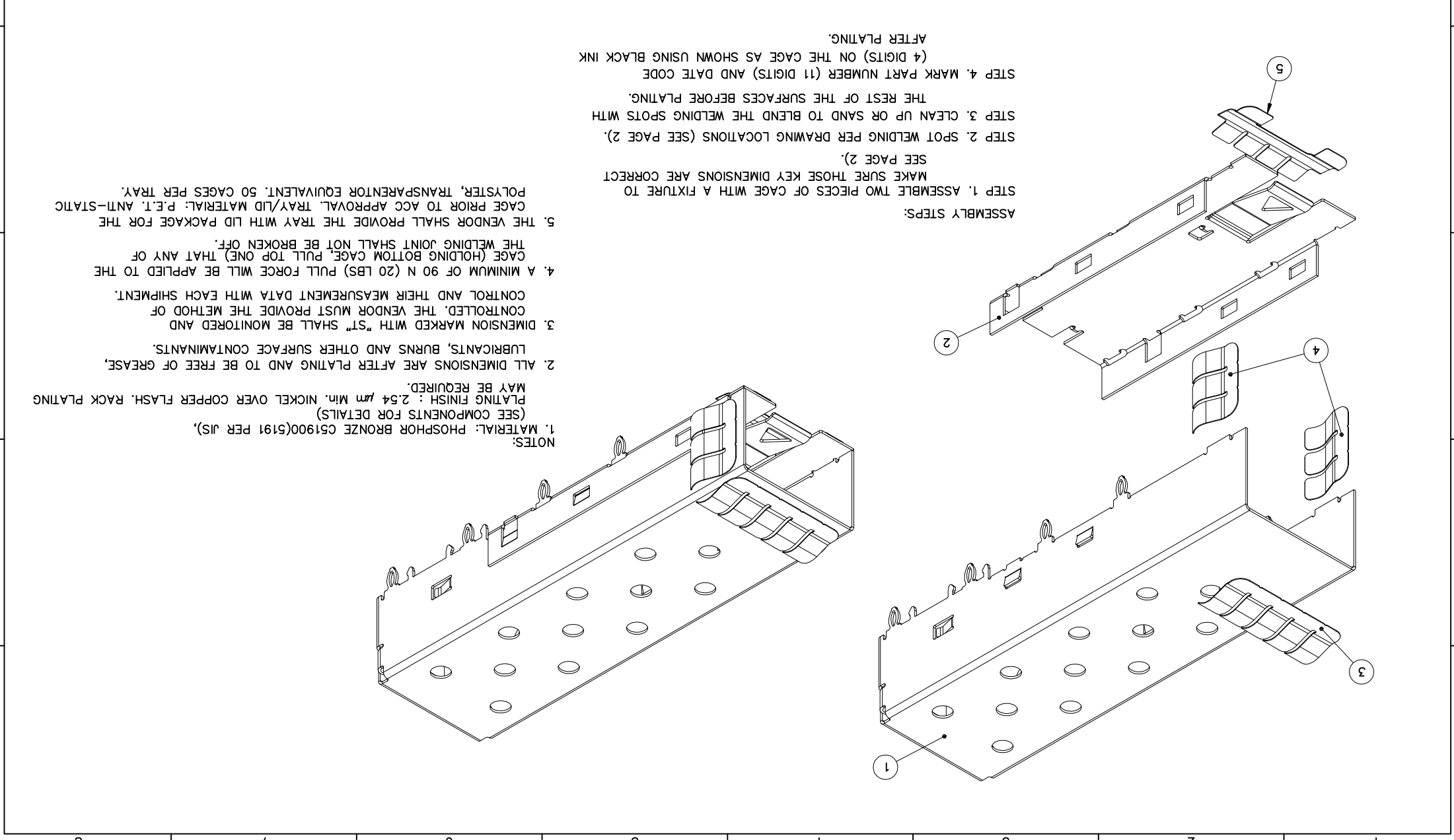


REV	ECN NO.	NAME	DATE	'XXX±0.10	'XXX±	DRWN: Terry	Q'TY:	7	8
				'XX±0.20	'XX±	CHKD: Schumi	FINISH:	1	1
				'X±0.30	'X±	APPD: Jason	MATL:	2	2
				'X±0.40	'X±	DONGGUAN UMAXCONN ENTERPRISE LIMITED		1	1
				LINEAR	ANGLES	Umax conn		2	2
				TOLERANCE		DONGGUAN UMAXCONN ENTERPRISE LIMITED		3	3
						TITLE:		4	4
						1X1 SFP+ CAGE ASSY WITH		5	5
						SPECIAL SIDE & TOP SPRING FINGER		6	6
						EM1 CLIP AND		7	7
						DOUBLE BEND LATCH BOTTOM CAGE		8	8
						PART NO. 161C200			
						DWG NO. 161C200M07001			
						UNITS SCALE SHEET REV			
						MM 2 : 1 1 OF 2 A			



ASSEMBLY STEPS:

STEP 1. ASSEMBLE TWO PIECES OF CAGE WITH A FIXTURE TO MAKE SURE THOSE KEY DIMENSIONS ARE CORRECT (SEE PAGE 2).

STEP 2. SPOT WELDING PER DRAWING LOCATIONS (SEE PAGE 2).

STEP 3. CLEAN UP OR SAND TO BLEND THE WELDING SPOTS WITH THE REST OF THE SURFACES BEFORE PLATING.

STEP 4. MARK PART NUMBER (11 DIGITS) AND DATE CODE (4 DIGITS) ON THE CAGE AS SHOWN USING BLACK INK AFTER PLATING.

NOTES:

1. MATERIAL: PHOSPHOR BRONZE C51900(5191 PER JIS), PLATING FINISH : 2.54 μ m Min. NICKEL OVER COPPER FLASH. RACK PLATING MAY BE REQUIRED.

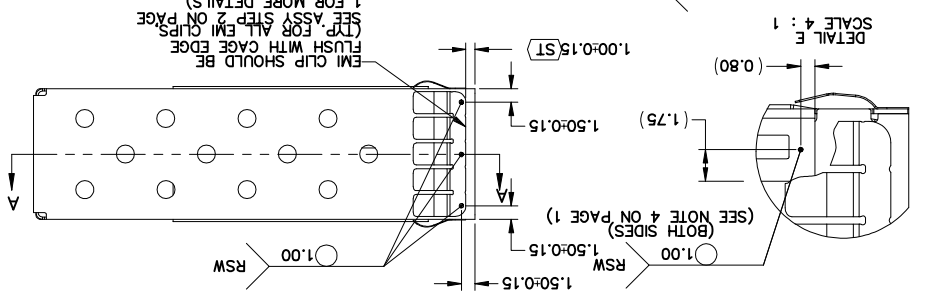
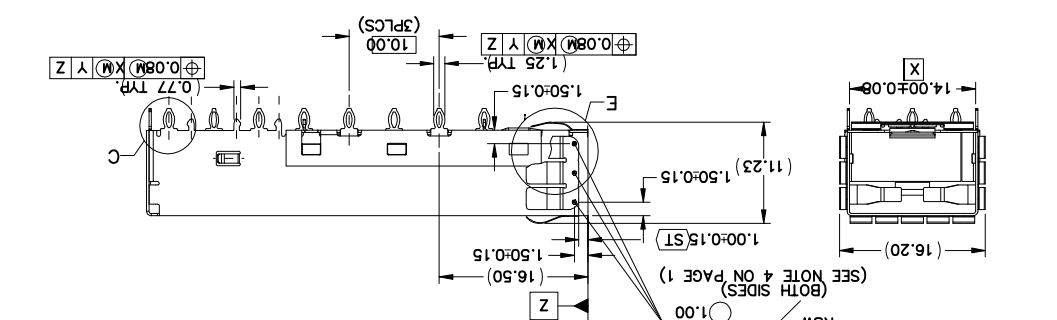
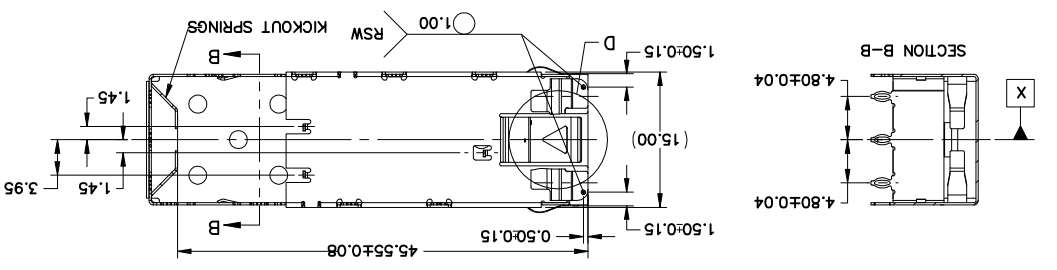
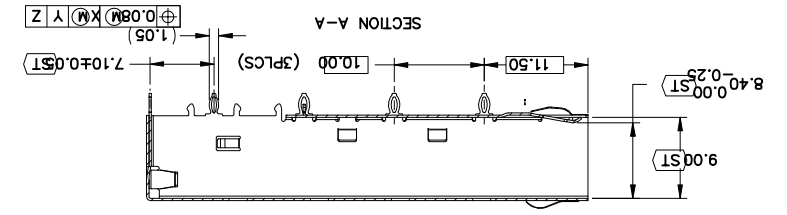
2. ALL DIMENSIONS ARE AFTER PLATING AND TO BE FREE OF GREASE, LUBRICANTS, BURNS AND OTHER SURFACE CONTAMINANTS.

3. DIMENSION MARKED WITH "ST" SHALL BE MONITORED AND CONTROLLED. THE VENDOR MUST PROVIDE THE METHOD OF CONTROL AND THEIR MEASUREMENT DATA WITH EACH SHIPMENT.

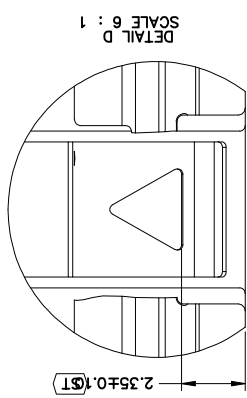
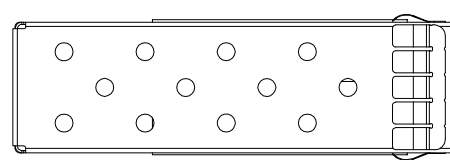
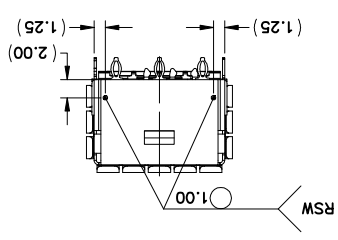
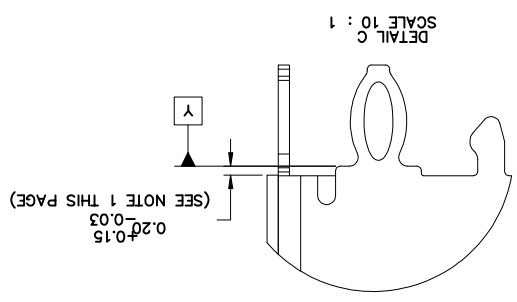
4. A MINIMUM OF 90 N (20 LBS) PULL FORCE WILL BE APPLIED TO THE CAGE (HOLDING BOTTOM CAGE, PULL TOP ONE) THAT ANY OF THE WELDING JOINT SHALL NOT BE BROKEN OFF.

5. THE VENDOR SHALL PROVIDE THE TRAY WITH LID PACKAGE FOR THE CAGE PRIOR TO ACC APPROVAL. TRAY/LID MATERIAL: P.E.T. ANTI-STATIC POLYESTER, TRANSPARENTOR EQUIVALENT. 50 CAGES PER TRAY.

REV	ECN NO.	NAME	DATE	XXX±	XXX±	DRWN: Terry	Q'TY:		
				.XX±	.XX±	CHKD: Schumi	FINISH:		
				.X±	.X±	APPD: Jason	MATL:	DWG NO. 161C200M07001	
				X±	X±	Umax conn 东莞市外贸实业有限公司 DONGGUAN UMAXCONN ENTERPRISE LIMITED			
		LINEAR	ANGLES						PART NO. 161C200
TOLERANCE									TITLE: 1X1 SFP+ CAGE ASSY WITH SPECIAL SIDE & TOP SPRING FINGER EM1 CLIP AND DOUBLE BEND LATCH BOTTOM CAGE



NOTE:
1. THIS DIM (GAP) WILL BE MEASURED AS FOLLOWS: PUT THE GAGE ON THE
FOOTPRINT GAGE, USE FEELER GAGE TO MEASURE THE GAP PER SPEC
(0.15 mm MIN.).



MM	UNITS	SCALE	SHEET	REV
2 : 1	2 OF 2	A		

8 CUSTOMER

8

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