

## REVISION BD

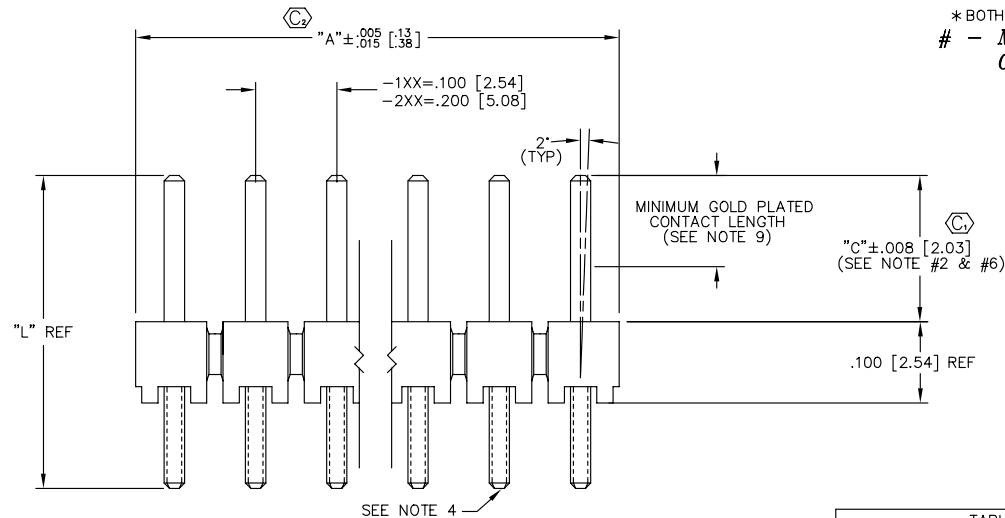
DO NOT SCALE  
FROM THIS PRINT

TABLE 1

## TERMINAL SPECIFICATIONS

TERMINAL SPEC	PIN #1	"L"	PIN #2 <sup>(2)</sup>	PIN #3	"C"
-05 <sup>(3)</sup>	T-1S6-21-XX-2	.335 [8.51]	N/A	N/A	.105 [2.67] <sup>(5)</sup>
-06 <sup>(3)</sup>	T-1S6-18-XX-2	.300 [7.62]	N/A	N/A	.105 [2.67] <sup>(5)</sup>
-07 <sup>(3)</sup>	T-1S6-07-XX-2	.430 [10.92]	N/A	N/A	.230 [5.84] <sup>(5)</sup>
-08 <sup>(4)</sup>	T-1S6-08-XX-2	.530 [13.46]	T-1S6-09-XX-2	T-1S6-11-XX-2	.230 [5.84] <sup>(5)(6)</sup>
-09	T-1S6-09-XX-2	.730 [18.54]	T-1S6-11-XX-2	T-1S6-20-XX-2	.230 [5.84] <sup>(6)</sup>
-10	T-1S6-10-XX-2	.830 [21.08]	T-1S6-12-XX-2	T-1S6-13-XX-2	.230 [5.84]
-11	T-1S6-11-XX-2	.930 [23.62]	T-1S6-20-XX-2	T-1S6-19-XX-2	.230 [5.84]
-12	T-1S6-12-XX-2	1.030 [26.16]	T-1S6-13-XX-2	T-1S6-14-XX-2	.230 [5.84]
-13	T-1S6-13-XX-2	1.230 [31.24]	T-1S6-14-XX-2	N/A	.230 [5.84]
-14 <sup>(3)</sup>	T-1S6-08-XX-2	.530 [13.46]	N/A	N/A	.320 [8.13] <sup>(5)</sup>
-15 <sup>(3)</sup>	T-1S6-09-XX-2	.730 [18.54]	N/A	N/A	.520 [13.20] <sup>(5)</sup>
-16	T-1S6-09-XX-2	.730 [18.54]	T-1S6-11-XX-2	T-1S6-20-XX-2	.320 [8.13] <sup>(5)(6)</sup>
-17 <sup>(3)</sup>	T-1S6-10-XX-2	.830 [21.08]	N/A	N/A	.620 [15.75] <sup>(5)</sup>
-18 <sup>(3)</sup>	T-1S6-11-XX-2	.930 [23.62]	N/A	N/A	.720 [18.29] <sup>(5)</sup>
-19 <sup>(3)</sup>	T-1S6-12-XX-2	1.030 [26.16]	N/A	N/A	.820 [20.83] <sup>(5)</sup>
-20 <sup>(3)</sup>	T-1S6-13-XX-2	1.230 [31.24]	N/A	N/A	1.020 [25.91] <sup>(5)</sup>
-21	T-1S6-14-XX-2	1.430 [36.62]	N/A	N/A	1.220 [30.99] <sup>(5)</sup>
-21 <sup>(1)</sup>	T-1S6-14-XX-2	1.430 [36.62]	N/A	N/A	.230 [5.84]
-22	T-1S6-15-XX-2	.630 [16.00]	T-1S6-10-XX-2	T-1S6-12-XX-2	.230 [5.84] <sup>(5)(6)</sup>
-23 <sup>(3)</sup>	T-1S6-16-XX-2	.445 [11.30]	N/A	N/A	.230 [5.84] <sup>(5)</sup>
-24 <sup>(3)</sup>	T-1S6-17-XX-2	.480 [12.19]	N/A	N/A	.265 [6.73] <sup>(5)</sup>
-25 <sup>(4)</sup>	T-1S6-15-XX-2	.630 [16.00]	T-1S6-10-XX-2	T-1S6-12-XX-2	.320 [8.13] <sup>(5)(6)</sup>
-26 <sup>(3)</sup>	T-1RS7-01-XX-2	.456 [11.58]	N/A	N/A	.230 [5.84]
-27	T-1S6-19-XX-2	1.330 [33.78]	N/A	N/A	.230 [5.84]
-28	T-1S6-20-XX-2	1.130 [28.70]	T-1S6-19-XX-2	N/A	.230 [5.84]
-29 <sup>(4)</sup>	T-1S6-19-XX-2	1.330 [33.78]	N/A	N/A	.320 [8.13]
-30 <sup>(4)</sup>	T-1S6-20-XX-2	1.130 [28.70]	T-1S6-19-XX-2	N/A	.320 [8.13]
-41	T-1S6-25-XX-2	.365 [9.27]	N/A	N/A	.230 [5.84]
-42	T-1S6-26-XX-2	.470 [11.94]	N/A	N/A	.320 [8.13]

- (1) WITH -RA OR -RE OPTION  
(2) OMIT WITH -O ROW SPECIFICATION  
(3) NOT AVAILABLE IN -RA OR -RE OPTION.  
(4) NOT AVAILABLE IN -RE OPTION.  
(5) AVAILABLE IN -LL OPTION.  
(6) AVAILABLE IN -LA OPTION.  
(7) ON STYLE -08 -RA & -LA  
OPTIONS ONLY; 'C' = .230±.008 [5.84±.20]



## NOTES:

- TERMINAL PUSHOUT FORCE: 3 LBS. MIN.
- HEIGHT VARIATION BETWEEN A PIN AND ANY ADJACENT PIN SHALL BE .005 [0.13] MAX (R.A. TAIL N/A).
- ASSEMBLE GOLD PLATE END AS SHOWN.
- TERMINAL SPEC. STYLE -26 (T-1RS7-01-X-2): ROUND END TO APPEAR ON BOTTOM.
- NOTE DELETED
- (C) REPRESENTS CRITICAL DIMENSION FOR STATISTICAL PROCESS CONTROL.
- C±.008 [0.20] FOR STYLE -08, OPTIONS -RA & -LA ONLY.
- TOW & SWAY SPEC. OF 2" APPLIES TO ALL POSITIONS, POST & TAIL, IN ALL DIRECTIONS.
- .165 [4.19] REF, EXCEPT PINS -18, -21 & 25 ARE .050 [1.27] REF.
- CRIMP TWO PINS CLOSEST TO CENTER OF THE PART IF THERE IS A POLARIZED POSITION IN THE MIDDLE/CENTER.
- NOTE DELETED.

PROPRIETARY NOTE  
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DIMENSIONS ARE IN INCHES  
UNLESS OTHERWISE NOTED

TOLERANCES ARE:

ONE PLACE DECIMALS ± .1 [2.54] THREE PLACE DECIMALS ± .005 [.13]  
TWO PLACE DECIMALS ± .01 [.25] FOUR PLACE DECIMALS ± .0020 [.051]

ANGLES  
± 2°

TITLE: ASSEMBLY,  
.025 SQ. POST  
HI-TEMP  
TERMINAL STRIP

DWG NO:  
HTSW-XXX-XX-XXX-X-XX-XX-XX  
SHEET 1 OF 3

HTSW-XXX-XX-XXX-X-XX-XX-XX

TERMINAL SPACE SPEC.  
(SEE ASSEMBLY INSTR.)  
-1= .100 [2.54] (FILL EVERY POS.)  
-2= .200 [5.08] (FILL E/O POS. STARTING  
W/ 1st & ENDING W/ LAST  
POS. IN BODY)

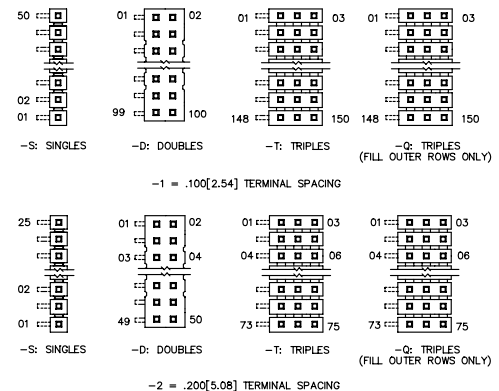
BODY LENGTH SPEC.  
EXPRESSED IN # OF POS.  
-1: -01 THRU -50 (-S,-D,-T,-RA)  
-01 THRU -50 (-S,-RE,-S-RA,-D-RA)  
"A"= NO. OF POS. x .100  
-2: -02 THRU -25 (-S,-D,-T,-RA)  
-02 THRU -25 (-S,-RE,-S-RA,-D-RA)  
"A"= (NO OF POS. x .200)-.100

TERMINAL SPECIFICATION  
SEE TABLE 1

## PLATING SPECIFICATIONS

- G: GOLD
- T: TIN
- S: SELECTIVE HEAVY GOLD
- H: HEAVY GOLD
- L: SELECTIVE LIGHT GOLD
- F: FLASH SELECTIVE GOLD
- P: GOLD FLASHED PALLADIUM NICKEL (N/A IN STYLES -05 & -06)
- E: EXTRA HEAVY GOLD (AVAILABLE IN STYLES -07,-08,-09 STRAIGHT)  
(-08 DOUBLE RIGHT ANGLE)
- TL: TIN/LEAD (AVAILABLE ONLY ON LEAD STYLES -07, -08 & -09)
- TM: MATTE TIN
- SM: HEAVY SELECTIVE GOLD, MATTE TIN TAIL
- LM: LIGHT SELECTIVE GOLD, MATTE TIN TAIL
- FM: FLASH SELECTIVE GOLD, MATTE TIN TAIL
- STL: HEAVY SELECTIVE GOLD, TIN / LEAD (93/7±5%)TAIL

\* BOTH THE -LC OPTION AND THE -MW OPTION MAY NOT BE ON THE SAME ASSEMBLY.  
# - MW OPTION, DO NOT DESIGN IN. SAMTEC WILL  
ONLY SUPPORT EXISTING BUSINESS 2/12/02.



## POLARIZATION

(STRAIGHT &amp; RA VERSIONS)

FIG. 1

## MATERIAL:

BODIES:  
LIQUID CRYSTAL POLYMER  
COLOR: NATURAL

TERMINALS:  
PHOSPHOR BRONZE

EXISPROD\ASSEMBLY\100  
HTSWASH1

**samtec**

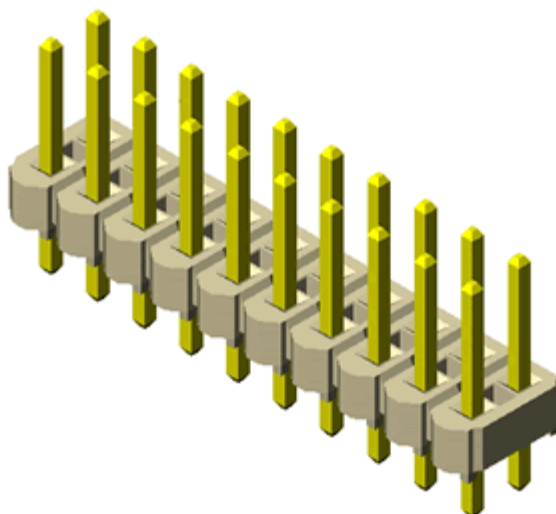
520 PARK EAST BLVD. NEW ALBANY, INDIANA 47150  
PHONE (812) 944-6733 P.O. BOX 1147  
CODE 55322

MADE BY:  
PURVIS 2-17-87

HTSW-XXX-XX-XXX-X-XX-XX-XX  
SHEET 1 OF 3



Project Number: Lead Free		Tracking Code: TC0310-Lead Free-0120	
Requested by: John Schmelz		Date: 3/4/2003	Product Rev: AU
Part #: HTSW-150-07-L-D		Lot #: NA	Tech: J.S. Eng: J.S.
Part description: HTSW			Qty to test: 10
Test Start: 3/4/2003	Test Completed: 3/6/2003		



**Perform Solder Heat Resistance using three temperature profiles: 230°C, 260°C and 280°C.  
Summary Report**

#### **PART DESCRIPTION**

**HTSW-150-07-L-D**

**CERTIFICATION**

All instruments and measuring equipment were calibrated to National Institute for Standards and Technology (NIST) traceable standards according to ISO 10012-1 and ANSI/NCSL 2540-1, as applicable.

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**SCOPE**

Perform Solder Heat Resistance using three temperature profiles: 230° C, 260° C and 280° C.

**APPLICABLE DOCUMENTS**

Standards: EIA Publication 364

**TEST SAMPLES AND PREPARATION.**

- 1) Parts are visually inspected for cleanliness.

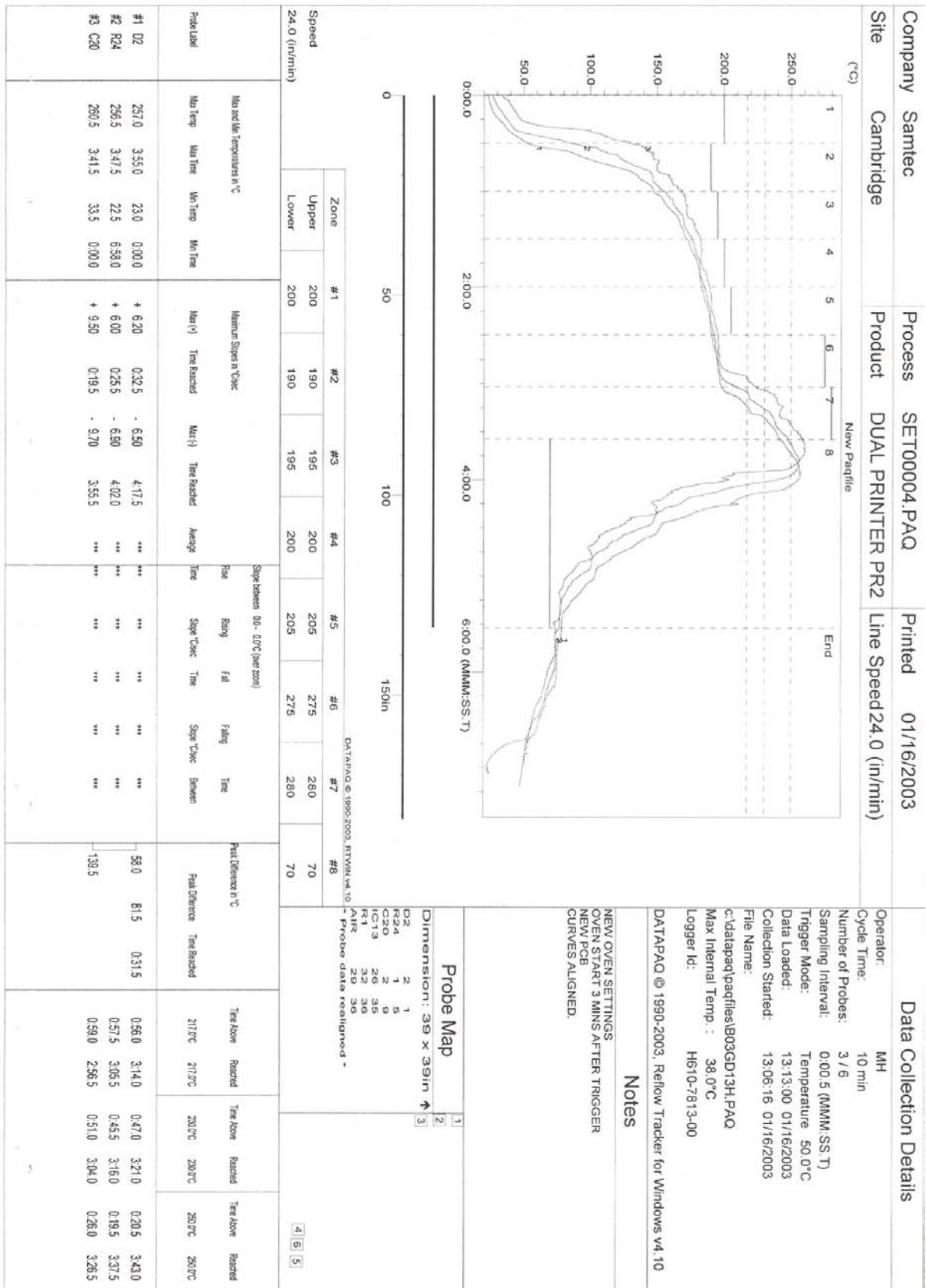
**FLOWCHART**

TEST STEP	260 °C		280 °C GROUP D	230 °C GROUP E Control
01	1 Pass	Group A	1 Pass	1 Pass
02	Solder Heat Resistance		Solder Heat Resistance	Solder Heat Resistance
03	2nd Pass	Group B		
04	Solder Heat Resistance			
05	3rd Pass	Group C		
06	Solder Heat Resistance			

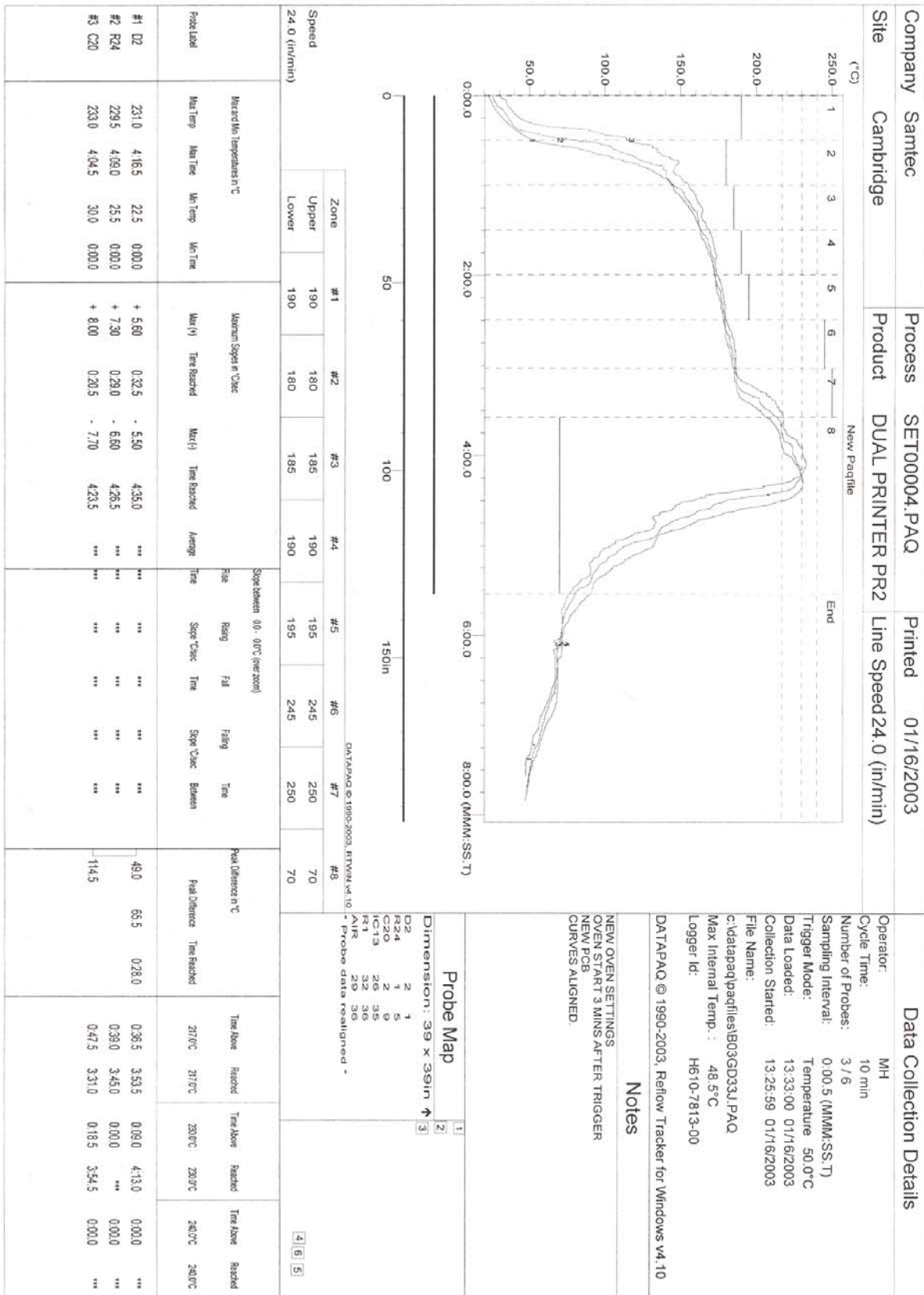
**Solder Heat Resistance (Visual): Blistering, Distortion  
(Bowed or Twisted), Discoloration**

**OVEN THERMAL PROFILE (Control):**

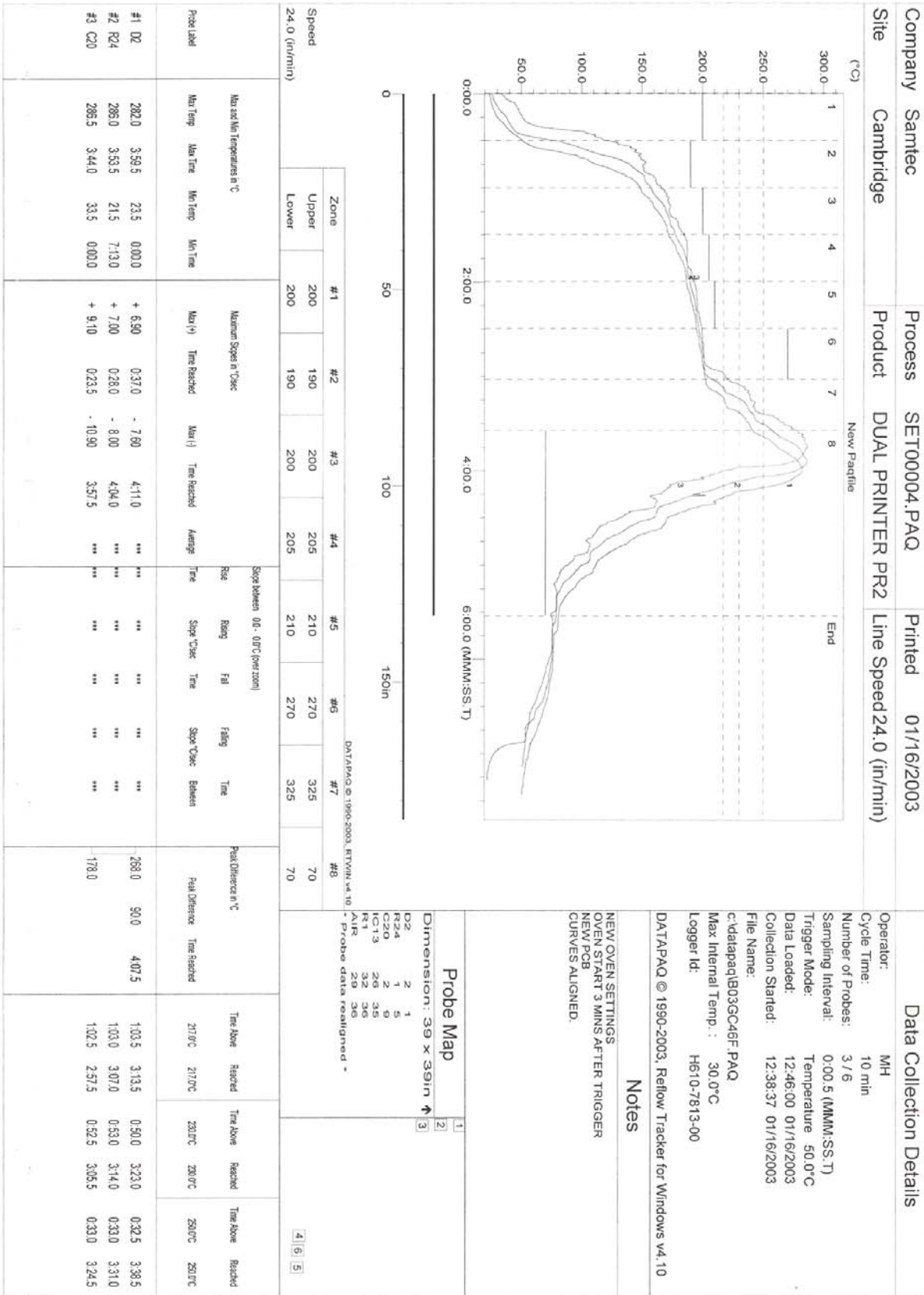
1) The Following Thermal Profiles were used to stress the parts.



# OVEN THERMAL PROFILE, SUPPLEMENTAL TEST: Solder Heat Resistance (Visual) at 230 °C



# OVEN THERMAL PROFILE, SUPPLEMENTAL TEST Continued: Solder Heat Resistance (Visual) at 280 °C



Tracking Code: TC0310-Lead Free-0120	Part #: HTSW-150-07-L-D
Part description: HTSW	

**ATTRIBUTE DEFINITION**

**SOLDER HEAT RESISTANCE (Visual):**

- 1) Blistering
  - a) Pass/Fail
- 2) Distortion
  - a) Bowed or Twisted
- 3) Discoloration
  - a) Pass/Fail

## RESULTS

### Solder Heat Resistance, 260 °C Thermal Stressing

- **Blistering**
  - One Thermal Stress-----Pass
  - Two Thermal Stresses-----Pass
  - Three Thermal Stresses-----Pass
- **Distortion**
  - One Thermal Stress-----Pass
  - Two Thermal Stresses-----Pass
  - Three Thermal Stresses-----Pass
- **Discoloration**
  - One Thermal Stress-----Pass
  - Two Thermal Stresses-----Pass
  - Three Thermal Stresses-----Pass

### Supplemental Tests

#### Solder Heat Resistance, 230°C Thermal Stressing

- **Blistering**
  - One Thermal Stress-----Pass
- **Distortion**
  - One Thermal Stress-----Pass
- **Discoloration**
  - One Thermal Stress-----Pass

#### Solder Heat Resistance, 280 °C Thermal Stressing

- **Blistering**
  - One Thermal Stress-----Pass
- **Distortion**
  - One Thermal Stress-----Pass
- **Discoloration**
  - One Thermal Stress-----Pass

Tracking Code: TC0310-Lead Free-0120	Part #: HTSW-150-07-L-D
Part description: HTSW	

## EQUIPMENT AND CALIBRATION SCHEDULES

**Equipment #:** THL-01

**Description:** Temperature/Humidity Chart Recorder

**Manufacturer:** Dickson

**Model:** THDX

**Serial #:** 9316255

**Accuracy:** Temp: +/- 1C; Humidity: +/-2% RH (0 - 60%) +/- 3% RH (61 - 95%).

... Last Cal: 7/15/02, Next Cal: 7/15/03

**Equipment #:** OV-5

**Description:** Nitrogen Purge IR Reflow

**Manufacturer:** Vitronics Soltec

**Model:** XPM-730

**Serial #:** XN 70328

**Accuracy:** + / - 5° C