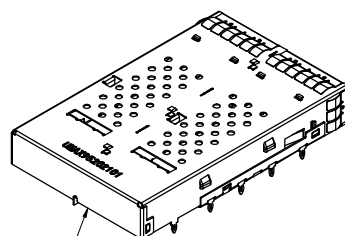


1. MATERIAL: MATERIAL: COPPER ALLOY , (SEE COMPONENTS FOR DETAILS)

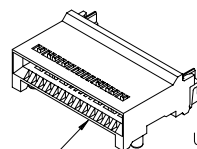
PLATING FINISH: 2.54-3.81  $\mu\text{m}$  (100-150  $\mu''$ ) NICKEL OVER  
COPPER FLASH. RACK PLATING MAY BE REQUIRED.

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.




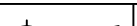
NO REAR PINS P#: UMAX95202101 SHOWN



UMAX952L0301  
SHOWN ON THIS VIEW  
SCALE 2 : 1

✓ CAN BE USED IN CONJUNCTION WITH A CAGE

UMAX95202101  
SHOWN ON THIS VIEW  
SCALE 1.5 : 1

TOLERANCE		 <b>东莞市友贸实业有限公司</b> DONGGUAN UMAX ENTERPRISE LIMITED		TITLE: zQSFP/QSFP28 CAGE SUB-ASSEMBLY WITH MODIFIED SPRING CLIPS				
LINEAR	ANGLES			PART NO. SEE NOTE1				
X,±0.40	X°,± 3°			DWG NO. C-UMAX92D0210				
.X,±0.30	.X°,± 2°	APPD: Jason	MAT'L:		UNITS	SCALE	SHEET	REV
.XX,±0.20	.XX°,± 1°	CHKD: Schumi	FINISH:		MM	1 : 1	1 OF 3	0
.XXX,±0.10	.XXX°,± 0.5°	DRWN: Lei Songping	Q'TY:					

STEP 1. ASSEMBLE TOP/BOTTOM AND SIDE EMI CLIPS ONTO TOP AND BOTTOM CAGES.

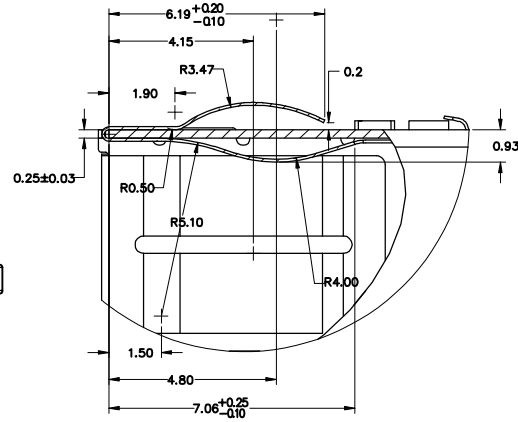
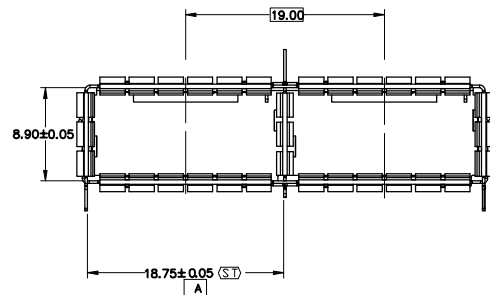
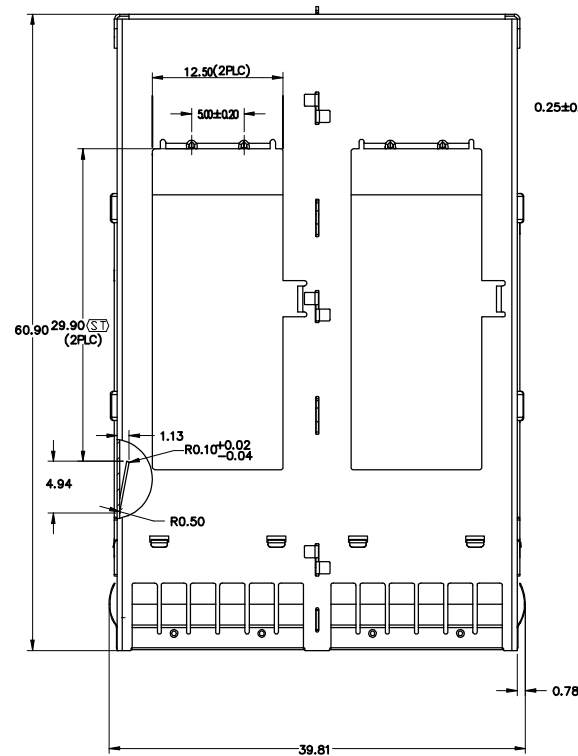
STEP 2. SPOT WELDING PER DRAWING LOCATIONS (SEE PAGE 2).  
STEP 3. ASSEMBLE TWO PIECES OF CAGE WITH A FIXTURE TO  
MAKE SURE THOSE KEY DIMENSIONS ARE CORRECT

SEE PAGE 2).

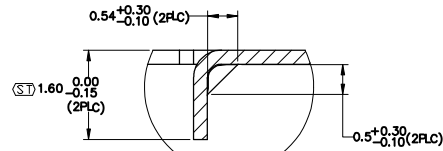
STEP 4. CLEAN UP OR SAND TO BLEND THE WELDING SPOTS WITH THE REST OF THE SURFACES BEFORE PLATING.

SETP 5. AFTER PLATING, FLEX EMI CLIPS TO BREAK PLATING BONDS

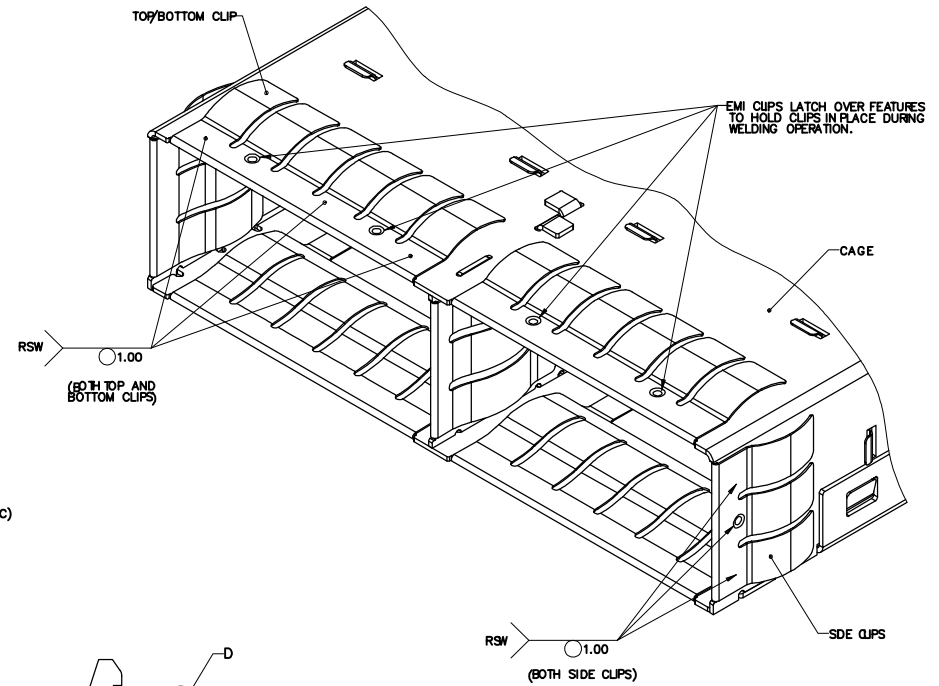
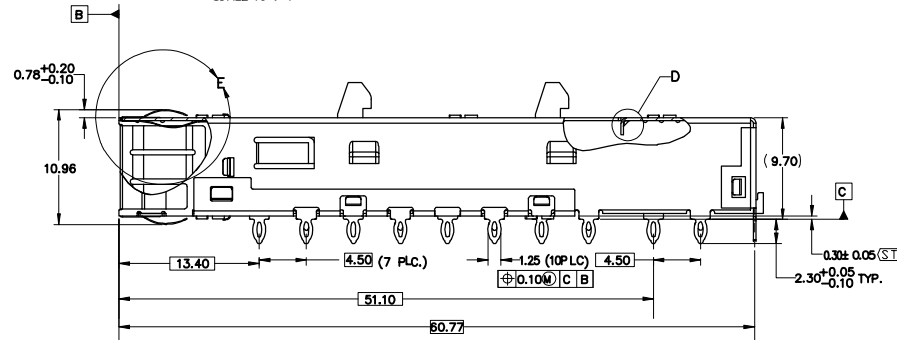
AND FORM HOOKS TO DIMENSIONS SHOWN ON SHEET 2.



DETAIL E  
SCALE 10 : 1



DETAIL D  
SCALE 16 : 1



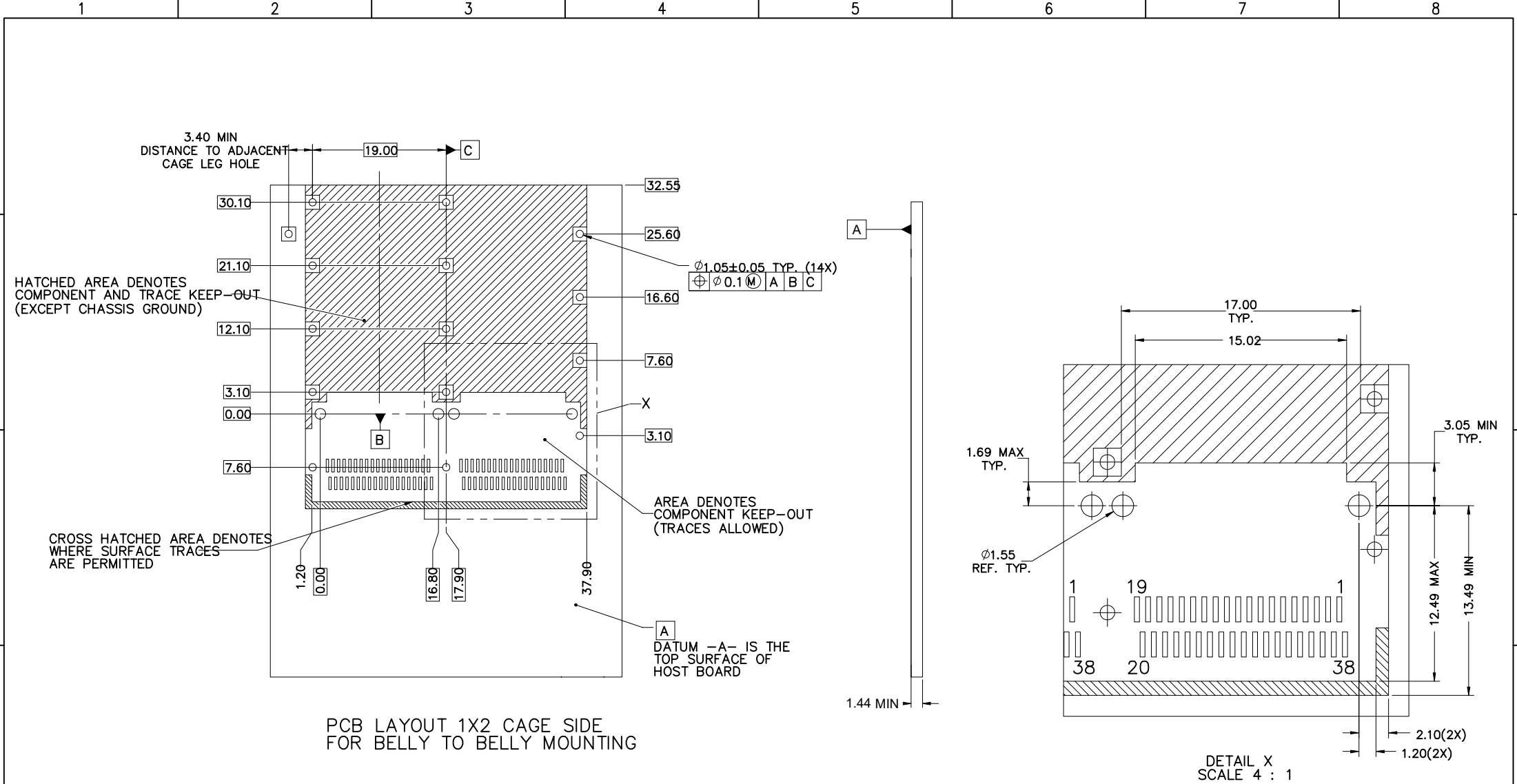
EMI CLIPS LATCH OVER FEATURES TO HOLD CLIPS IN PLACE DURING WELDING OPERATION.

P#: UMAX95212101 SHOWN ON THIS PAGE

TOLERANCE		<b>UMax</b> 东莞市友贸实业有限公司 <b>conn</b> DONGGUAN UMAX ENTERPRISE LIMITED	
LINEAR	ANGLES		
X±0.40	X°± 3°	APPD: Jason	MAT'L:
.X±0.30	.X°± 2°	CHKD: Schumi	FINISH:
.XX±0.20	.XX°± 1°	DRWN: Lei Songping	Q'TY:
.XXX±0.10	.XXX°± 0.5°		

TITLE: zQSFP/QSFP28 CAGE SUB-ASSEMBLY WITH MODIFIED SPRING CLIPS			
PART NO.		SEE NOTE1	
DWG NO.		C-UMAX92D0210	
	UNITS	SCALE	SHEET
	MM	1 : 1	2 OF 3
			REV
			0

REV	ECN NO.	NAME	DATE



- NOTES:
- DATUMS X AND Y ESTABLISHED BY CUSTOMER'S FIDUCIAL.
  - LOCATION OF EDGE OF PCB IS APPLICATION SPECIFIC.
  - FINISHED HOLE SIZE.

REV	ECN NO.	NAME	DATE	TOLERANCE		UMax conn 东莞市友贸实业有限公司 DONGGUAN UMAX ENTERPRISE LIMITED	TITLE: zQSFP/QSFP28 CAGE SUB-ASSEMBLY WITH MODIFIED SPRING CLIPS			
				LINEAR	ANGLES		PART NO.	SEE NOTE1		
				X±0.40	X°± 3°	APPD: Jason	DWG NO.	C-UMAX92D0210		
				.X±0.30	.X°± 2°	MAT'L:		UNITS	SCALE	SHEET
				.XX±0.20	.XX°± 1°	CHKD: Schumi		MM	1 : 1	3 OF 3
				.XXX±0.10	.XXX°± 0.5°	DRWN: Lei Songping				REV
						Q'TY:				0