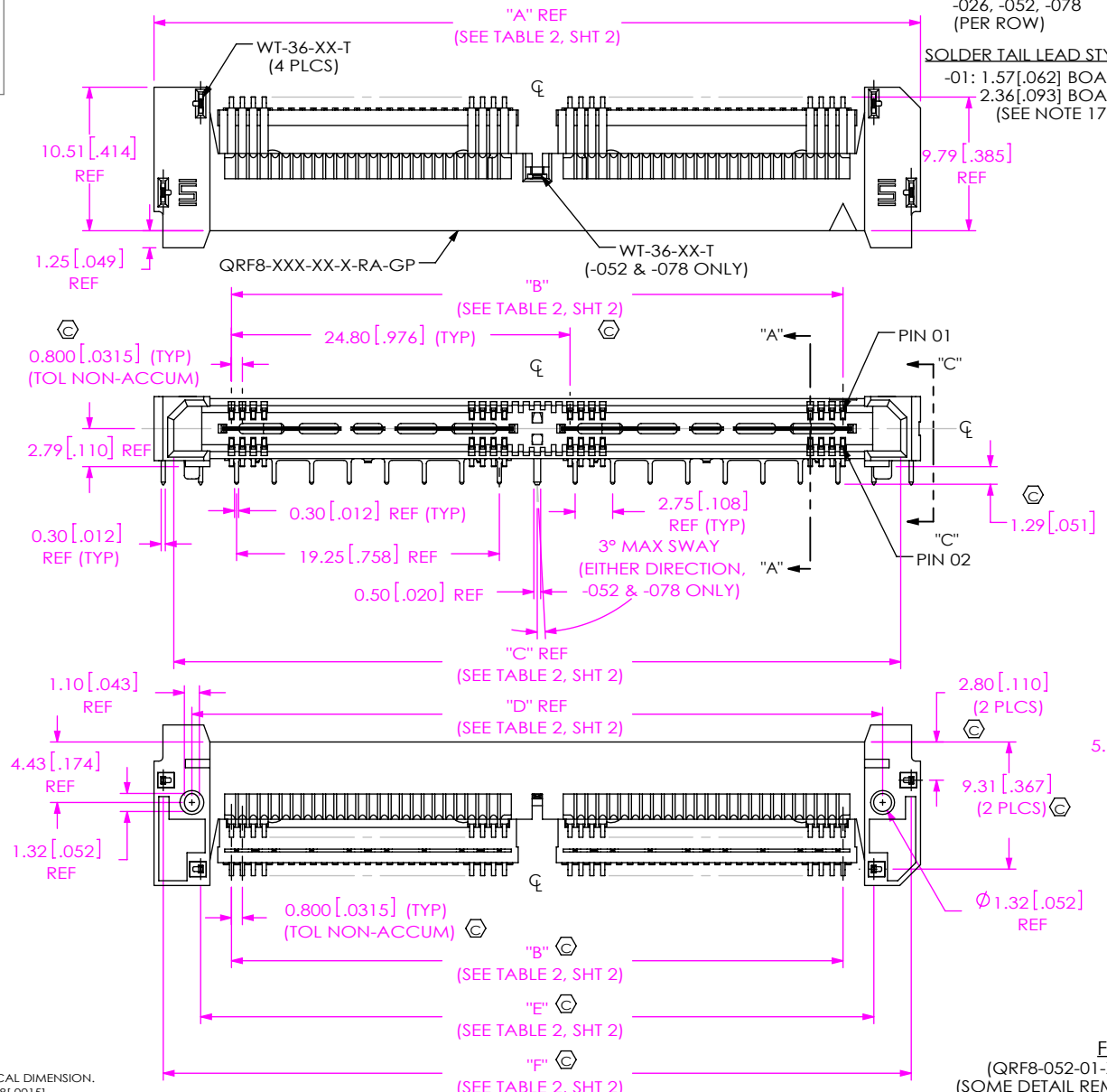


DO NOT SCALE FROM THIS PRINT

DESIGNED & DIMENSIONED IN MILLIMETERS [INCHES]

QRF8-XXX-XX-X-RA-GP-X-XX



No OF POSITIONS  
-026, -052, -078 (PER ROW)  
SOLDER TAIL LEAD STYLE  
-01: 1.57[.062] BOARD OR 2.36[.093] BOARD (SEE NOTE 17)

PACKAGING  
BLANK: TRAY (SEE NOTES 10 & 18)  
-TR: TAPE & REEL (SEE NOTES 18 & 19)  
-FR: FULL REEL QTY TAPE & REEL (SEE NOTES 18 & 19)  
(-078 POSITION IS NOT AVAILABLE FOR -TR & -FR)  
PICK & PLACE OPTION  
-K: POLYIMIDE FILM (NOT AVAILABLE FOR -026 & -078) (USE K-DOT-.276-.375-.005 SEE FIG 2, SHT 6)  
GUIDE POSTS REQUIREMENT  
-GP (SEE NOTE 9)

RIGHT ANGLE  
-RA  
PLATING SPECIFICATION  
-S: 30μ" SELECTIVE GOLD IN CONTACT AREA, MATTE TIN ON TAIL (USE C-288-XX-S & IM-T-1G36-XX-S)  
-L: 10μ" SELECTIVE GOLD IN CONTACT AREA, MATTE TIN ON TAIL (USE C-288-XX-L & IM-T-1G36-XX-L)

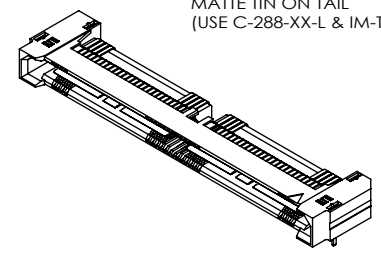


FIG 1 (QRF8-052-01-X-RA-GP SHOWN) (SOME DETAIL REMOVED FOR CLARITY)

VIEW "C"-"C" SCALE 4 : 1

NOTES:

1. REPRESENTS A CRITICAL DIMENSION.
2. BURR ALLOWANCE: 0.038[.0015].
3. MINIMUM PUSHOUT FORCE: SIGNAL: 2.22N[.5 LB], GROUND PLANE: 4.45N[1 LB].
4. NOTE DELETED.
5. MEASURE AT BEND TANGENCY.
6. MEASURE ON PINS ONLY, STANDOFFS NOT INCLUDED IN MEASUREMENT.
7. POST HEIGHT VARIATION BETWEEN ANY TWO PINS: 0.05[.002] MAXIMUM.
8. NOTE DELETED.
9. PARTS WITH THE -GP OPTION MUST MATE TO -GP OPTIONED QRM8 PARTS.
10. TRAYS ARE STANDARD PACKAGING.
11. DIMENSIONS MUST BE MEASURED BOTH ENDS OF COMB OR CONNECTOR.
12. NOTE DELETED.
13. NOTE DELETED.
14. NOTE DELETED.
15. SHEAR BURR ALLOWANCE: 0.15[.006] MAX ON THIS EDGE.
16. NOTE DELETED.
17. THE -01 SOLDER TAIL LEAD STYLE CAN BE USED FOR A 1.57[.062] OR A 2.36[.093] THICK PCB IF SAMTEC'S RECOMMENDED STENCIL APERTURE IS UTILIZED.
18. ORDERS WILL BE PACKAGED ACCORDING TO THE SAMTEC PACKAGING EFFICIENCY STANDARDS (SPES) FOUND ON WWW.SAMTEC.COM.
19. ATTACH LABEL TO EACH REEL.

TABLE 1		
LEAD STYLE	"OVER MOLDED GROUND PLANE"	"WELD TAB"
-01	IM-T-1G36-01-X	WT-36-01-T

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN MILLIMETERS [INCHES]. TOLERANCES ARE:  
DECIMALS ANGLES  
X.X: ±0.3 [0.1]  
X.XX: ±0.13 [0.05]  
X.XXX: ±0.050 [0.020]

PROPRIETARY NOTE  
THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION AND ALL DESIGN, MANUFACTURING, REPRODUCTION, USE, PATENT RIGHTS AND SALES RIGHTS ARE EXPRESSLY RESERVED BY SAMTEC, INC. THIS DOCUMENT SHALL NOT BE DISCLOSED, IN WHOLE OR PART, TO ANY UNAUTHORIZED PERSON OR ENTITY NOR REPRODUCED, TRANSFERRED OR INCORPORATED IN ANY OTHER PROJECT IN ANY MANNER WITHOUT THE EXPRESS WRITTEN CONSENT OF SAMTEC, INC.



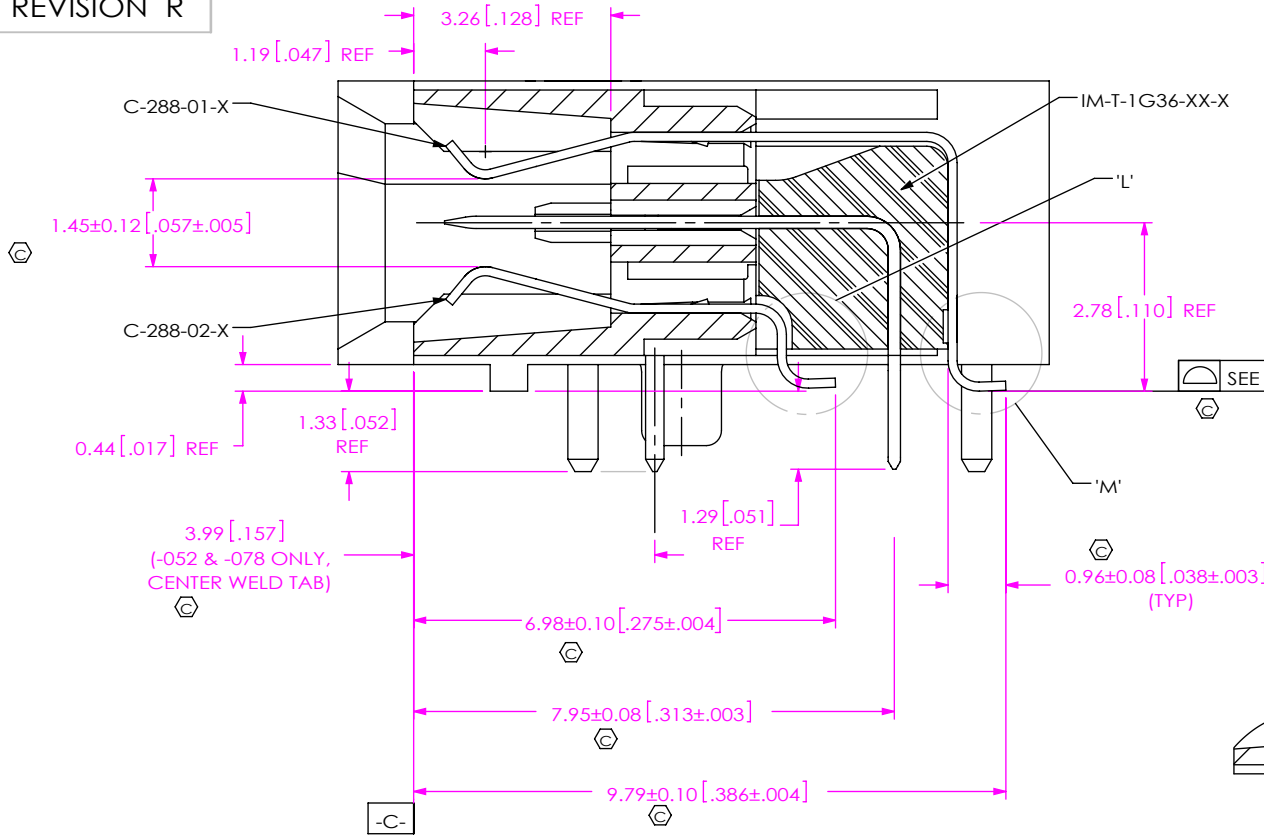
MATERIAL: DO NOT SCALE DRAWING  
INSULATORS: LCP UL94V-0; COLOR BLACK  
CONTACT : PHOS BRONZE  
GROUND PLANE: PHOS BRONZE

SHEET SCALE: 2:1

DESCRIPTION:  
0.8mm Q-RATE RIGHT ANGLE SOCKET ASSEMBLY  
DWG. NO.

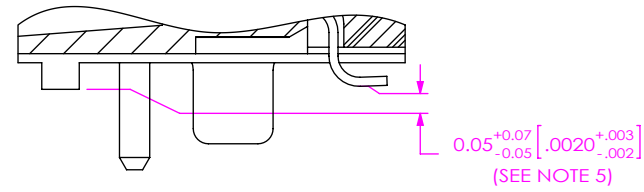
QRF8-XXX-XX-X-RA-GP-X-XX

BY: R MUSSER 09/19/2008 SHEET 1 OF 6

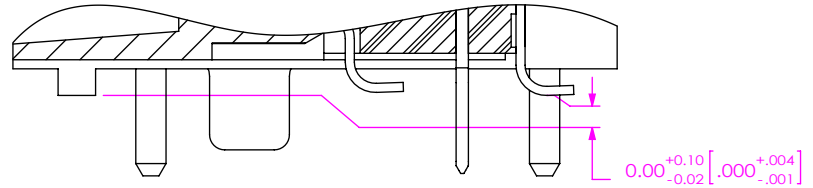


**TABLE 4**

No OF POSITIONS	BOTTOM ROW STRAIGHTNESS	TOP ROW STRAIGHTNESS	COPLANARITY
-026, -052, -078	0.10 [0.004]	0.10 [0.004]	0.15 [0.006]



**DETAIL 'L'**  
BOTTOM ROW TAIL  
(LOCATE ASSY ON DATUM -C- FOR MEASUREMENTS)



**DETAIL 'M'**  
TOP ROW TAIL  
(LOCATE ASSY ON DATUM -C- FOR MEASUREMENTS)

**TABLE 2**

No OF POSITIONS	"A"	"B"	"C"	"D"	"E"	"F"
-026	31.35 [1.234]	20.00 [0.787]	28.45 [1.120]	25.80 [1.016]	24.52 [0.965]	30.00 [1.181]
-052	56.15 [2.211]	44.80 [1.764]	53.25 [2.096]	50.60 [1.992]	49.32 [1.942]	54.80 [2.157]
-078	80.95 [3.187]	69.60 [2.740]	78.05 [3.073]	75.40 [2.969]	74.12 [2.918]	79.60 [3.134]

**PROPRIETARY NOTE**  
THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION AND ALL DESIGN, MANUFACTURING, REPRODUCTION, USE, PATENT RIGHTS AND SALES RIGHTS ARE EXPRESSLY RESERVED BY SAMTEC, INC. THIS DOCUMENT SHALL NOT BE DISCLOSED, IN WHOLE OR PART, TO ANY UNAUTHORIZED PERSON OR ENTITY NOR REPRODUCED, TRANSFERRED OR INCORPORATED IN ANY OTHER PROJECT IN ANY MANNER WITHOUT THE EXPRESS WRITTEN CONSENT OF SAMTEC, INC.

DO NOT SCALE DRAWING  
SHEET SCALE: 2:1

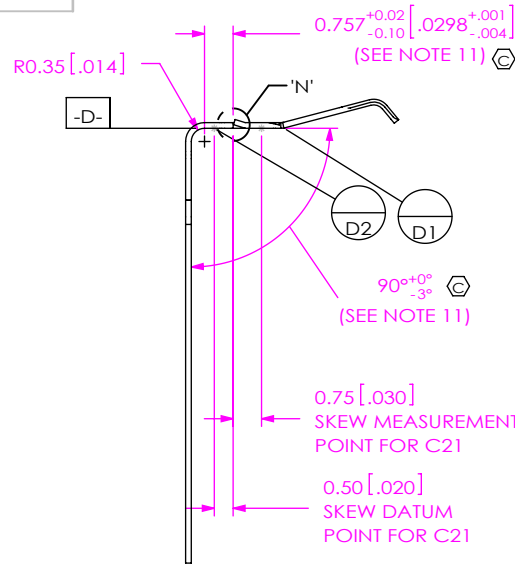


520 PARK EAST BLVD, NEW ALBANY, IN 47150  
PHONE: 812-944-6733 FAX: 812-948-5047  
e-Mail info@SAMTEC.com code 55322

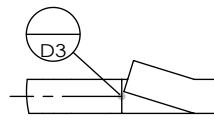
DESCRIPTION:  
0.8mm Q-RATE RIGHT ANGLE SOCKET ASSEMBLY

DWG. NO.  
**QRF8-XXX-XX-X-RA-GP-X-XX**

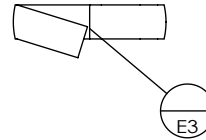
BY: R MUSSER 09/19/2008 SHEET 2 OF 6



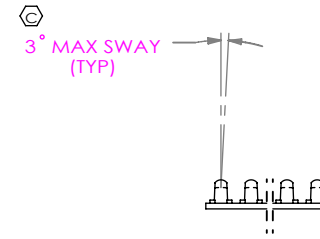
IN-PROCESS 1  
(FORM 1 CONTACT C-288-02-X)  
(RIGHT SIDE SHOWN)



DETAIL 'N'  
SCALE 30 : 1

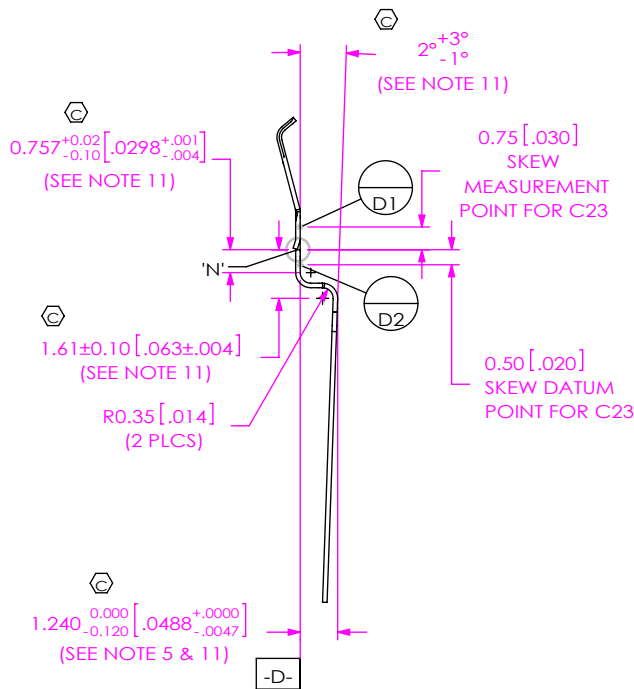
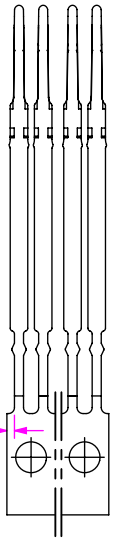


DETAIL 'P'  
SCALE 30 : 1

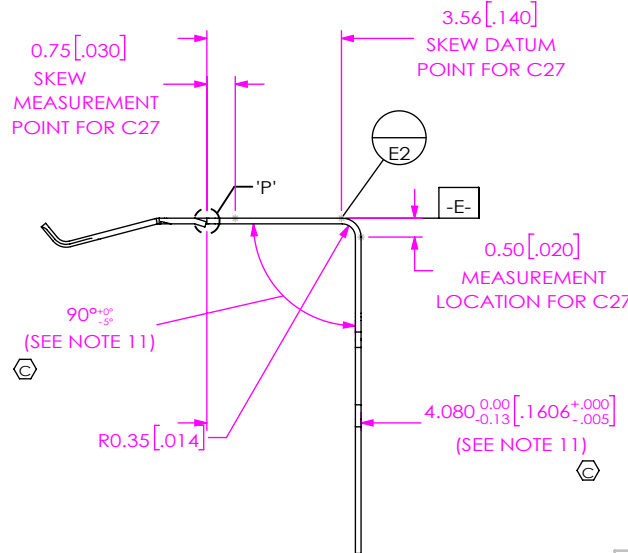


0.25±0.08 [0.010±.003]

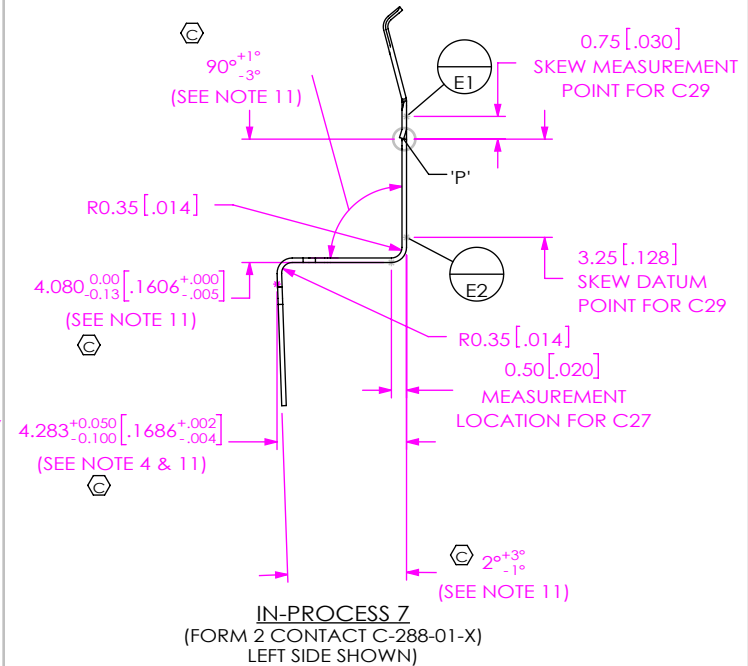
C-288-XX-X IN-PROCESS VIEW



IN-PROCESS 2  
(FORM 2 CONTACT C-288-02-X)  
(RIGHT SIDE SHOWN)



IN-PROCESS 6  
(FORM 1 CONTACT C-288-01-X)  
(LEFT SIDE SHOWN)



IN-PROCESS Z  
(FORM 2 CONTACT C-288-01-X)  
LEFT SIDE SHOWN)

PROPRIETARY NOTE

THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION AND ALL DESIGN, MANUFACTURING, REPRODUCTION, USE, PATENT RIGHTS AND SALES RIGHTS ARE EXPRESSLY RESERVED BY SAMTEC, INC. THIS DOCUMENT SHALL NOT BE DISCLOSED, IN WHOLE OR IN PART, TO ANY UNAUTHORIZED PERSON OR ENTITY NOR REPRODUCED, TRANSFERRED OR INCORPORATED IN ANY OTHER PROJECT IN ANY MANNER WITHOUT THE EXPRESS WRITTEN CONSENT OF SAMTEC, INC.

DO NOT SCALE DRAWING

SHEET SCALE: 4:1

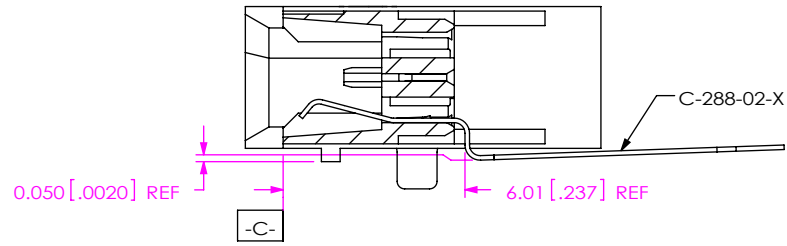


520 PARK EAST BLVD, NEW ALBANY, IN 47150  
PHONE: 812-944-6733 FAX: 812-948-5047  
e-Mail info@SAMTEC.com code 55322

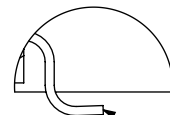
DESCRIPTION:  
0.8mm Q-RATE RIGHT ANGLE SOCKET ASSEMBLY

DWG. NO.  
QRF8-XXX-XX-X-RA-GP-X-XX

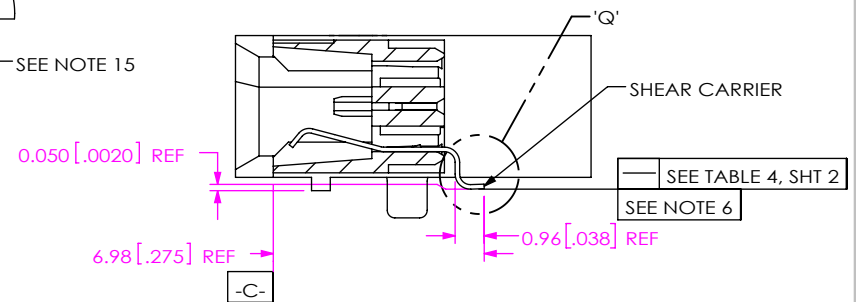
BY: R MUSSER 09/19/2008 SHEET 3 OF 6



**IN-PROCESS 3**  
(FILL BOTTOM ROW)  
(SEE INSPECTION VIEW 1 FOR ASSEMBLY ORIENTATION AND CPC'S)

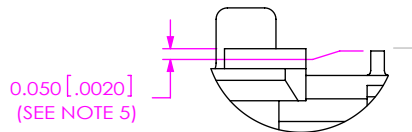
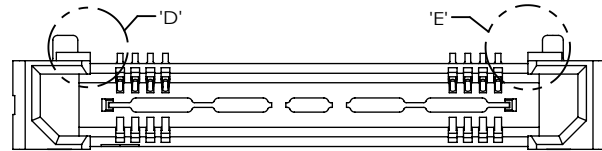


**DETAIL 'Q'**  
SCALE 8:1

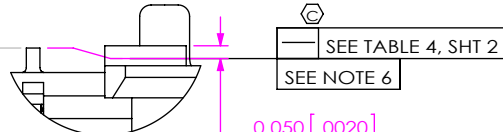


**IN-PROCESS 4**  
(CUTOFF OF CARRIER)  
(SEE INSPECTION VIEW 1 FOR ASSEMBLY ORIENTATION AND CPC'S)

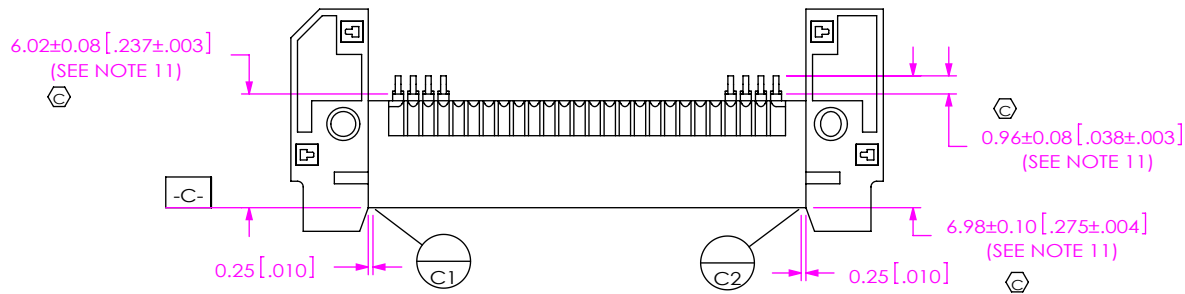
**INSPECTION VIEW 1**



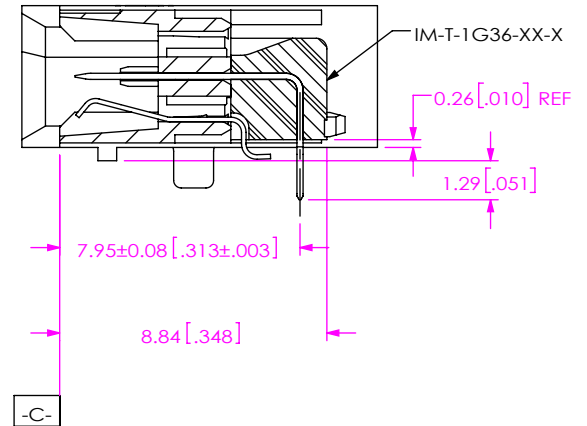
**DETAIL 'D'**  
SCALE 6:1



**DETAIL 'E'**  
SCALE 6:1



**INSPECTION FOR IN-PROCESS 3 & 4**  
(CARRIER NOT SHOWN FOR IN-PROCESS 3 INSPECTIONS)



**IN-PROCESS 5**  
(FILL OVER MOLDED GROUND PLANE)  
(IM-T-1G36-XX-X)

**PROPRIETARY NOTE**  
THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION AND ALL DESIGN, MANUFACTURING, REPRODUCTION, USE, PATENT RIGHTS AND SALES RIGHTS ARE EXPRESSLY RESERVED BY SAMTEC, INC. THIS DOCUMENT SHALL NOT BE DISCLOSED, IN WHOLE OR PART, TO ANY UNAUTHORIZED PERSON OR ENTITY NOR REPRODUCED, TRANSFERRED OR INCORPORATED IN ANY OTHER PROJECT IN ANY MANNER WITHOUT THE EXPRESS WRITTEN CONSENT OF SAMTEC, INC.

DO NOT SCALE DRAWING

SHEET SCALE: 4:1

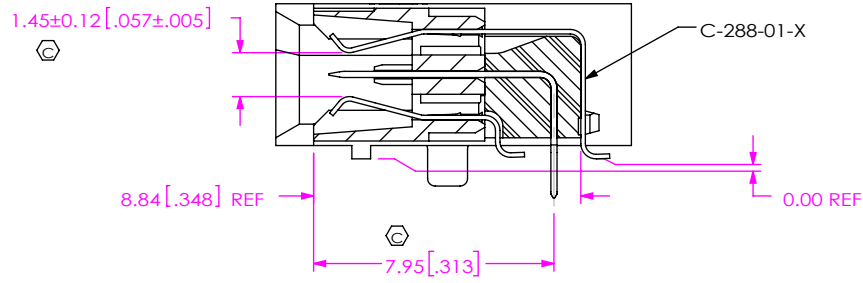


520 PARK EAST BLVD, NEW ALBANY, IN 47150  
PHONE: 812-944-6733 FAX: 812-948-5047  
e-Mail info@SAMTEC.com code 55322

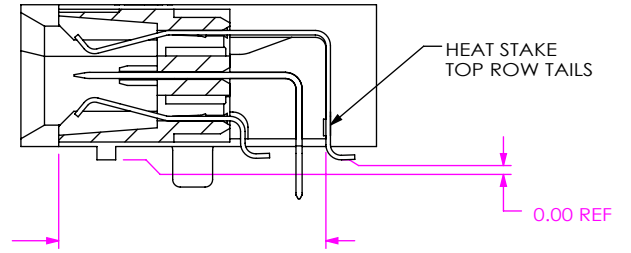
DESCRIPTION:  
0.8mm Q-RATE RIGHT ANGLE SOCKET ASSEMBLY

DWG. NO.  
**QRF8-XXX-XX-X-RA-GP-X-XX**

BY: R MUSSER 09/19/2008 SHEET 4 OF 6

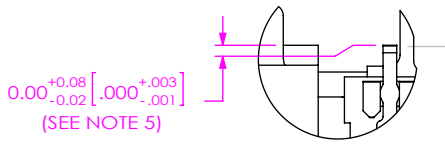
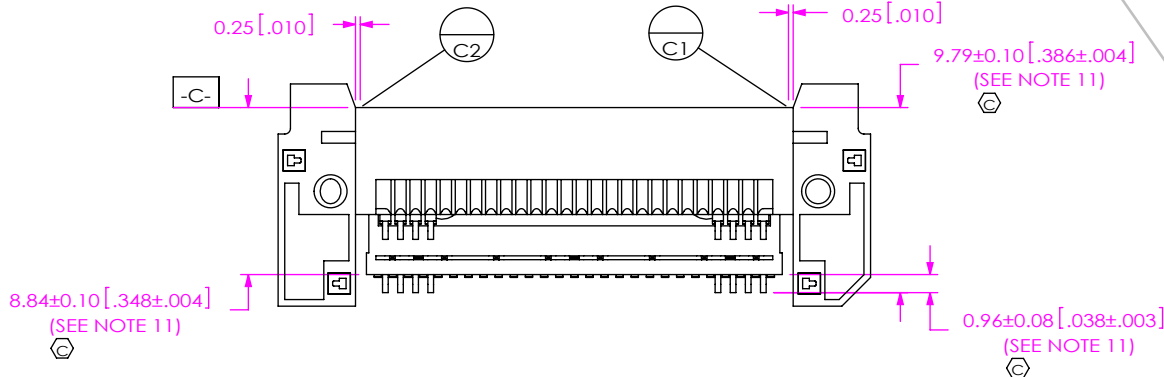


**IN-PROCESS 8**  
(FILL TOP ROW)  
(SEE INSPECTION VIEW 2 FOR ASSEMBLY ORIENTATION AND CPC'S)

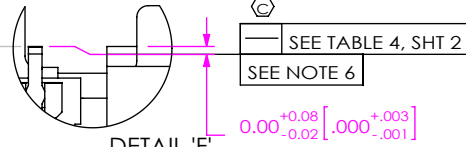


**IN-PROCESS 9**  
(HEAT STAKE TOP ROW CONTACTS)  
(SEE INSPECTION VIEW 2 FOR ASSEMBLY ORIENTATION AND CPC'S)

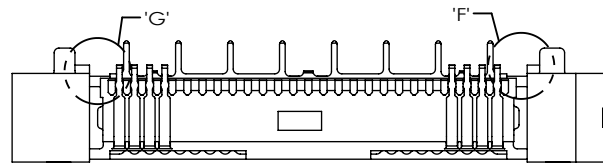
**INSPECTION VIEW 2**



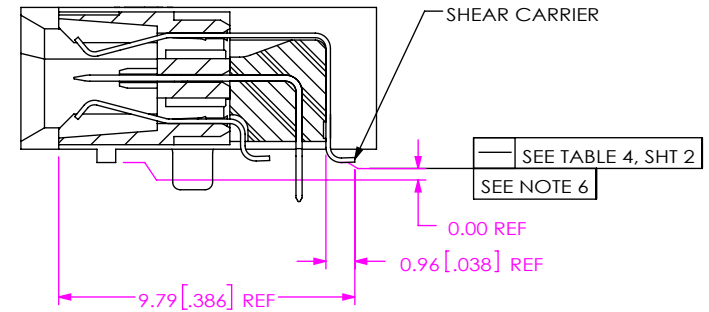
**DETAIL 'G'**  
SCALE 6:1



**DETAIL 'F'**  
SCALE 6:1



**INSPECTION FOR IN-PROCESS 8, 9 & 10**  
(CARRIER NOT SHOWN FOR IN-PROCESS 8 INSPECTIONS)



**IN-PROCESS 10**  
(CUTOFF OF CARRIER)  
(SEE INSPECTION VIEW 2 FOR ASSEMBLY ORIENTATION AND CPC'S)

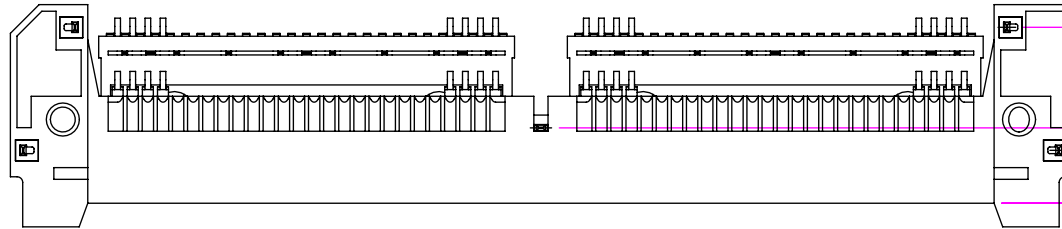
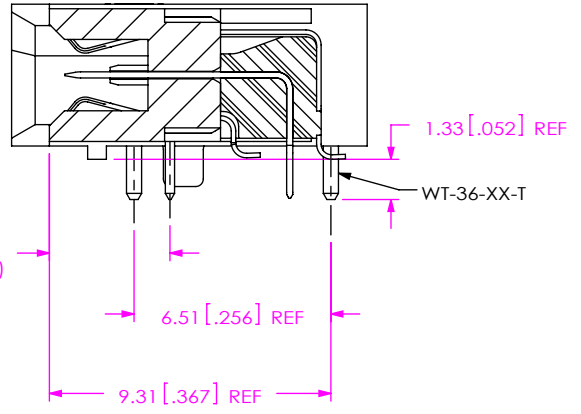
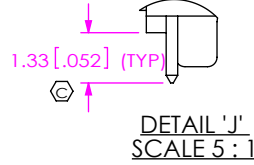
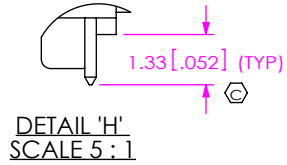
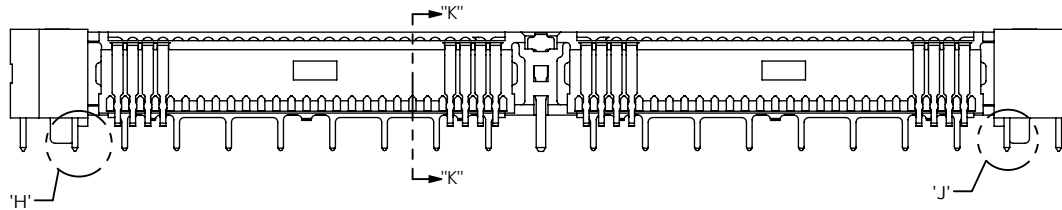
**PROPRIETARY NOTE**  
THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION AND ALL DESIGN, MANUFACTURING, REPRODUCTION, USE, PATENT RIGHTS AND SALES RIGHTS ARE EXPRESSLY RESERVED BY SAMTEC, INC. THIS DOCUMENT SHALL NOT BE DISCLOSED, IN WHOLE OR PART, TO ANY UNAUTHORIZED PERSON OR ENTITY NOR REPRODUCED, TRANSFERRED OR INCORPORATED IN ANY OTHER PROJECT IN ANY MANNER WITHOUT THE EXPRESS WRITTEN CONSENT OF SAMTEC, INC.

DO NOT SCALE DRAWING  
SHEET SCALE: 4:1



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

DESCRIPTION: 0.8mm Q-RATE RIGHT ANGLE SOCKET ASSEMBLY
DWG. NO. <b>QRF8-XXX-XX-X-RA-GP-X-XX</b>
BY: R MUSSER 09/19/2008 SHEET 5 OF 6



IN-PROCESS 11  
(FILL WELD TAB)  
(WT-36-XX-T)

3.99 [.157]  
(-052 & -078 ONLY,  
CENTER WELD TAB)

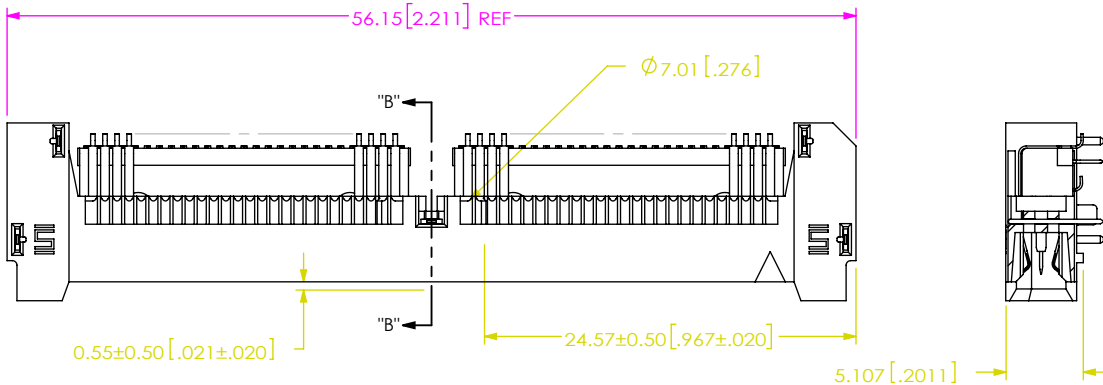


FIG 2  
-K OPTION  
(USE K-DOT-.276-.375-.005)  
(ONLY FOR QRF8-052-01-X-RA-GP-K SHOWN)  
(SOME DETAIL REMOVED FOR CLARITY)

SECTION "B"-"B"  
SCALE 2:1

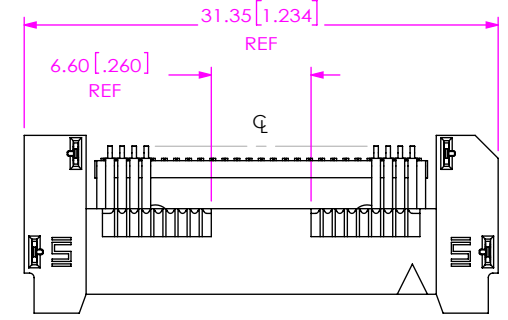


FIG 3  
(QRF8-026-01-X-RA-GP SHOWN)  
(SOME DETAIL REMOVED FOR CLARITY)

**PROPRIETARY NOTE**  
THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION AND ALL DESIGN, MANUFACTURING, REPRODUCTION, USE, PATENT RIGHTS AND SALES RIGHTS ARE EXPRESSLY RESERVED BY SAMTEC, INC. THIS DOCUMENT SHALL NOT BE DISCLOSED, IN WHOLE OR PART, TO ANY UNAUTHORIZED PERSON OR ENTITY NOR REPRODUCED, TRANSFERRED OR INCORPORATED IN ANY OTHER PROJECT IN ANY MANNER WITHOUT THE EXPRESS WRITTEN CONSENT OF SAMTEC, INC.

DO NOT SCALE DRAWING  
SHEET SCALE: 4:1



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

DESCRIPTION:  
0.8mm Q-RATE RIGHT ANGLE SOCKET ASSEMBLY

DWG. NO.  
QRF8-XXX-XX-X-RA-GP-X-XX

BY: R MUSSER 09/19/2008 SHEET 6 OF 6