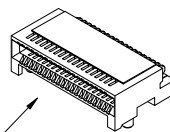
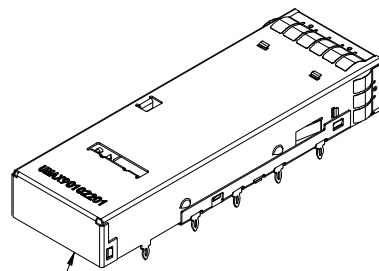
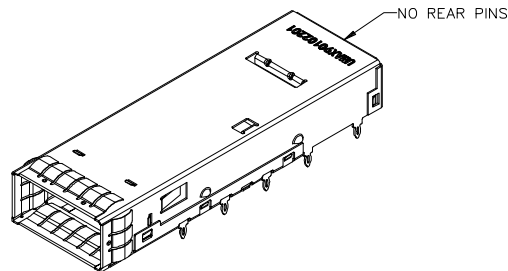


UMAX90102201
SHOWN ON THIS VIEW
SCALE 2 : 1



UMAX90L1151
SHOWN ON THIS VIEW
SCALE 2 : 1

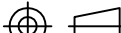
ASSEMBLY STEPS:

- 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.

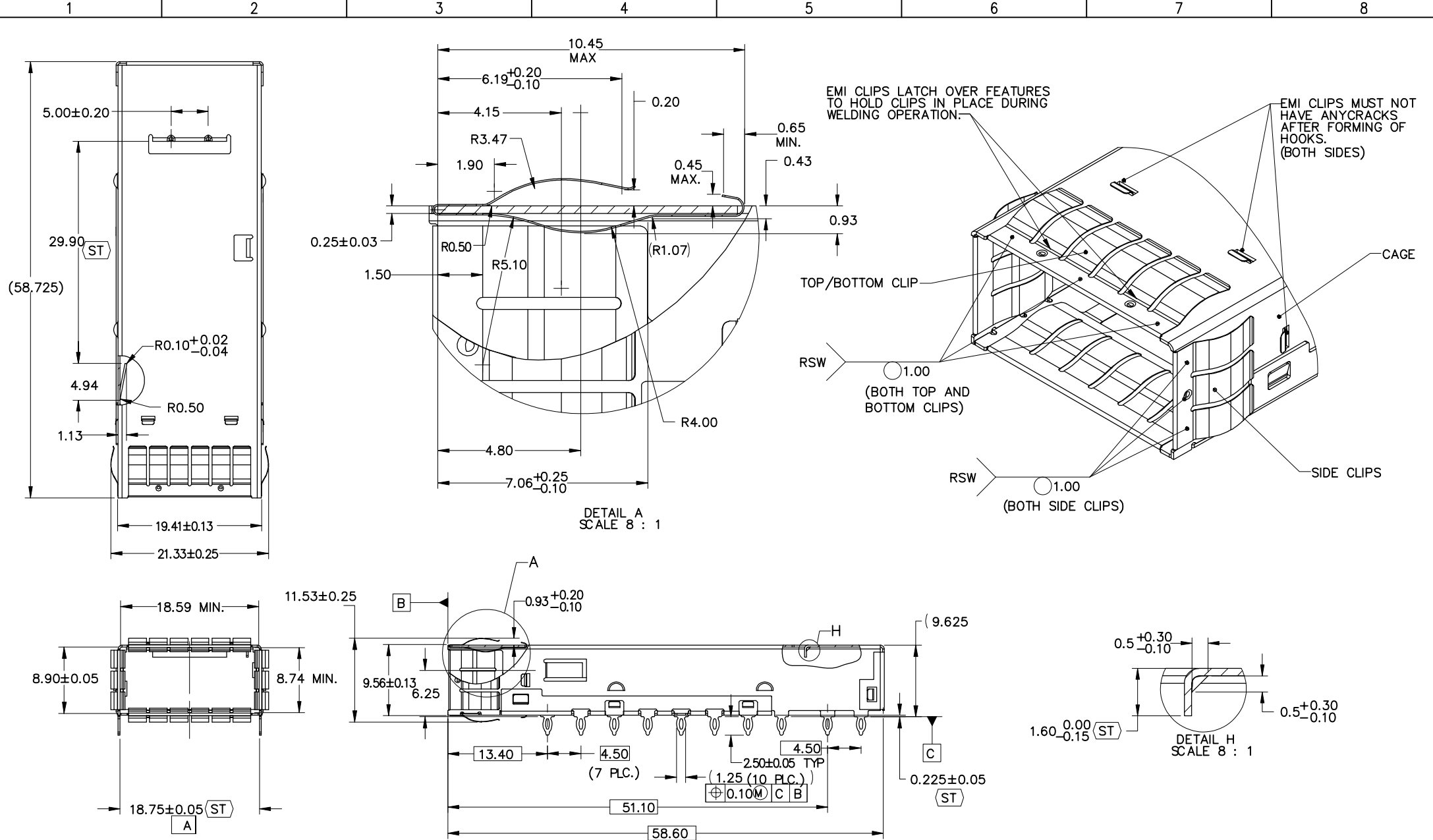
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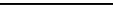
1. MATERIAL: COPPER ALLOY , (SEE COMPONENTS FOR DETAILS)
- PLATING FINISH: 2.54-3.81 μm (100-150 μin) NICKEL OVER COPPER FLASH. RACK PLATING MAY BE REQUIRED.
2. ALL DIMENSIONS ARE AFTER PLATING AND TO BE FREE OF GREASE, LUBRICANTS, BURNS AND OTHER SURFACE CONTAMINANTS.
3. DIMENSION MARKED WITH "ST" SHALL 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 POLYSTER, 40 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.

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. UMAX90102201				
X,±0.40	X°,± 3°			DWG NO. C-UMAX9C1210				
.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 4	0
.XXX±0.10	.XXX°± 0.5°	DRWN:Lei Songping	Q'TY:					

REV	ECN NO.	NAME	DATE



				TOLERANCE		UMax conn 东莞市友贸实业有限公司 DONGGUAN UMAX ENTERPRISE LIMITED		TITLE: QSF+ CAGE SUB-ASSEMBLY WITH MODIFIED SPRING CLIPS				
				LINEAR	ANGLES			PART NO. UMAX90102201				
				X,±0.40	X°,± 3°							
				.X,±0.30	.X°,± 2°			APPD: Jason	MAT'L:	DWG NO. C-UMAX9C1210		
.XX,±0.20	.XX°,± 1°	CHKD: Schumi	FINISH:		UNITS	SCALE	SHEET	REV				
REV	ECN NO.	NAME	DATE		.XXX,±0.10	.XXX°,± 0.5°	DRWN:Lei Songping	Q'TY:	MM	1 : 1	2 OF 4	0

