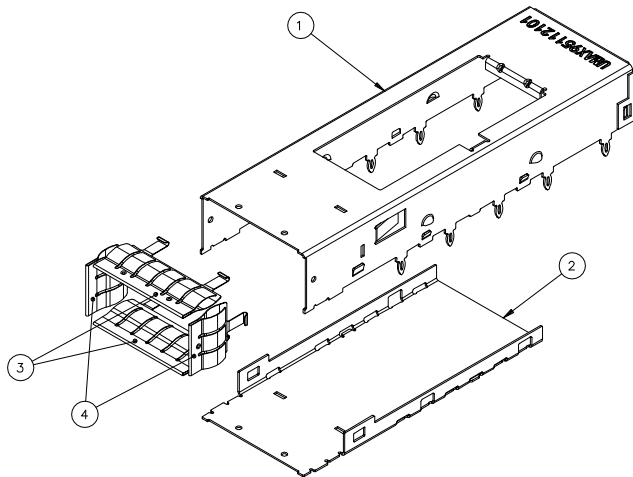
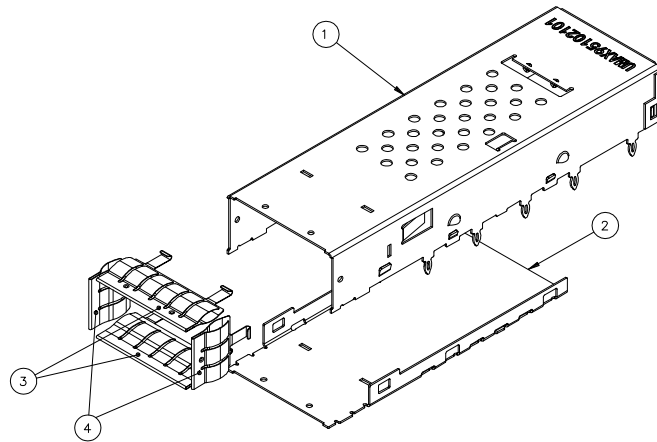
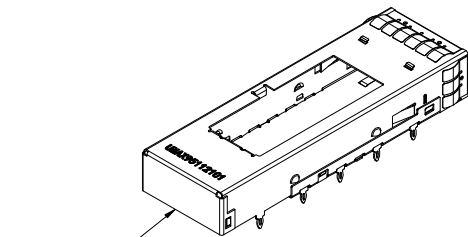




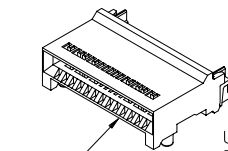
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SHOWN ON THIS VIEW
SCALE 2 : 1



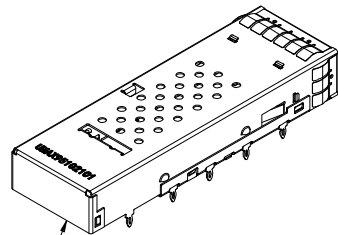
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SCALE 2 : 1



P#: UMAX95112101 SHOWN



UMAX952L0301
SHOWN ON THIS VIEW
SCALE 2 : 1



P#: UMAX95102101 SHOWN

NOTES:

1. MATERIAL: PHOSPHOR BRONZE C51900, (SEE COMPONENTS FOR DETAILS)
- PLATING FINISH: 2.54-3.81 μm (100-150 μin) 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 POLYESTER, 45 CAGES PER TRAY.

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

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.

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

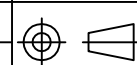
APPD: Jason
CHKD: Schumi
DRWN: Lei Songping

MAT'L:
FINISH:
Q'TY:

TITLE: zQSFP/QSFP28 CAGE
SUB-ASSEMBLY WITH MODIFIED
SPRING CLIPS

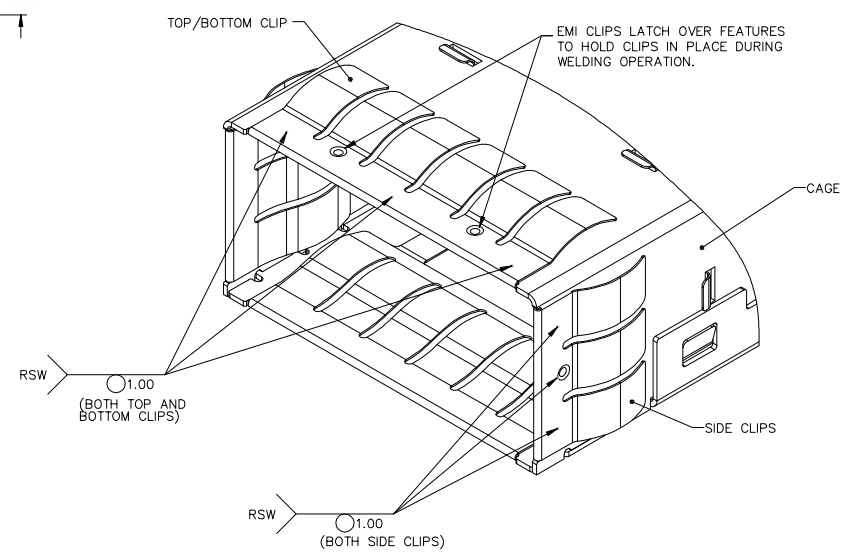
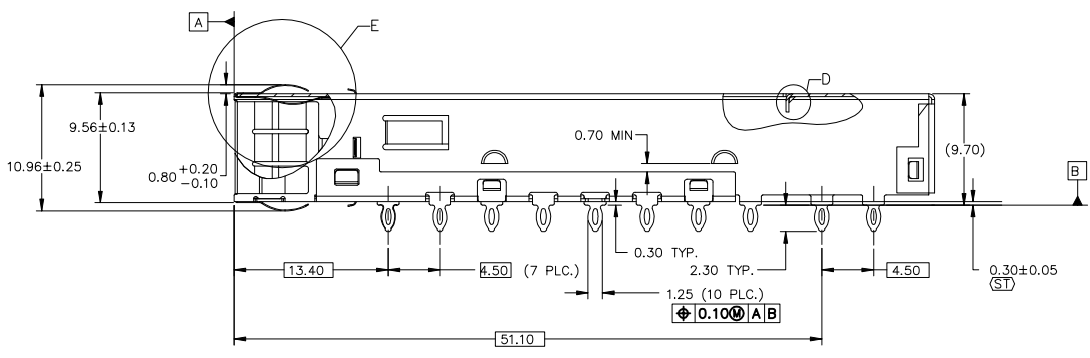
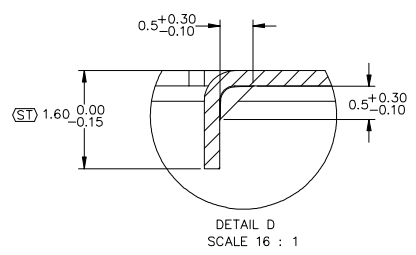
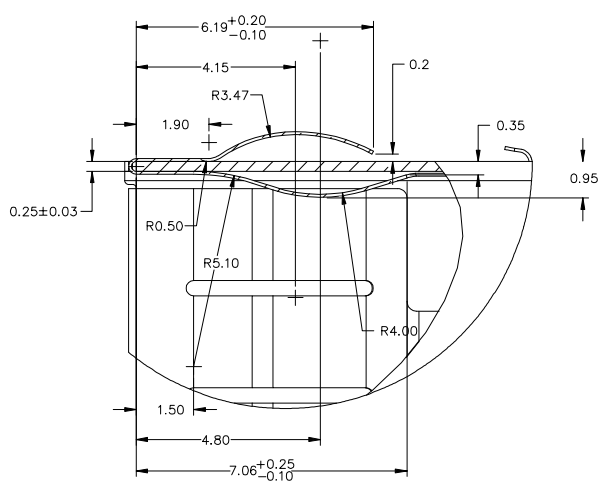
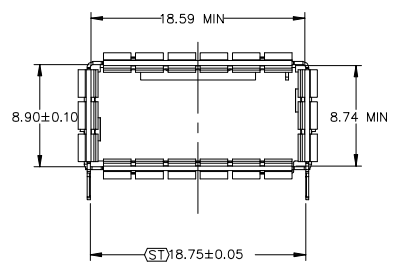
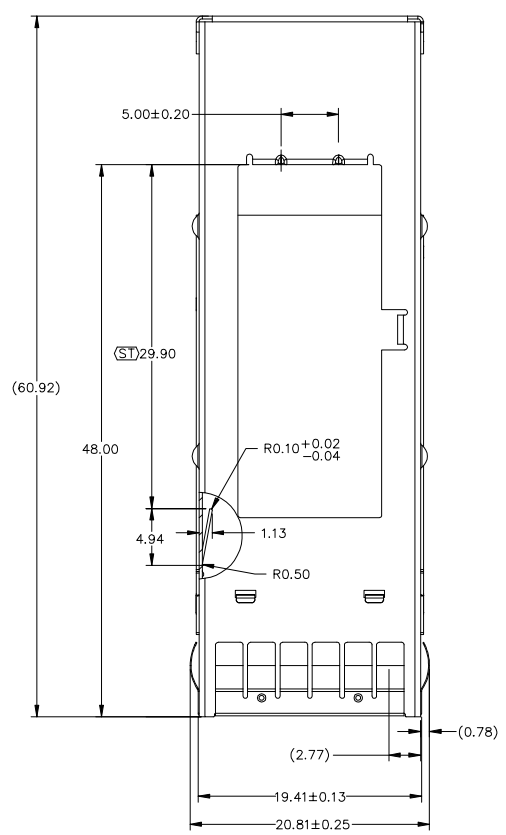
PART NO. SEE NOTE1

DWG NO. C-UMAX9D1211



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

REV	ECN NO.	NAME	DATE



P#: UMAX95112101 SHOWN ON THIS PAGE

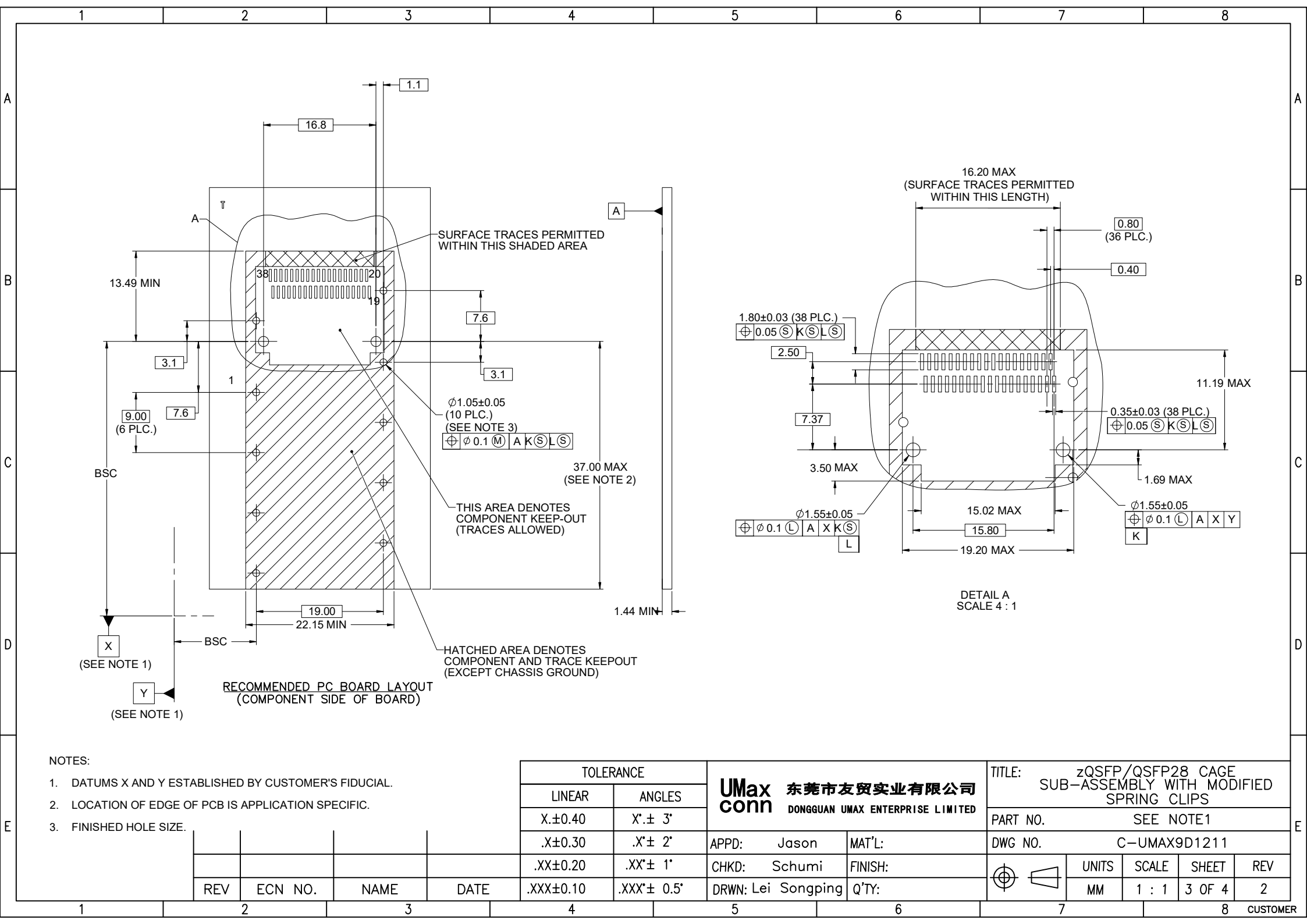
REV	ECN NO.	NAME	DATE

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 东莞市友贸实业有限公司 conn DONGGUAN UMAX ENTERPRISE LIMITED	
APPD: Jason	MAT'L:
CHKD: Schumi	FINISH:
DRWN: Lei Songping	Q'TY:

TITLE: zQSFP/QSFP28 CAGE SUB-ASSEMBLY WITH MODIFIED SPRING CLIPS				
PART NO.		SEE NOTE1		
DWG NO.		C-UMAX9D1211		
	UNITS	SCALE	SHEET	REV
	MM	1 : 1	2 OF 4	2

CUSTOMER



- 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 DONGGUAN UMAX ENTERPRISE LIMITED	TITLE: zQSFP/QSFP28 CAGE SUB-ASSEMBLY WITH MODIFIED SPRING CLIPS			
				LINEAR	ANGLES		PART NO.	SEE NOTE 1		
				X±0.40	X'± 3'	APPD: Jason	DWG NO.	C-UMAX9D1211		
				.X±0.30	.X'± 2'	MAT'L:		UNITS	SCALE	SHEET
				.XX±0.20	.XX'± 1'	CHKD: Schumi		MM	1 : 1	3 OF 4
				.XXX±0.10	.XXX'± 0.5'	DRWN: Lei Songping				REV
						Q'TY:				2

