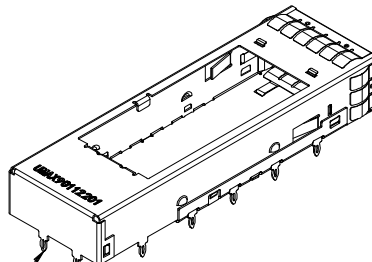
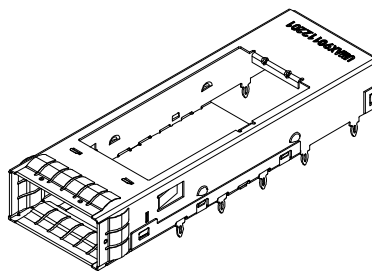
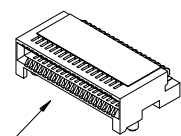


UMAX90112201
SHOWN ON THIS VIEW
SCALE 2 : 1



2 REAR PIN



UMAX90L1151
SHOWN ON THIS VIEW
SCALE 2 : 1

← CAN BE USED IN CONJUNCTION WITH A CAGE

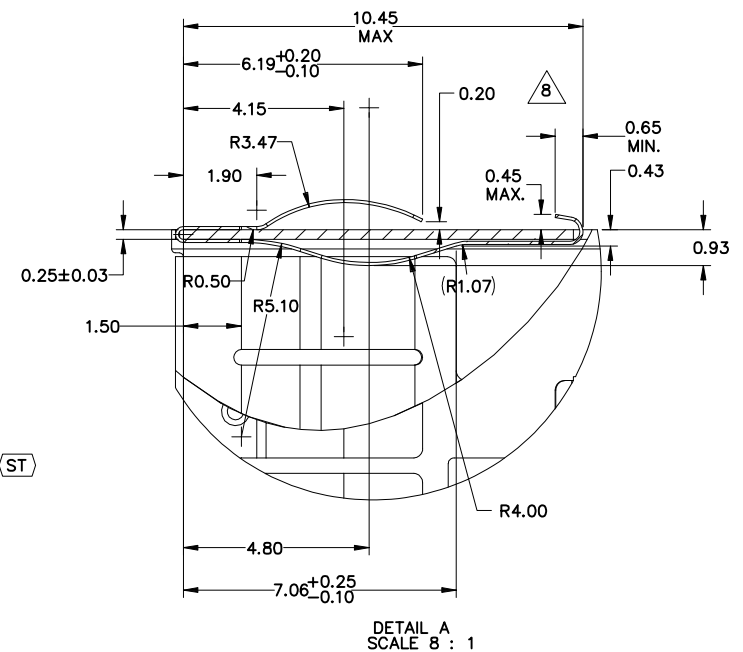
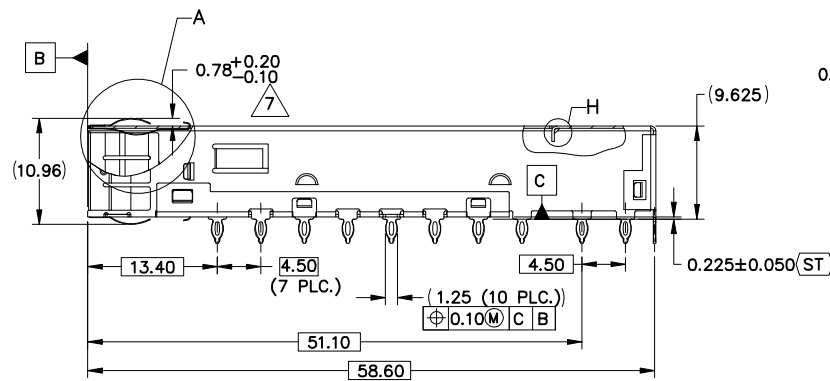
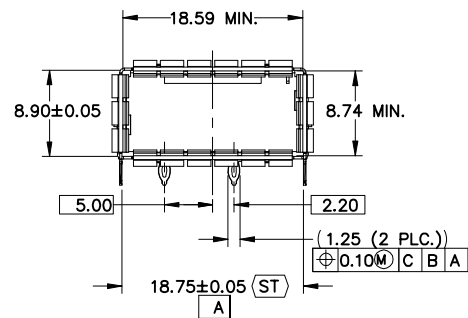
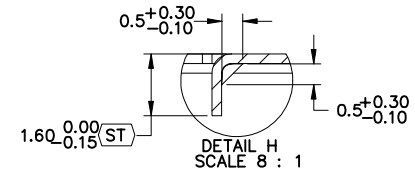
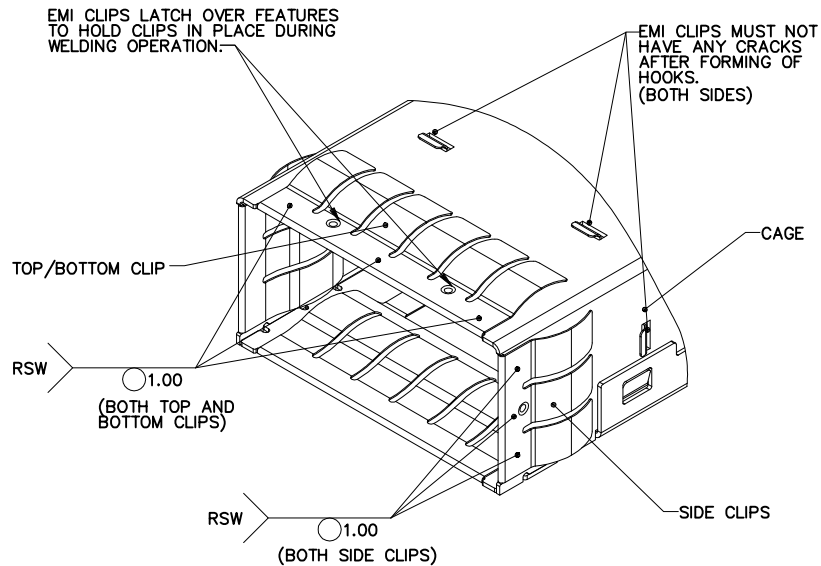
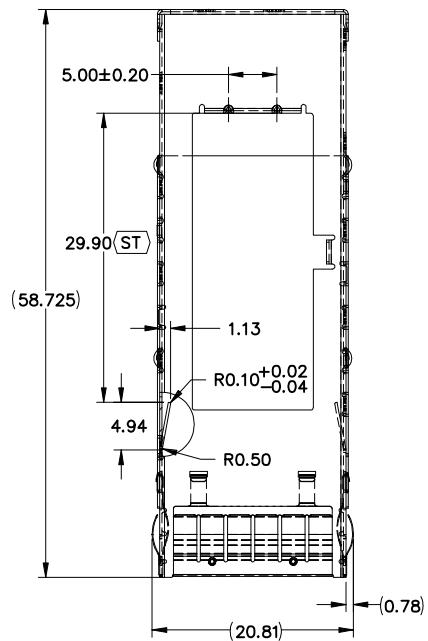
ASSEMBLY STEPS:
STEP 1. ASSEMBLE TOP/BOTTOM AND SIDE EMI CLIPS ONTO TOP AND BOTTOM CAGES.
STEP 2. SPOT WELDING PER DRAWING LOCATIONS (SEE PAGE 2).
STEP 3. ASSEMBLE TWO PIECES OF CAGE WITH A FIXTURE TO MAKE SURE THOSE KEY DIMENSIONS ARE CORRECT (SEE PAGE 2).
STEP 4. CLEAN UP OR SAND TO BLEND THE WELDING SPOTS WITH THE REST OF THE SURFACES BEFORE PLATING.
STEP 5. AFTER PLATING, FLEX EMI CLIPS TO BREAK PLATING BONDS AND FORM HOOKS TO DIMENSIONS SHOWN ON SHEET 2.

NOTES:
1. MATERIAL: COPPER ALLOY , (SEE COMPONENTS FOR DETAILS)
PLATING FINISH: 2.54-3.81 μm (100-150 μ") 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).
5. TRAY/LID MATERIAL: P. E. T. ANTI-STATIC POLYSTER, 40 CAGES PER TRAY.
6. PRESS FIT PIN DESIGNED TO HAVE INSERTION FORCE 31-44.5 N (7-10 LBS) AND MIN. 9 N (2 LBS) RETENSION FORCE PER PIN.
△. APPLIES TO ALL OUTER EMI FINGERS.
△. EACH EMI SPRING HOOK MUST CONFORM TO DIMENSIONS SHOWN AND HAVE SUFFICIENT CLEARANCE WITH CAGE SOLTS TO ALLOW INNER SPRING PROFILE TO BE COMPRESSED FLAT.

4	SIDE EMI CLIP	2
3	TOP/BOTTOM EMI CLIP	2
2	BOTTOM CAGE	1
1	TOP CAGE	1
ITEM NO.	DESCRIPTION	QTY.

REV	ECN NO.	NAME	DATE

TOLERANCE		UMax conn 东莞市友贸实业有限公司 DONGGUAN UMAX ENTERPRISE LIMITED		TITLE: QSFP+ CAGE SUB-ASSEMBLY WITH MODIFIED SPRING CLIPS			
LINEAR	ANGLES			PART NO. UMAX90112201			
X±0.40	X°± 3°	APPD: Jason	MAT'L:	DWG NO. C-UMAX9C2210			
.X±0.30	.X°± 2°	CHKD: Schumi	FINISH:		UNITS	SCALE	SHEET
.XX±0.20	.XX°± 1°	DRWN: Lei Songping	Q'TY:		MM	1 : 1	1 OF 4
.XXX±0.10	.XXX°± 0.5°			REV 0			



TOLERANCE	
LINEAR	ANGLES
X±0.40	X°± 3°
.X±0.30	.X°± 2°
.XX±0.20	.XX°± 1°
.XXX±0.10	.XXX°± 0.5°

UMax conn 东莞市友贸实业有限公司
DONGGUAN UMAX ENTERPRISE LIMITED

APPD: Jason MAT'L:
CHKD: Schumi FINISH:
DRWN: Lei Songping Q'TY:

TITLE: QSFP+ CAGE SUB-ASSEMBLY
WITH MODIFIED SPRING CLIPS

PART NO. UMAX90112201

DWG NO. C-UMAX9C2210

UNITS	SCALE	SHEET	REV
MM	1 : 1	2 OF 4	0

REV	ECN NO.	NAME	DATE

