

DO NOT SCALE FROM THIS PRINT

**DESIGNED & DIMENSIONED IN INCHES[MILLIMETERS]**

SIR1-XX-X-S-X-X-XX

**No OF POSITIONS**  
 -03, -05, -07, -10, -15,  
 \*-20, \*-25, \*-30  
 (PER ROW)

**PACKAGING**  
 -TR: TAPE & REEL FOR OPTIONAL

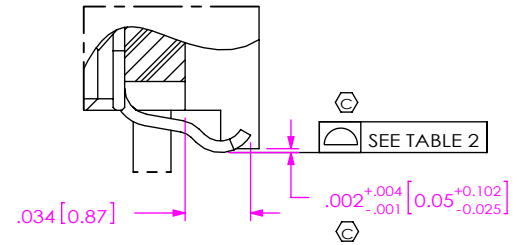
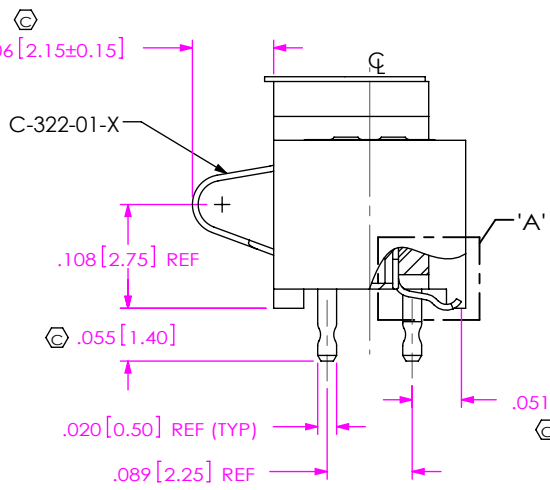
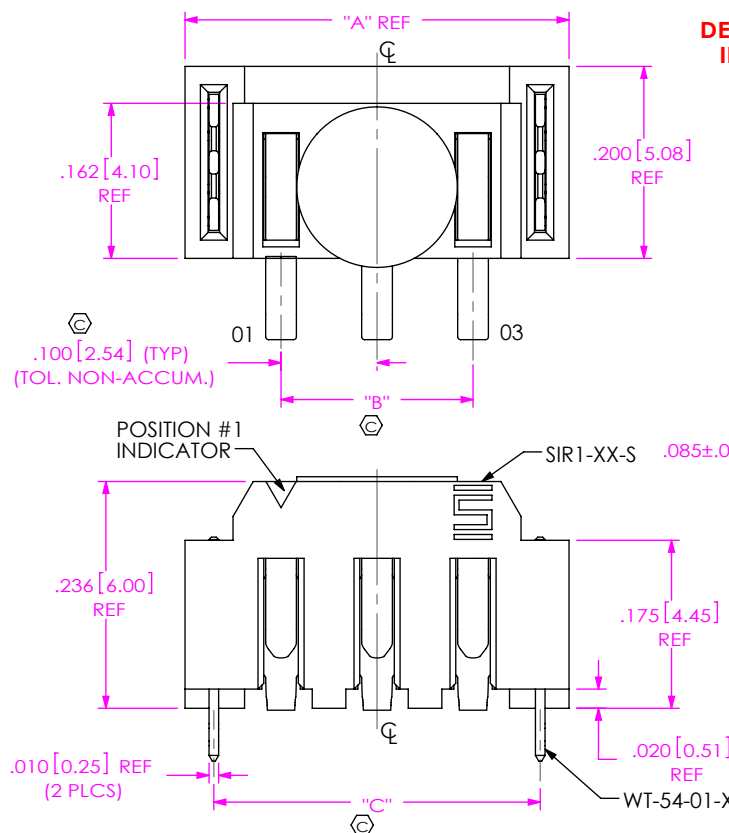
**PLATING SPECIFICATION**  
 -L: 10µ" GOLD IN CONTACT AREA,  
 MATTE TIN ON TAIL  
 -S: 30µ" GOLD IN CONTACT AREA,  
 MATTE TIN ON TAIL

**OPTION**  
 -A: ALIGNMENT PIN  
 (USE SIR1-XX-A-X)  
 -K: POLYAMIDE FILM  
 (USE K-DOT-.157-.250-.005,  
 SEE FIG. 3, SHT 2)

**ROW SPECIFICATION**  
 -S: SINGLE ROW

**THREADED INSERT OPTION**  
 \*-E: THREADED INSERT (ENGLISH)  
 (USE INS-14-2-56-115.)  
 \*-M: THREADED INSERT (METRIC)  
 (USE INS-14-M2-115-N)

(\* = NOT TOOLED)

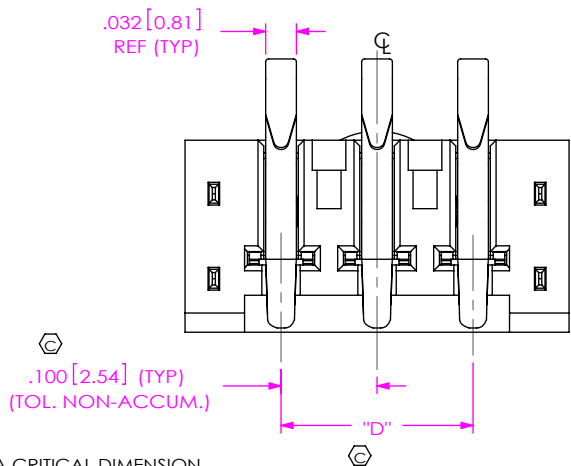


DETAIL 'A'  
 SCALE 10:1

No. OF POS	COPLANARITY
-03, -05, -07, -10, -15	.0040 [0.102]
*-20, *-25, & *-30	.0060 [0.152]

(\* = NOT TOOLED)

FIG 1  
 SIR1-03-X-S SHOWN  
 (FOR POSITIONS -03, -05, -10, & -15)



No. OF POS	"A"	"B"	"C"	"D"	"E"	"F"	"G"
-03	.400 [10.16]	.2000 [5.080]	.340 [8.64]	.2000 [5.080]	N/A	N/A	N/A
-05	.600 [15.24]	.4000 [10.160]	.540 [13.72]	.4000 [10.160]	N/A	N/A	N/A
-07	.800 [20.32]	.6000 [15.240]	.740 [18.80]	.6000 [15.240]	N/A	N/A	N/A
-10	1.100 [27.94]	.9000 [22.860]	1.040 [26.42]	.9000 [22.860]	N/A	N/A	N/A
-15	1.600 [40.64]	1.4000 [35.560]	1.540 [39.12]	1.4000 [35.560]	N/A	N/A	N/A
*-20	2.200 [55.88]	2.0000 [50.800]	2.140 [54.36]	2.0000 [50.800]	1.0700 [27.178]	1.1000 [27.940]	.9000 [22.860]
*-25	2.700 [68.58]	2.5000 [63.500]	2.640 [67.06]	2.5000 [63.500]	1.3700 [34.798]	1.4000 [35.560]	1.2000 [30.480]
*-30	3.200 [81.28]	3.0000 [76.200]	3.140 [79.76]	3.0000 [76.200]	1.5700 [39.878]	1.6000 [40.640]	1.4000 [35.560]

(\* = NOT TOOLED)

NOTES:

- ⊕ REPRESENTS A CRITICAL DIMENSION.
- BURR ALLOWANCE: .0015[.038] MAX.
- MINIMUM PUSHOUT FORCE: .5 LB[2.2 N].
- LOAD INSERTS IN DIRECTION OF THE ARROW USING HAND LOAD THERMAL INSERTION PRESS.
- THREADED INSERT MUST BE ABLE TO HANDLE 20 in-oz's OF TORQUE MIN WITHOUT ROTATING OR "LOOSENING".
- THREADED INSERT RETENSION TO BE 7lbs. MIN.
- THREADED INSERT TO BE FLUSH TO .005[0.13] BELOW HOUSING SURFACE.
- NOTE DELETED.
- ASSEMBLIES TO BE PACKAGED IN TUBES, UNLESS -TR IS SPECIFIED.

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES.  
 TOLERANCES ARE:  
 DECIMALS ANGLES  
 .XX: ±.01 [.3] 2°  
 .XXX: ±.005 [.13]  
 .XXXX: ±.0020 [.051]

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520 PARK EAST BLVD. NEW ALBANY, IN 47150  
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**MATERIAL:** DO NOT SCALE DRAWING SHEET SCALE: 5:1  
 INSULATOR: LCP, COLOR: BLACK  
 CONTACT: PHOS BRONZE  
 WELD TAB: PHOS BRONZE

**DESCRIPTION:**  
 ONE PIECE POWER RIGHT ANGLE ASSEMBLY  
 DWG. NO. SIR1-XX-X-S-X-X-XX

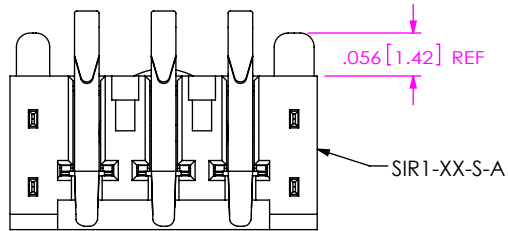
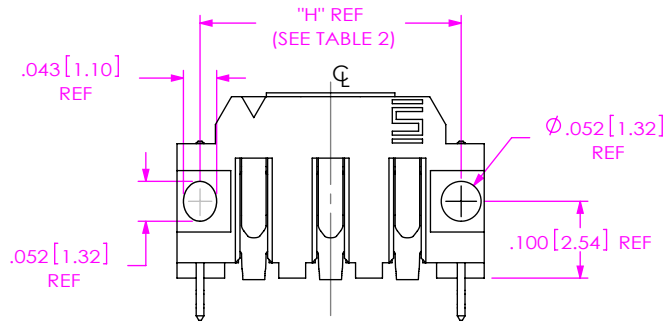
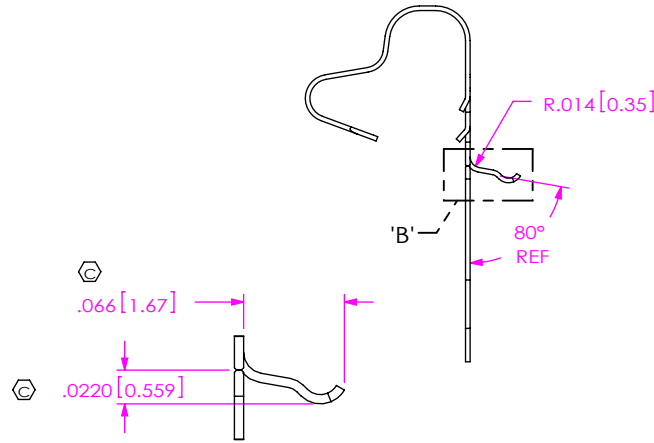
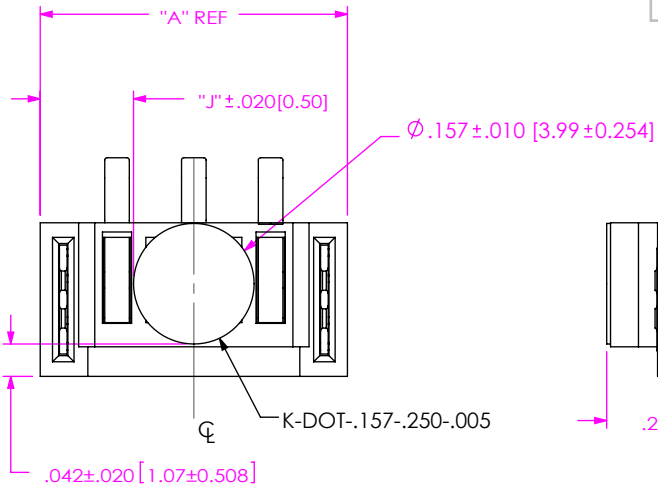
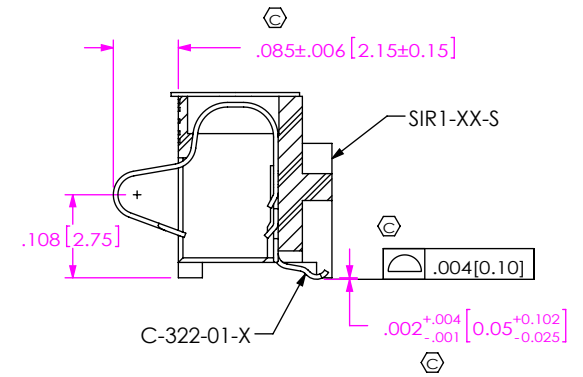


FIG 2  
(SIR1-03-X-S-A SHOWN)  
(SAME AS FIG 1, EXCEPT AS SHOWN)

FIG 3  
(SIR1-03-X-S-K SHOWN)  
(SAME AS FIG 1, EXCEPT AS SHOWN)



DETAIL 'B'  
SCALE 8 : 1  
IN-PROCESS 1  
(FORM CONTACT C-322-01-X)

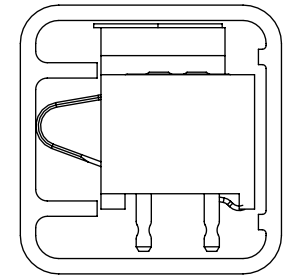


IN-PROCESS 2  
(FILL CONTACT C-322-01-X)

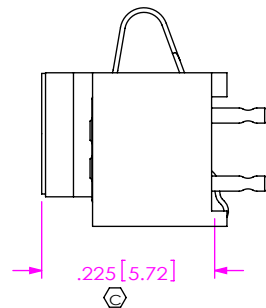
**TABLE 3**

No. OF POS	"H"	"J"
-03	.3400 [8.636]	.122 [3.10]
-05	.5400 [13.716]	.222 [5.64]
-07	.7400 [18.796]	.322 [8.18]
-10	1.0400 [26.416]	.472 [11.99]
-15	1.5400 [39.116]	.722 [18.34]
*-20	2.1400 [54.356]	1.022 [25.96]
*-25	2.6400 [67.056]	1.272 [32.31]
*-30	3.1400 [79.756]	1.522 [38.66]

(\* = NOT TOOLED)



PACKAGING VIEW  
TUBE: PT-1-24-11-63  
PLUG: TP-09



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DO NOT SCALE DRAWING

SHEET SCALE: 4:1



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e-Mail info@SAMTEC.com code 55322

DESCRIPTION:  
ONE PIECE POWER RIGHT ANGLE ASSEMBLY

DWG. NO.  
SIR1-XX-X-S-X-X-XX

BY: ROY LUO 5/20/2010 SHEET 2 OF 3

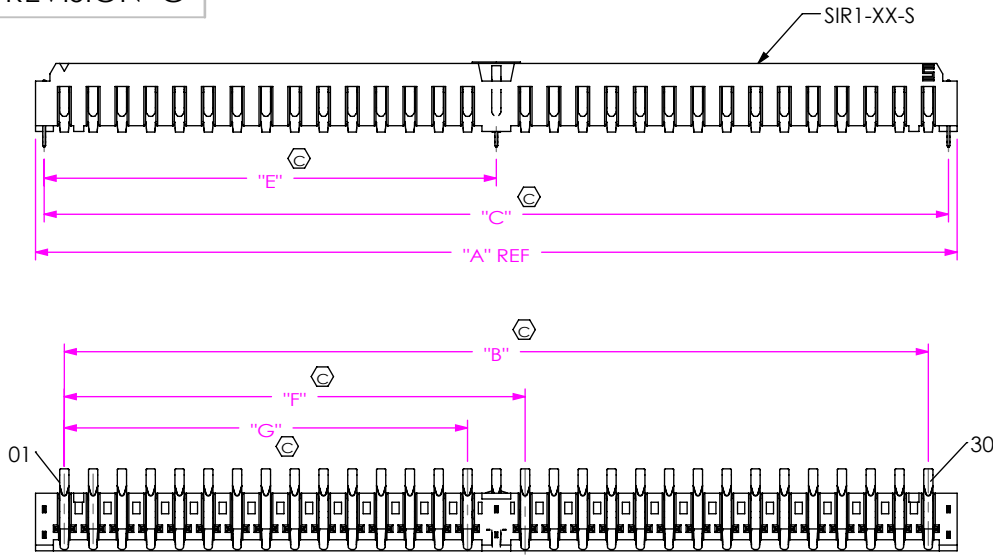


FIG 4  
(SIR1-30-X-S SHOWN)  
(SAME AS FIG 1, EXCEPT AS SHOWN)  
(FOR POSITIONS -20, -25, & -30)  
(NOT TOOLED)

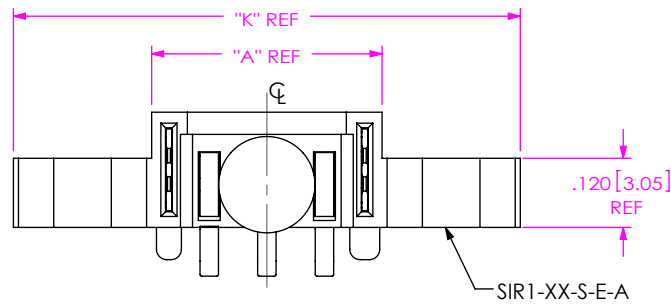
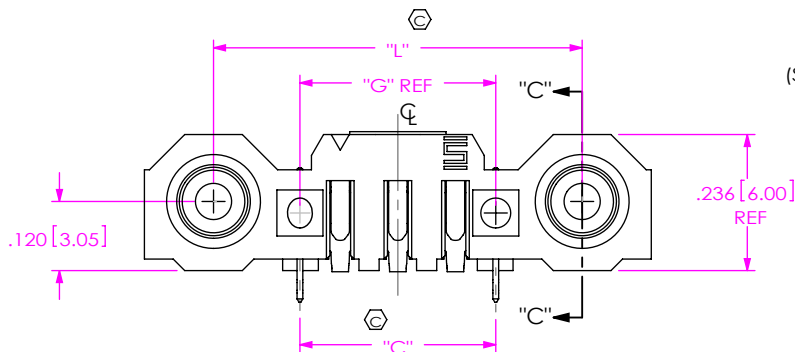


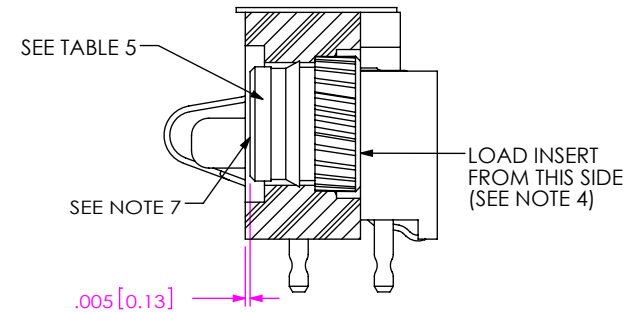
FIG 5  
-E & -M OPTION  
(SIR1-03-X-S-X-A SHOWN)  
(SAME AS FIG 2, EXCEPT AS SHOWN)  
(NOT TOOLED)



No. OF POS	"K"	"L"
-03	.880 [22.352]	.640 [16.26]
-05	1.080 [27.432]	.840 [21.34]
-07	1.280 [32.512]	1.040 [26.42]
-10	1.580 [40.132]	1.340 [34.04]
-15	2.080 [52.832]	1.840 [46.74]
-20	2.680 [68.072]	2.440 [61.98]
-25	3.180 [80.772]	2.940 [74.68]
-30	3.680 [93.472]	3.440 [87.38]

OPTION	THREADED INSERT
-E	INS-14-2-56-115
**M	INS-14-M2-115-N

\*\* = METRIC THREADED INSERTS  
TO BE FLASH NICKEL PLATED



SECTION "C"-"C"  
SCALE 5 : 1

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DO NOT SCALE DRAWING

SHEET SCALE: 3:1



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ONE PIECE POWER RIGHT ANGLE ASSEMBLY

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BY: ROY LUO 5/20/2010 SHEET 3 OF 3