

FIG 4  
XXX: POLARIZATION LOCATION  
INSERT PK-06-N INTO SPECIFIED POS  
AND BREAK OFF TAB

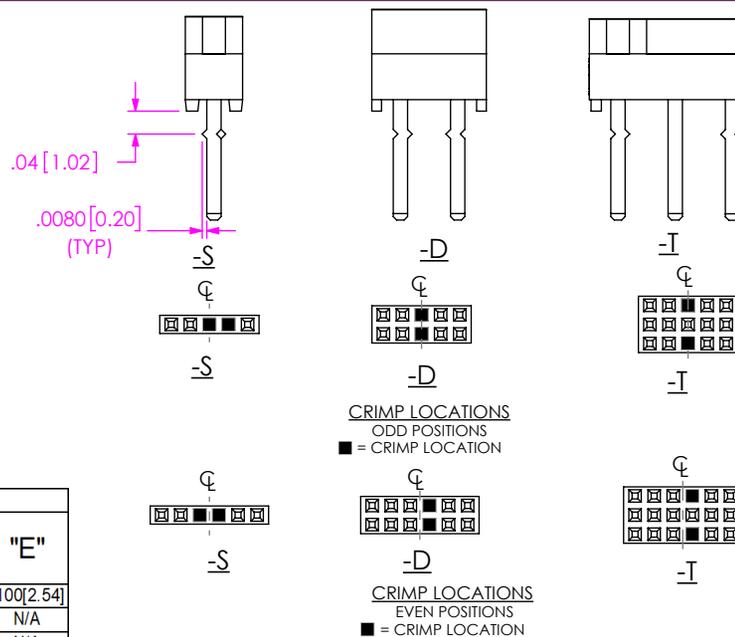


FIG 2  
-LL: LOCKING LEAD OPTION  
LOCATED ON OR ABOUT CENTERLINE  
[N/A IN 1 OR 2 POSITION SINGLE ROW] F:\DWG\SW\Exisprod\Assembly\100\ESQ-1XX-XX-X-XXX-XX-X-XX.slddrw

		TABLE 1 SPACER SPECIFICATION (FOR A ONE POSITION SINGLE SEE NOTE 3)			"B" (SEE TABLE 3)	"C"	"D"	"E"
STANDARD INSERTION FORCE	CONTACT	ESQ-S	ESQ-D	ESQ-T				
-12	C-15-2-X	N/A	N/A	N/A	.09[2.29]	.435[11.05]	.525[13.33]	.100[2.54]
-13	C-15-3-X	N/A	N/A	N/A	.29[7.37]	.435[11.05]	.725[18.41]	N/A
-14	C-15-4-X	N/A	N/A	N/A	.48[12.2]	.435[11.05]	.915[23.24]	N/A
-23	C-15-3-X	(1) SUB-SSB-32	(1) DSB-XX	(1) SUB-SSB-32 (1) DSB-XX	.19[4.83]	.535[13.59]	.725[18.41]	N/A
-24	C-15-4-X	(1) SUB-SSB-32	(1) DSB-XX	(1) SUB-SSB-32 (1) DSB-XX	.38[9.65]	.535[13.59]	.915[23.24]	N/A
-33	C-15-3-X	(2) SUB-SSB-32	(2) DSB-XX	(2) SUB-SSB-32 (2) DSB-XX	.09[2.87]	.635[16.13]	.725[18.41]	N/A
-34	C-15-4-X	(2) SUB-SSB-32	(2) DSB-XX	(2) SUB-SSB-32 (2) DSB-XX	.28[7.11]	.635[16.13]	.915[23.24]	N/A
-44	C-15-4-X	(1) ESS-XX-S	(3) DSB-XX	(1) ESS-XX-S (3) DSB-XX	.18[4.57]	.735[18.67]	.915[23.24]	N/A
LOW INSERTION FORCE	CONTACT	SPACER SPECIFICATION (FOR A ONE POSITION SINGLE SEE NOTE 3)			"B" (SEE TABLE 3)	"C"	"D"	"E"
		ESQ-S	ESQ-D	ESQ-T				
-37	C-60-2-X	N/A	N/A	N/A	.09[2.87]	.435[11.05]	.525[13.33]	.100
-38	C-60-3-X	N/A	N/A	N/A	.29[7.37]	.435[11.05]	.725[18.41]	N/A
-39	C-60-4-X	N/A	N/A	N/A	.48[12.2]	.435[11.05]	.915[23.24]	N/A
-48	C-60-3-X	(1) SUB-SSB-32	(1) DSB-XX	(1) SUB-SSB-32 (1) DSB-XX	.19[4.83]	.535[13.59]	.725[18.41]	N/A
-49	C-60-4-X	(1) SUB-SSB-32	(1) DSB-XX	(1) SUB-SSB-32 (1) DSB-XX	.38[9.65]	.535[13.59]	.915[23.24]	N/A
-58	C-60-3-X	(2) SUB-SSB-32	(2) DSB-XX	(2) SUB-SSB-32 (2) DSB-XX	.09[2.87]	.635[16.13]	.725[18.41]	N/A
-59	C-60-4-X	(2) SUB-SSB-32	(2) DSB-XX	(2) SUB-SSB-32 (2) DSB-XX	.28[7.11]	.635[16.13]	.915[23.24]	N/A
-69	C-60-4-X	(1) ESS-XX-S	(3) DSB-XX	(1) ESS-XX-S (3) DSB-XX	.18[4.57]	.735[18.67]	.915[23.24]	N/A

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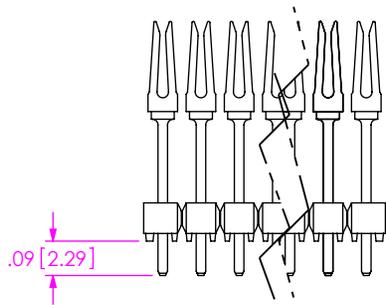
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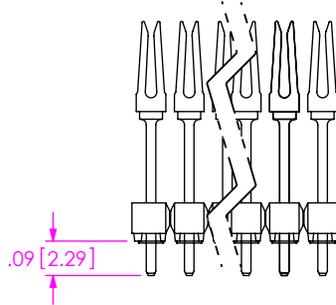
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DWG. NO. ESQ-1XX-XX-X-X-XXX-XX-X-XX

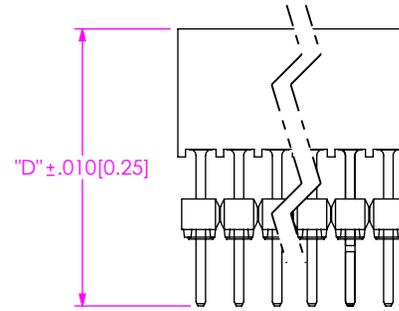
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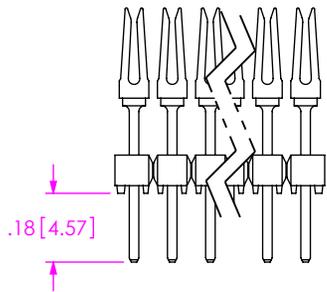


PRESS ON -MW

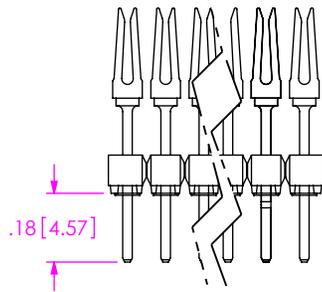


PRESS ON  
SSW BODY

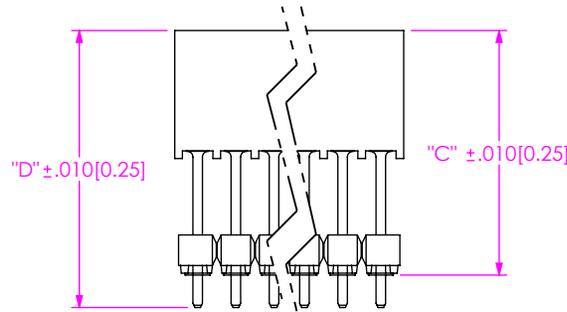
IN-PROCESS  
-12, -33, -37, -58



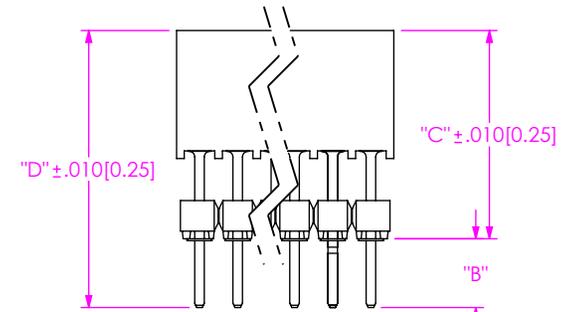
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PRESS ON -MW



PRESS ON  
SSW BODY



REPRESS STACKER BODY  
AND -MW TO PROPER "C" DIM

IN-PROCESS  
-13, -14, -23, -24, -34, -38  
-39, -44, -48, -49, -59, -69

TABLE 3

LEAD STYLE	"B" IN PROCESS FOR 1 POSITION SINGLE ROW (SEE NOTE 2)						
	FILL (1)	FILL (2)	REPRESS (1)	FILL (3)	REPRESS (2)	FILL (4)	REPRESS (3)
-23/-48	.290[7.37]	.150[3.81]	.190[4.83]	N/A	N/A	N/A	N/A
-24/-49	.480[12.19]	.340[8.64]	.380[9.65]	N/A	N/A	N/A	N/A
-33/-58	.290[7.37]	.150[3.81]	.190[4.83]	.050[1.27]	.090[2.29]	N/A	N/A
-34/-59	.480[12.19]	.340[8.64]	.380[9.65]	.240[6.10]	.280[7.11]	N/A	N/A
-44/-69	.480[12.19]	.340[8.64]	.380[9.65]	.240[6.10]	.280[7.11]	.140[3.56]	.180[4.57]

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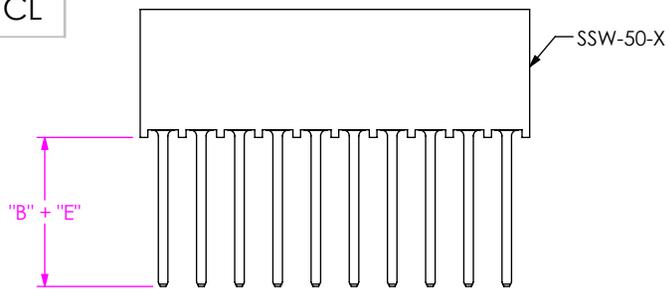


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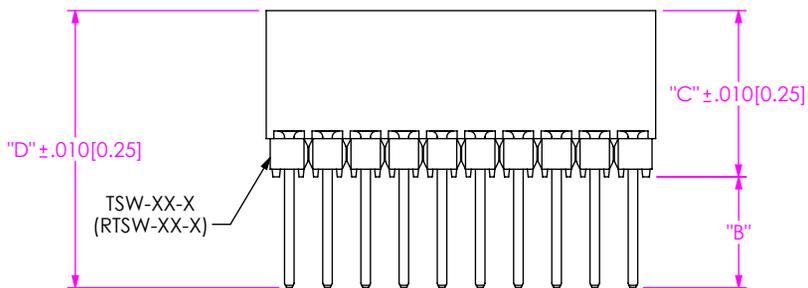
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DWG. NO. ESQ-1XX-XX-X-X-XXX-XX-X-XX

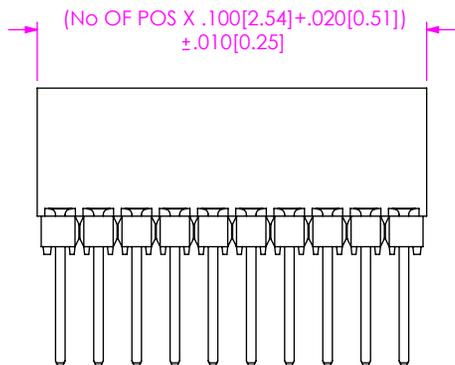
BY: WITHTAKER 9-11-98 SHEET 3 OF 4



**STEP 1**  
MACHINE FILL SSW-50-X



**STEP 2**  
MULTI-CUT TSW-50-X TO POS (RTSW-50-D FOR DOUBLE ROW)  
AND MOUNT AS SHOWN.  
(IF RTSW-50-D NOT AVAILABLE, TSW-50-D MAY BE USED)

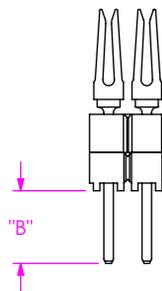


**STEP 3**  
ROTO CUT TO POS

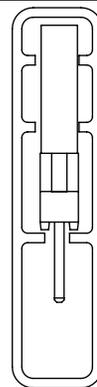
**FIG 5**  
ESQ-110-XX-X-S  
IN PROCESS "B"  
(LEAD STYLE -12 & -37)  
(-S & -D ONLY)

TABLE 2			
LEAD STYLE	ROW	TUBE	PLUG (2)
-12, -13, -14, -37, -38, -39	-S	PT-ESQ002	TP-03
-23, -24, -48, -49		PT-ESQ001	TP-03
-33, -34, -44, -58, -59, -69		PT-1-24-01-47	TP-03
-12, -37	-D	PT-1-24-03-44	TP-07
-14, -24, -34, -44, -39, -49, -59, -69		PT-1-24-02-47	TP-26
-13, -23, -33, -38, -48, -58		PT-1-24-01-51	TP-13
-12, -37	-T	PT-1-24-01-51	TP-13
-13, -14, -23, -24, -33, -34, -44, -38, -39, -48, -49, -58, -59, -69		PT-1-24-03-51	TP-13

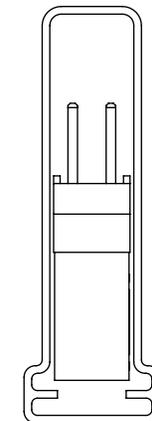
1. FOR -12 & -37 LEAD STYLES TUBE PAC KAGE -04 THRU -36 POSITION ONLY.
2. FOR -13, -23, -33, -38, -48, & -58 LEAD STYLES TUBE PACKAGE -08 THRU -36 POSITIONS ONLY.
3. FOR -14, -24, -34, -44, -39, -49, -59, & -69 LEAD STYLES -05 THRU -36 POSITIONS ONLY.



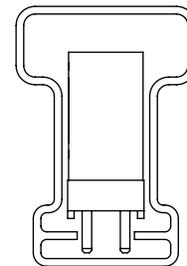
**FIG 6**  
ESQ-110-XX-X-D  
IN PROCESS "A"  
(LEAD STYLE -12-T, -13, -14, -23, -24, -33, -34, -44, -37-T, -38, -48, -49, -58, -59, -69)



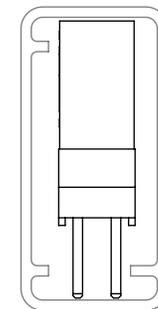
**-S**  
PT-ESQ001



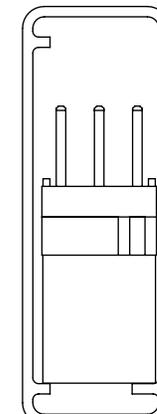
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PT-1-24-02-47



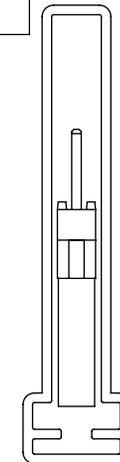
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PT-1-24-03-44



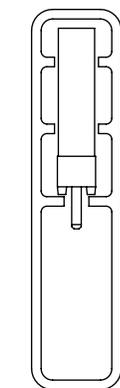
**-D**  
PT-1-24-01-51



**-T**  
PT-1-24-03-51



**-S**  
PT-1-24-01-47



**-S**  
PT-ESQ002

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BY: WHITTAKER 9-11-98 SHEET 4 OF 4