

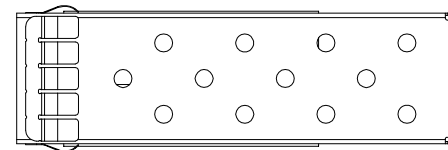
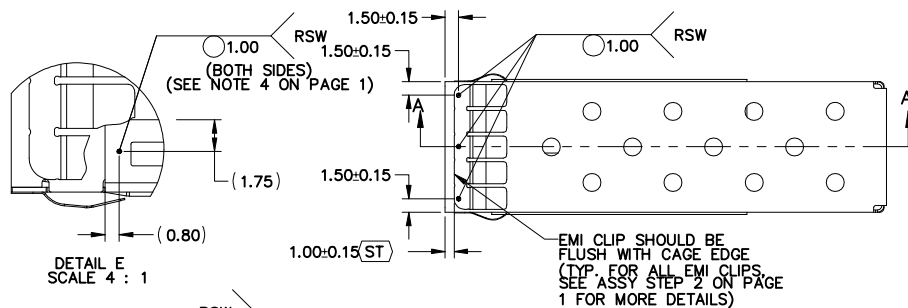
**NOTES:**

1. MATERIAL: PHOSPHOR BRONZE C51900(5191 PER JIS),  
(SEE COMPONENTS FOR DETAILS)  
PLATING FINISH : 2.54  $\mu\text{m}$  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  
POLYSTER, TRANSPARENTOR EQUIVALENT. 50 CAGES PER TRAY.

**ASSEMBLY STEPS:**

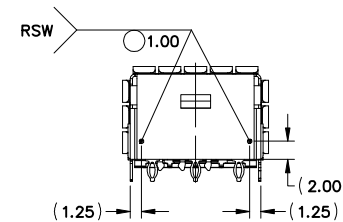
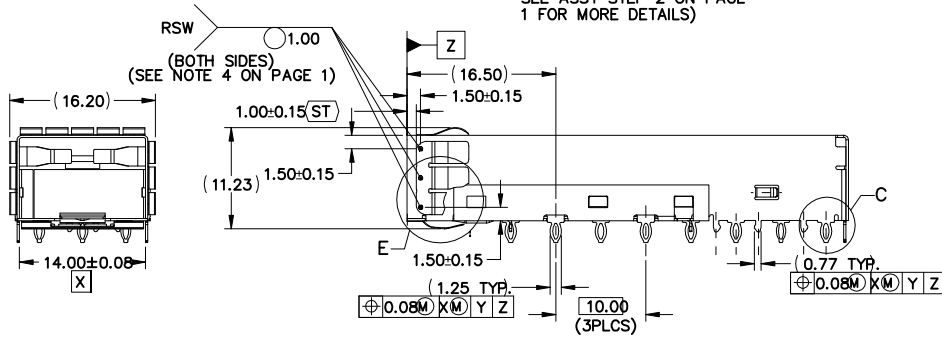
- STEP 1. ASSEMBLE TWO PIECES OF CAGE WITH A FIXTURE TO  
MAKE SURE THOSE KEY DIMENSIONS ARE CORRECT  
(SEE PAGE 2).
- STEP 2. SPOT WELDING PER DRAWING LOCATIONS (SEE PAGE 2).
- STEP 3. CLEAN UP OR SAND TO BLEND THE WELDING SPOTS WITH  
THE REST OF THE SURFACES BEFORE PLATING.
- STEP 4. MARK PART NUMBER (11 DIGITS) AND DATE CODE  
(4 DIGITS) ON THE CAGE AS SHOWN USING BLACK INK  
AFTER PLATING.

				TOLERANCE		<b>UMax conn</b> 东莞市友贸实业有限公司 DONGGUAN UMAXCONN ENTERPRISE LIMITED		TITLE: 1X1 SFP+ CAGE ASSY WITH SPECIAL SIDE & TOP SPRING FINGER EMI CLIP AND DOUBLE BEND LATCH BOTTOM CAGE				
				LINEAR	ANGLES			PART NO. 161C200				
				X $\pm$ 0.40	X $^{\circ}$ $\pm$	APPD:	Jason	MAT'L:	DWG NO. 161C200M07001			
				.X $\pm$ 0.30	.X $^{\circ}$ $\pm$	CHKD:	Schumi	FINISH:	UNITS SCALE SHEET REV			
				.XX $\pm$ 0.20	.XX $^{\circ}$ $\pm$	DRWN:	Terry	Q'TY:	MM	2 : 1	1 OF 2	A
REV	ECN NO.	NAME	DATE	.XXX $\pm$ 0.10	.XXX $^{\circ}$ $\pm$							

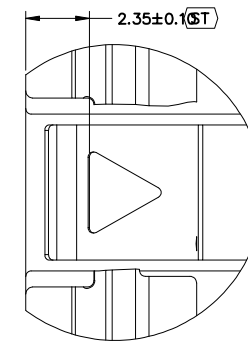


VIEW FOR PART MARKING DETAILS

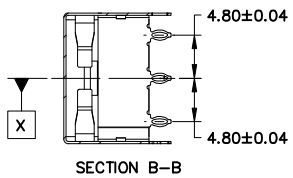
DETAIL E SCALE 4 : 1



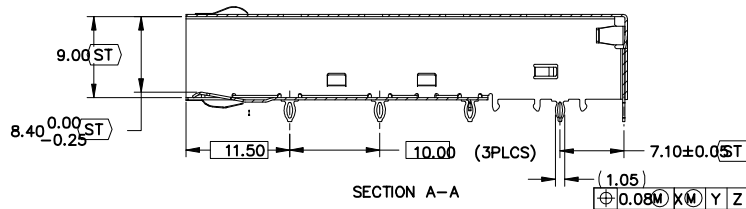
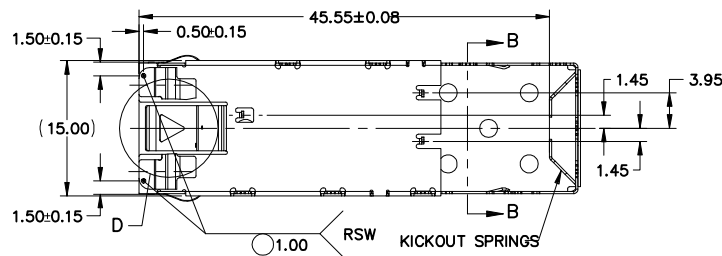
DETAIL C SCALE 10 : 1



DETAIL D SCALE 6 : 1



SECTION B-B



SECTION A-A

0.2<sup>+0.15</sup><sub>-0.03</sub>  
(SEE NOTE 1 THIS PAGE)

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

				TOLERANCE	
				LINEAR	ANGLES
				X±0.40	X°±
				.X±0.30	.X°±
				.XX±0.20	.XX°±
REV	ECN NO.	NAME	DATE	.XXX±0.10	.XXX°±

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

TITLE: 1X1 SFP+ CAGE ASSY WITH SPECIAL SIDE & TOP SPRING FINGER EMI CLIP AND DOUBLE BEND LATCH BOTTOM CAGE

PART NO. 161C200

DWG NO. 161C200M07001

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

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