSE assembly prints that states to contact the Samtec Interconnect Processing Group for new applications requiring the 80 and 100 position QTE and QSE components. This note is meant to alert customers to the difficulty of soldering parts this long. This occurs with eutectic solder as well as lead free, but the higher temperatures associated with lead free reflow result in increased board and part warpage during reflow. As a result, for new designs we recommend using two, shorter connectors in place of each long one. For example, we would recommend using two 40 position connectors as opposed to a single 80 position connector. The potential for misalignment when mating multiple connectors is minimal compared to the potential for soldering anomalies.

If the connectors have already been designed in, our general processing recommendations for the 80 position QTE and QSE components include the following:

- Excessive reflow temperatures and temperature durations should be avoided in order to minimize board and component warpage.
- Orient the components perpendicular with the rails during reflow, if possible. This orientation will heat the components more uniformly and may decrease the potential for component warpage.

Please review Samtec's component assembly drawing information and please contact Digi-Key at 1-800-344-4539 and ask for Technical Support if you have any questions.

Regards,

Digi-Key's Product Team

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