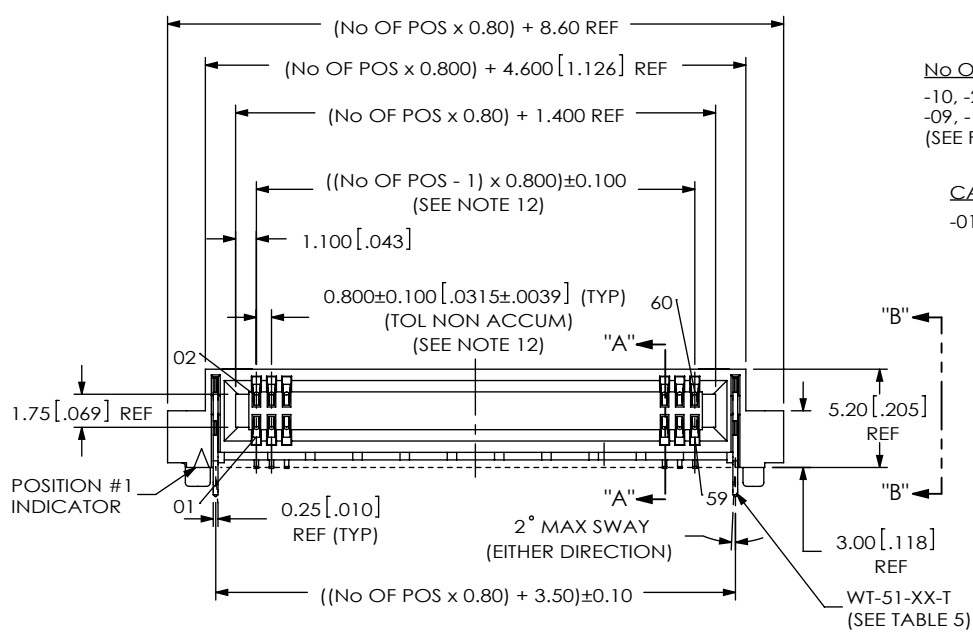


DO NOT SCALE FROM THIS PRINT



HSEC8-1XX-XX-X-RA-XX-XX

**No OF POSITIONS**  
 -10, -20, -30 (SEE FIG 1)  
 -09, -13, -25, -40, -49, -50, -60 (SEE FIG 2)

**CARD THICKNESS**  
 -01: 1.57mm [.062] THICK CARD

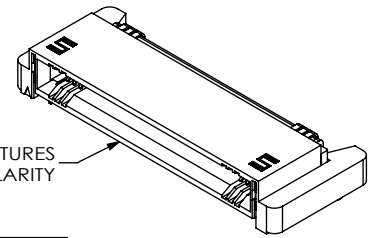
**PLATING SPECIFICATION**  
 -L: 10µ" SELECTIVE GOLD ON CONTACT AREA, TIN TAIL  
 -S: 30µ" SELECTIVE GOLD ON CONTACT AREA, TIN TAIL

(\* = NOT TOOLED)

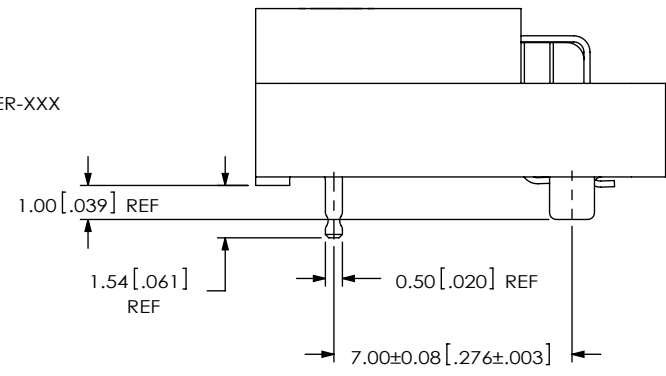
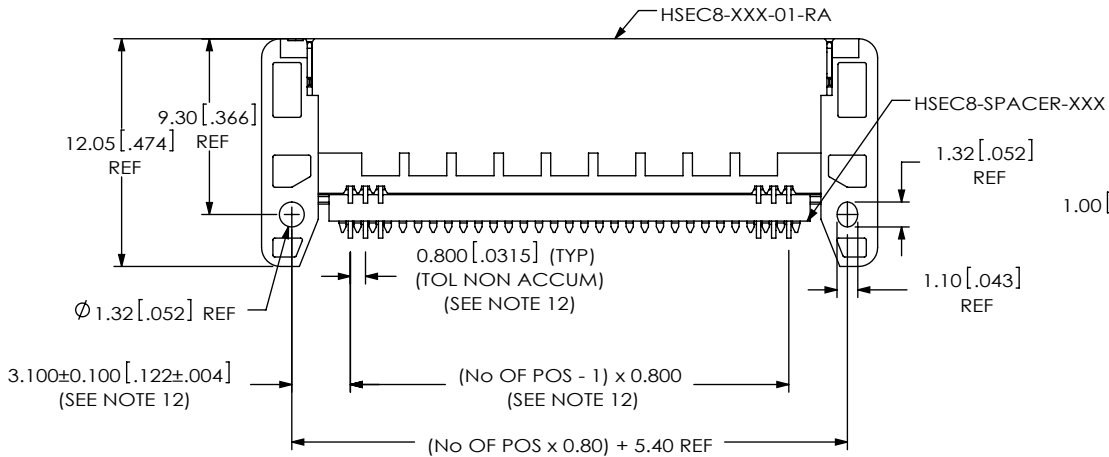
**PACKAGING**  
 -TR: TAPE & REEL

**OPTION**  
 -BL: BOARD LOCK OPTION (USE HSEC8-XXX-01-RA-BL) (AVAILABLE IN -09, -13, \*-20, 25, 40, -49, 50, 60 POS ONLY, SEE FIG 3, SHT 8)  
 -L2: ECDP LATCHING OPTION (USE HSEC8-XXX-01-RA-L2) (AVAILABLE IN -09, -13, -25, -49 POS ONLY, SEE FIG 4, SHT 9)

**ROW SPECIFICATION**  
 -RA: RIGHT ANGLE (USE HSEC8-XXX-01-RA-XX)



SOME CENTER FEATURES NOT SHOWN FOR CLARITY



SECTION "B"-"B"  
 SCALE 4.5 : 1

FIG 1  
 FOR POSITIONS -10, -20 & -30  
 HSEC8-130-01-X-RA SHOWN  
 (SOME CENTER FEATURES NOT SHOWN FOR CLARITY)

- NOTES:
- ① REPRESENTS A CRITICAL DIMENSION.
  - MAXIMUM BURR ALLOWANCE: 0.038 [.0015]
  - MINIMUM RETENTION FORCE: 2.22N [.500 LB] FOR PINS AND WELD TAB.
  - MEASURE AT BEND TANGENCY.
  - NOTE DELETED.
  - PARTS TO BE PACKAGED IN TRAY, UNLESS -TR OPTION IS SPECIFIED.
  - NOTE DELETED.
  - DIMENSIONS MUST BE MEASURED ON BOTH ENDS OF THE CONNECTOR.  
 IF PINS WERE HAND FORMED, MEASURE ONE PIN ONLY (IF APPLICABLE) ON EACH END.  
 IF PINS WERE AUTOMATION FORMED, MEASURE 4 CONSECUTIVE PINS ON EACH END.
  - NOTE DELETED.
  - NOTE DELETED.
  - LTC-XX TO BE IN CLOSED POSITION AS SHOWN.
  - MEASURE BOTH TOP AND BOTTOM ROWS.
  - DIMENSIONS TO BE MEASURED ON 4 CONSECUTIVE PINS IF AUTOMATION FORMED.  
 MEASURED ON ONE PIN FROM EACH END OF COMB IF HAND FORMED.
  - SEE CO-AU-WI-3163-M DOCUMENT FOR CRITICAL MEASUREMENT SPECIAL INSTRUCTIONS.

TABLE 5	
OPTION	WT-51-XX-T
NO OPTION	WT-51-01-T
-BL	WT-51-01-T
-L2	WT-51-02-T

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN MILLIMETERS. TOLERANCES ARE:  
 DECIMALS ANGLES  
 X.X: ±0.3 [.01] 2°  
 X.XX: ±0.13 [.005]  
 X.XXX: ±0.051 [.0020]

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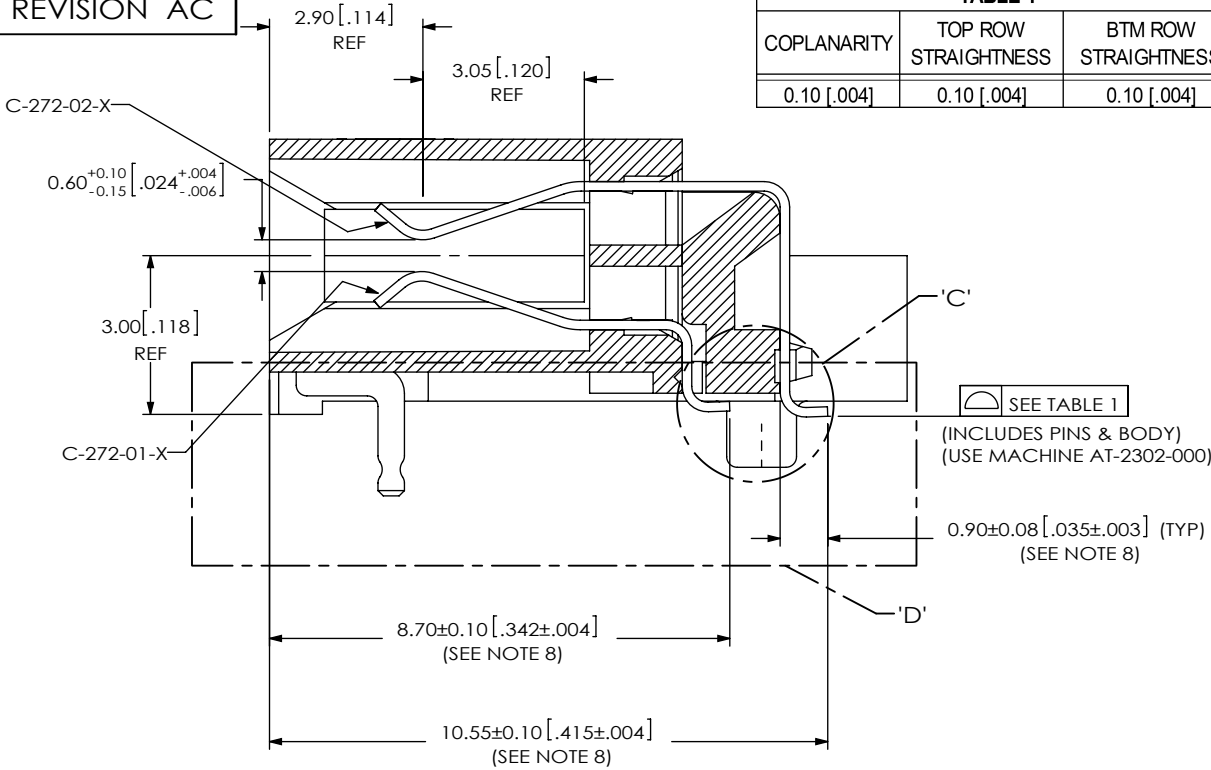
**samtec**  
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 e-Mail: info@SAMTEC.com code 55322

**MATERIAL:** DO NOT SCALE DRAWING SHEET SCALE: 2.5:1  
 INSULATOR: LCP UL94V-0, COLOR: BLACK  
 CONTACT: BeCu  
 WELD TAB: BRASS

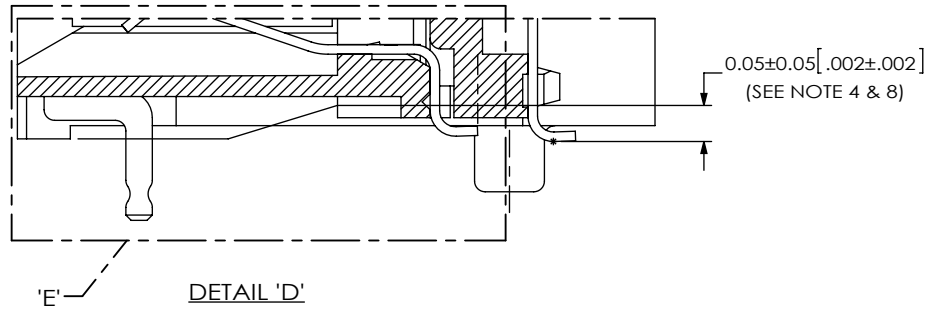
**DESCRIPTION:**  
 0.8MM HIGH SPEED ASSEMBLY  
**DWG. NO.**  
 HSEC8-1XX-XX-X-RA-XX-XX

REVISION AC

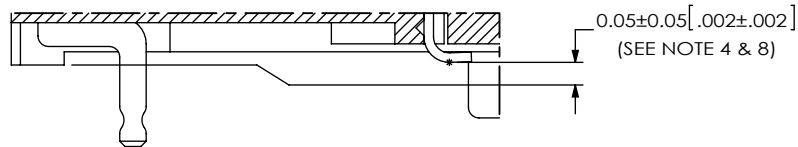
TABLE 1		
COPLANARITY	TOP ROW STRAIGHTNESS	BTM ROW STRAIGHTNESS
0.10 [.004]	0.10 [.004]	0.10 [.004]



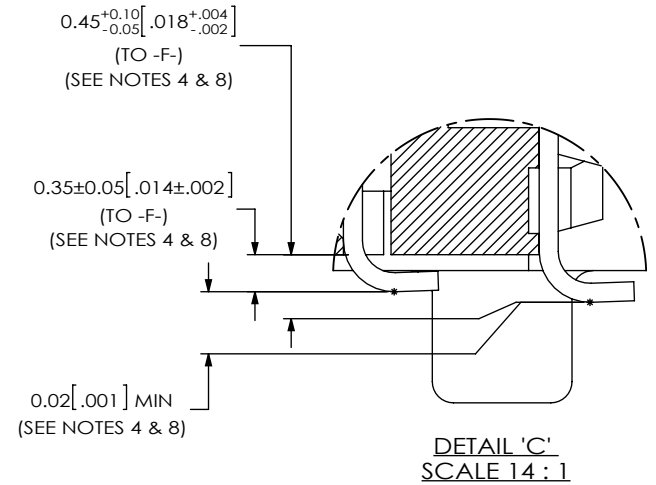
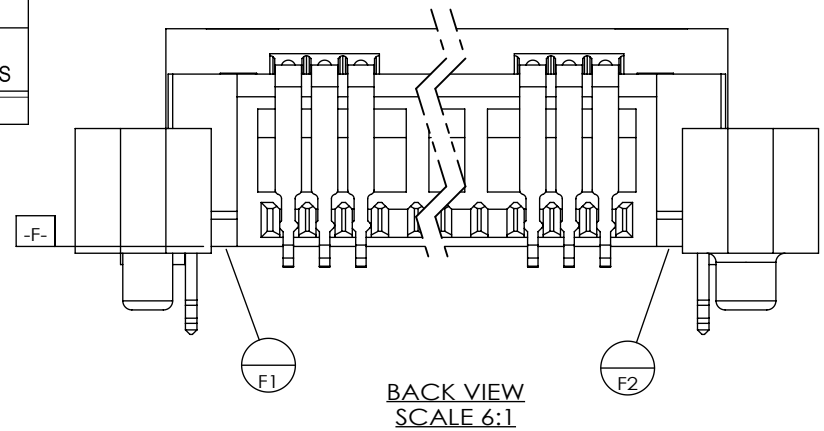
SECTION "A"-"A"



DETAIL 'D'



DETAIL 'E'



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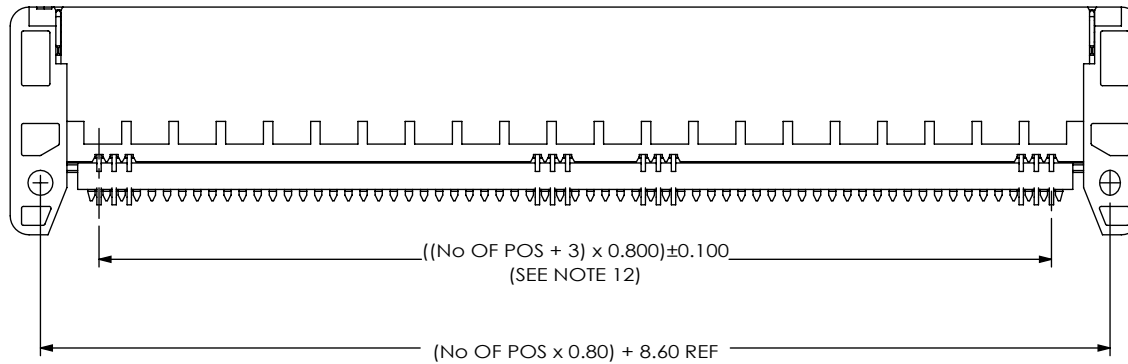
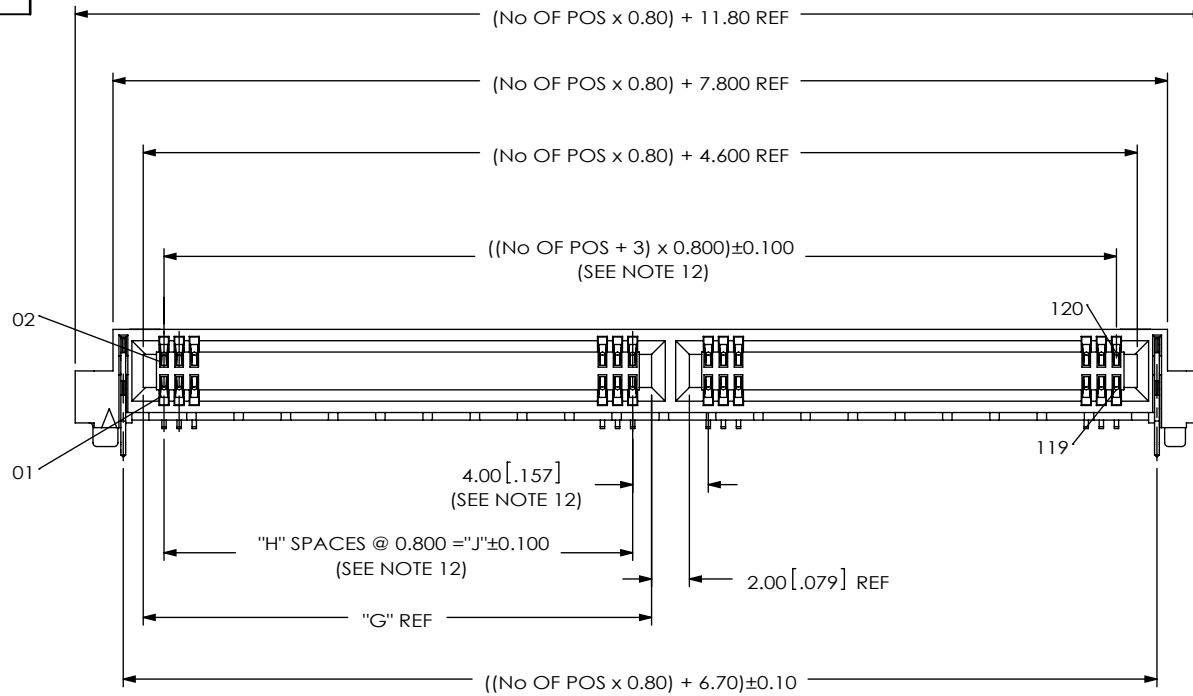
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BY: ROY LUO 11/05/2008 SHEET 2 OF 9



**FIG 2**  
 FOR POSITIONS -09, -13, -25, -40, -49, -50, -60  
 SAME AS FIG 1, UNLESS OTHERWISE STATED  
 HSEC8-160-01-X-RA SHOWN  
 (SOME CENTER FEATURES NOT SHOWN FOR CLARITY)

TABLE 2			
No OF POSITIONS	"G"	"H"	"J"
-09	4.500	3	2.400
-13	6.100	5	4.000
-25	6.100	5	4.000
-40	18.900	21	16.800
-49	22.900	26	20.800
-50	22.900	26	20.800
-60	26.900	31	24.800

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SHEET SCALE: 2.5:1

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DWG. NO.  
**HSEC8-1XX-XX-X-RA-XX-XX**

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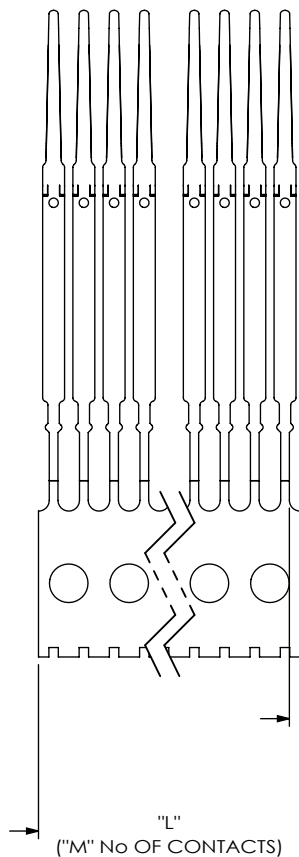
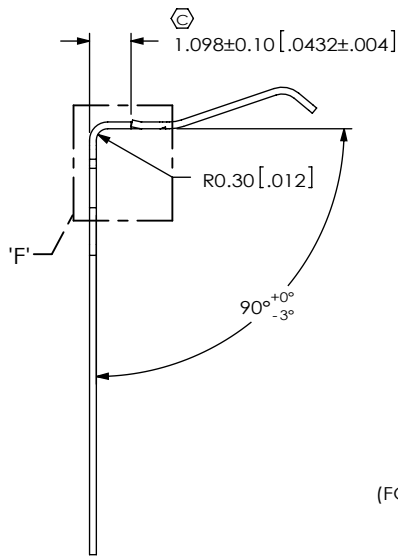


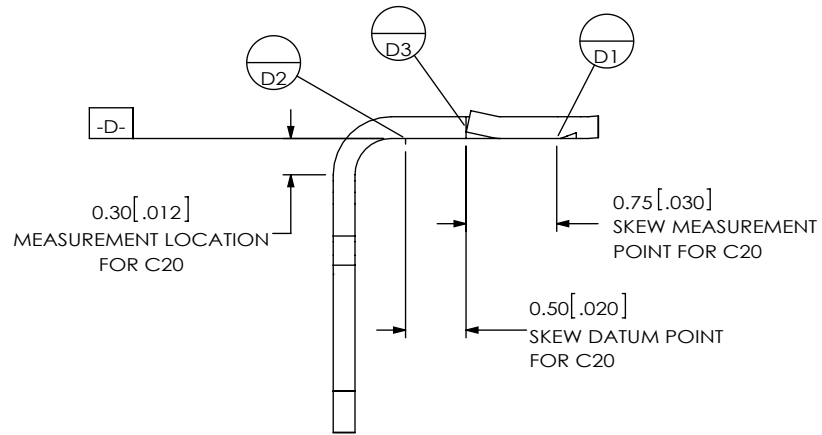
TABLE 3

POSITION	HAND FORM			AUTOMATION FORM		
	"L"	"M"	"N"	"L"	"M"	"N"
-09	10.41 [.410]	13	0.29	11.21 [.441]	14	1.09
-10	8.01 [.315]	10	0.29	8.01 [.315]	10	0.29
-13	13.61 [.536]	17	0.29	14.41 [.567]	18	1.09
-20	16.01 [.630]	20	0.29	16.01 [.630]	20	0.29
-25	23.21 [.914]	29	0.29	24.01 [.945]	30	1.09
-30	24.01 [.945]	30	0.29	24.01 [.945]	30	0.29
-40	35.21 [1.386]	44	0.29	36.81 [1.449]	46	1.09
-49	42.41 [1.670]	53	0.29	43.21 [1.701]	54	1.09
-50	43.21 [1.701]	54	0.29	43.21 [1.701]	54	0.29
-60	51.21 [2.016]	64	0.29	52.81 [2.079]	66	1.09

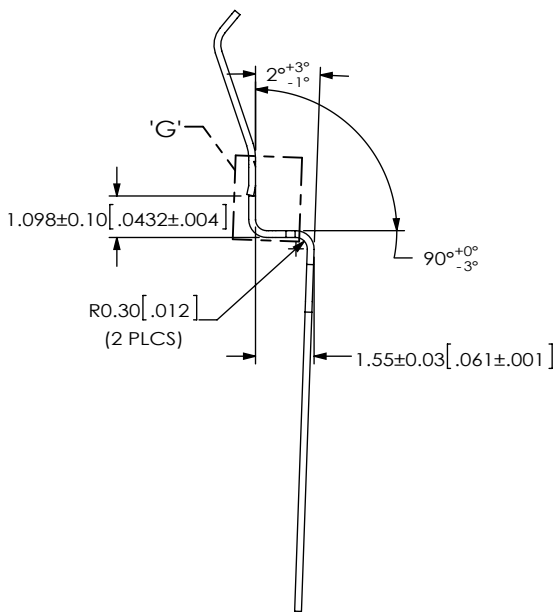
IN-PROCESS 1 & 2  
(COMB CUT CONTACT  
C-272-01-X & C-272-02-X)  
(USE FIXTURE AT-2194-815)



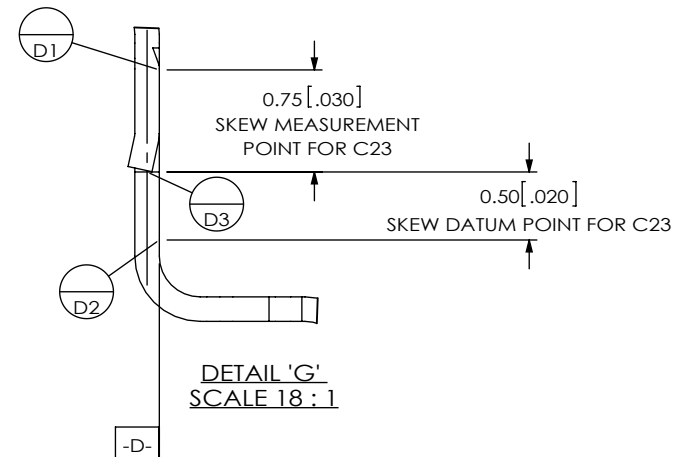
IN-PROCESS 2  
(FORM 1 CONTACT C-272-01-X)  
(USE FIXTURE AT-2194-815)  
(RIGHT SIDE SHOWN)  
(SEE NOTE 13)  
(ONLY APPLICABLE FOR HAND FORMING PINS)



DETAIL 'F'  
SCALE 16:1



IN-PROCESS 3  
(FORM 2 CONTACT C-272-01-X)  
(USE FIXTURE AT-2194-815)  
(RIGHT SIDE SHOWN)  
(SEE NOTE 13)



DETAIL 'G'  
SCALE 18:1

c:\enterprisevault\DWG\MISC\MKTG\HSEC8-1XX-XX-X-RA-XX-XX-MKT.SLDDRW

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SHEET SCALE: 5:1

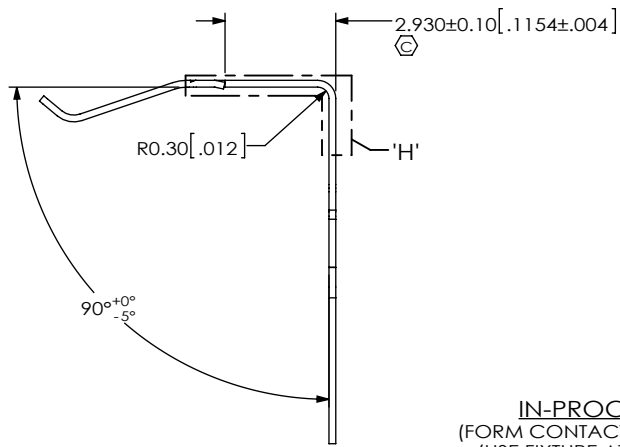


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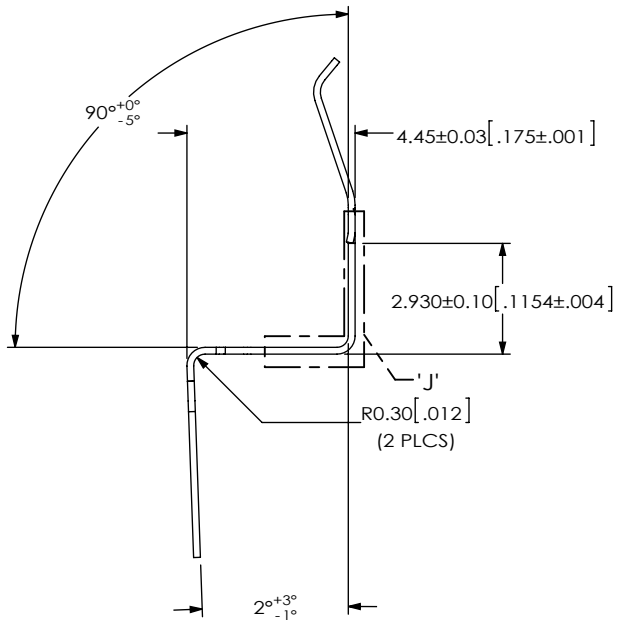
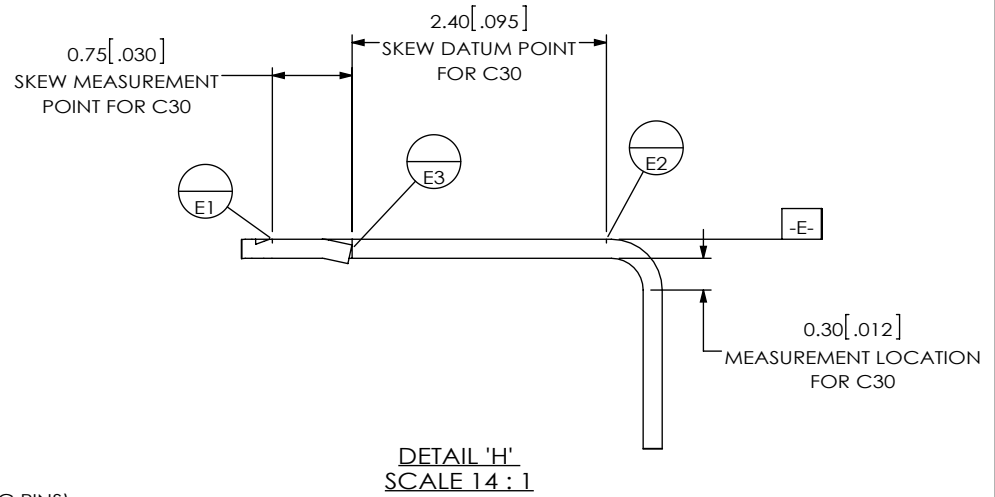
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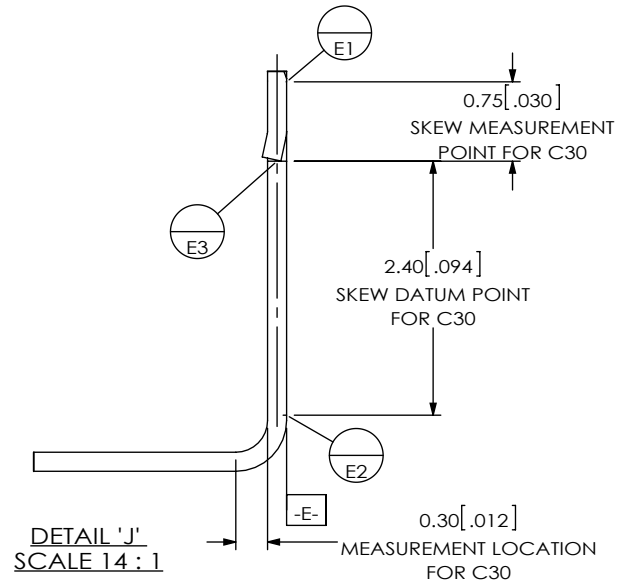
BY: ROY LUO 11/05/2008 SHEET 4 OF 9



**IN-PROCESS 8**  
 (FORM CONTACT C-272-02-X)  
 (USE FIXTURE AT-2194-815)  
 (LEFT SIDE SHOWN)  
 (SEE NOTE 13)  
 (ONLY APPLICABLE FOR HAND FORMING PINS)



**IN-PROCESS 9**  
 (FORM CONTACT C-272-02-X)  
 (USE FIXTURE AT-2194-815)  
 (LEFT SIDE SHOWN)  
 (SEE NOTE 13)



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SHEET SCALE: 5:1

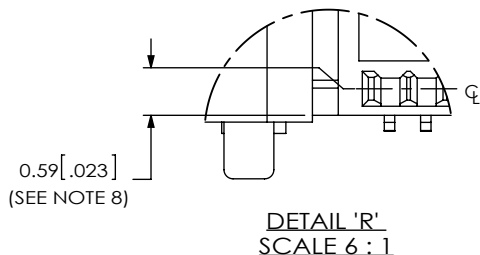
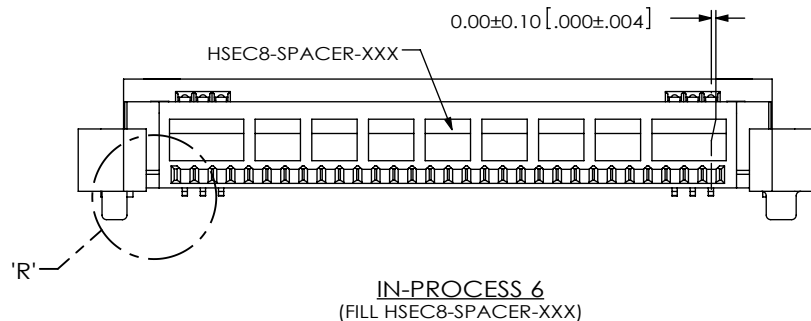
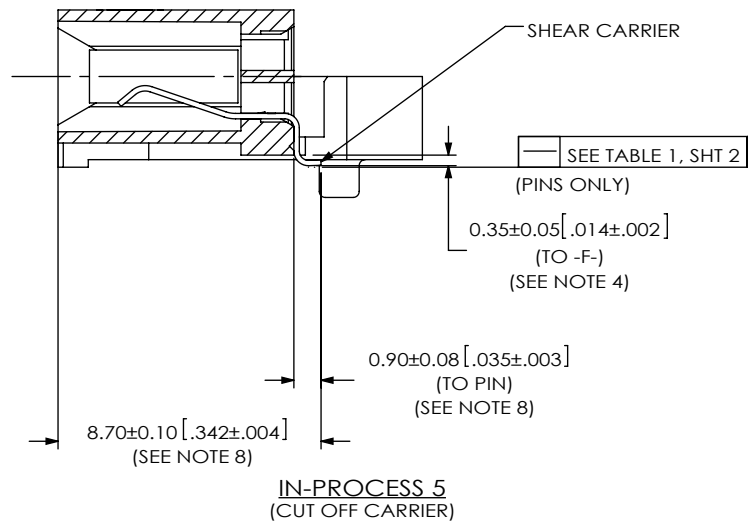
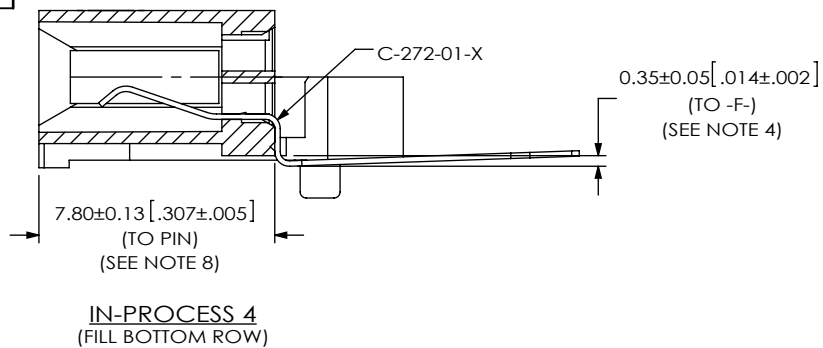



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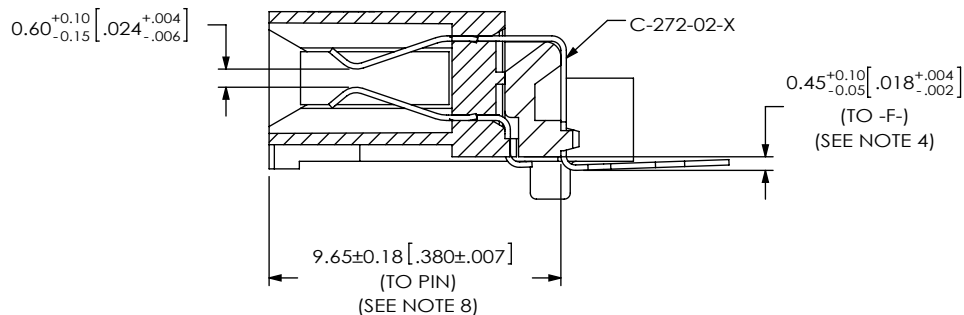
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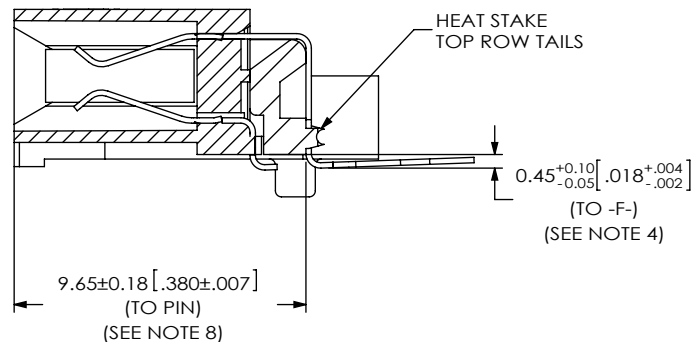
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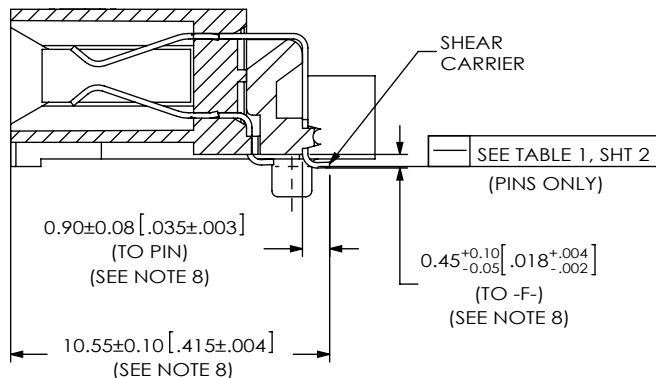
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	<p>DESCRIPTION: <b>0.8MM HIGH SPEED ASSEMBLY</b></p>	
	<p>DWG. NO. <b>HSEC8-1XX-XX-X-RA-XX-XX</b></p>	
<p>BY: ROY LUO 11/05/2008</p>		<p>SHEET 6 OF 9</p>



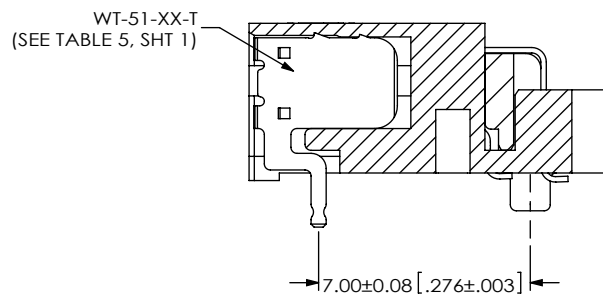
**IN-PROCESS 10**  
(FILL TOP ROW)



**IN-PROCESS 11**  
(HEAT STAKE TOP ROW CONTACTS)



**IN-PROCESS 12**  
(CUT OFF CARRIER)



**IN-PROCESS 13**  
(FILL WT-51-XX-T)

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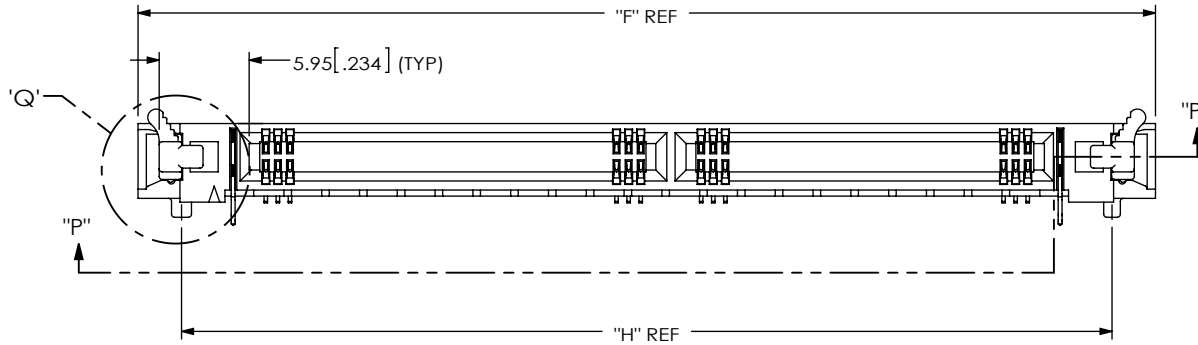
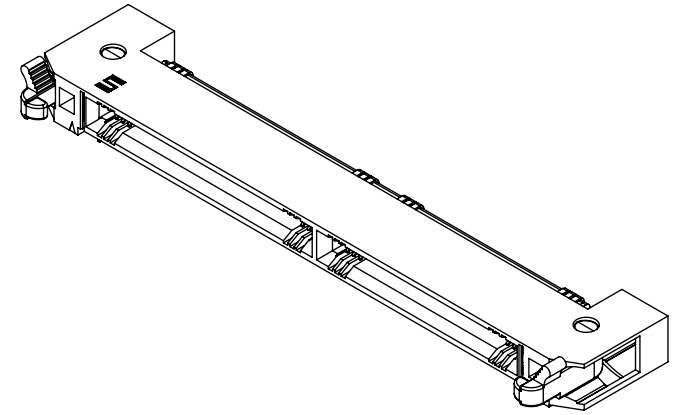
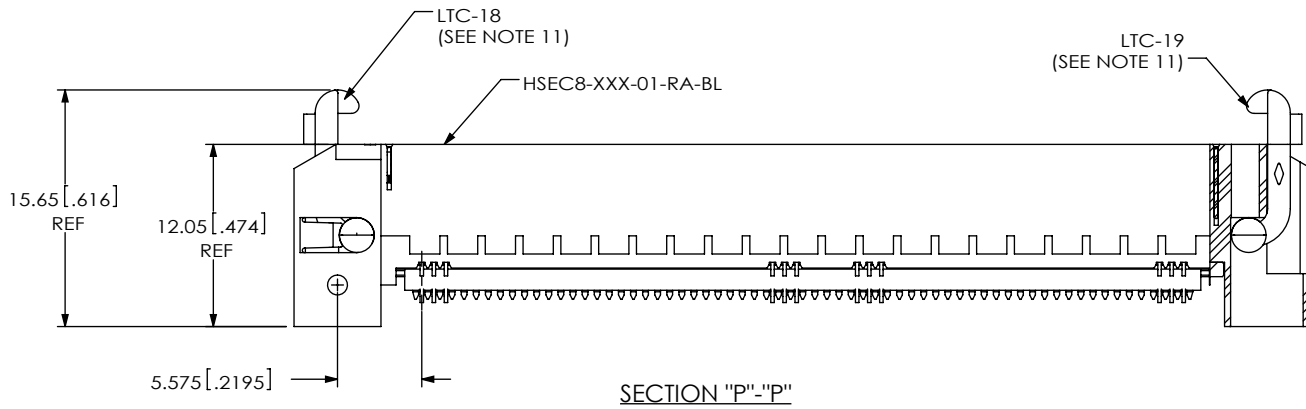


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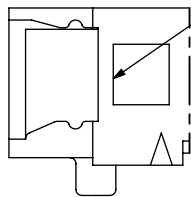
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**FIG 3**  
 -BL: BOARD LOCK OPTION ONLY AVAILABLE  
 FOR -09, -13, \*-20, -25, -40, -49, -50, -60 POSITIONS  
 (FOR -09, -13, -25, -40, -49, -50, -60 POSITIONS, SAME AS FIG 2, UNLESS OTHERWISE STATED)  
 (FOR \*-20 POSITION, SAME AS FIG 2, UNLESS OTHERWISE STATED)  
 HSEC8-160-01-X-RA-BL SHOWN  
 (SOME CENTER FEATURES NOT SHOWN FOR CLARITY)  
 (\* = NOT TOOLED)

No OF POSITIONS	"F"	"H"
-009	26.50	20.75
-013	29.70	23.95
*-020	32.10	26.35
-025	39.30	33.55
-040	51.30	45.55
-049	58.50	52.75
-050	59.30	53.55
-060	67.30	61.55

\* = NOT TOOLED



DETAIL 'Q'  
 SCALE 4 : 1

LTC-XX REMOVED FOR CLARITY

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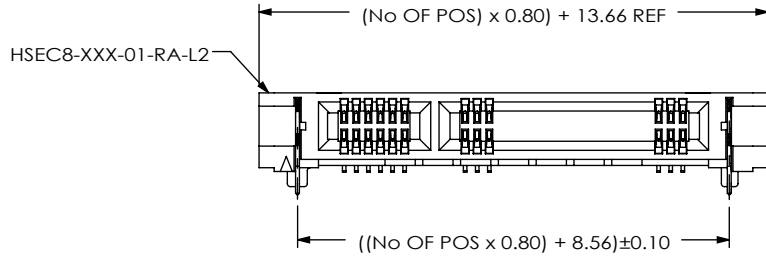
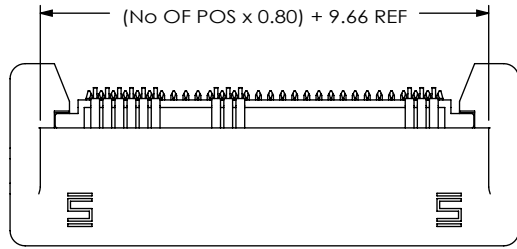
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**FIG 4**  
 -L2: ECDP LATCHING OPTION  
 AVAILABLE ONLY IN -09, -13, -25 & -49 POSITIONS  
 SAME AS FIG 2, UNLESS OTHERWISE STATED  
 HSEC8-125-01-X-RA-L2 SHOWN

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	<p>DESCRIPTION:                  0.8MM HIGH SPEED ASSEMBLY</p>		
	<p>DWG. NO.                  HSEC8-1XX-XX-X-RA-XX-XX</p>		
	<p>BY: ROY LUO</p>	<p>11/05/2008</p>	<p>SHEET 9 OF 9</p>