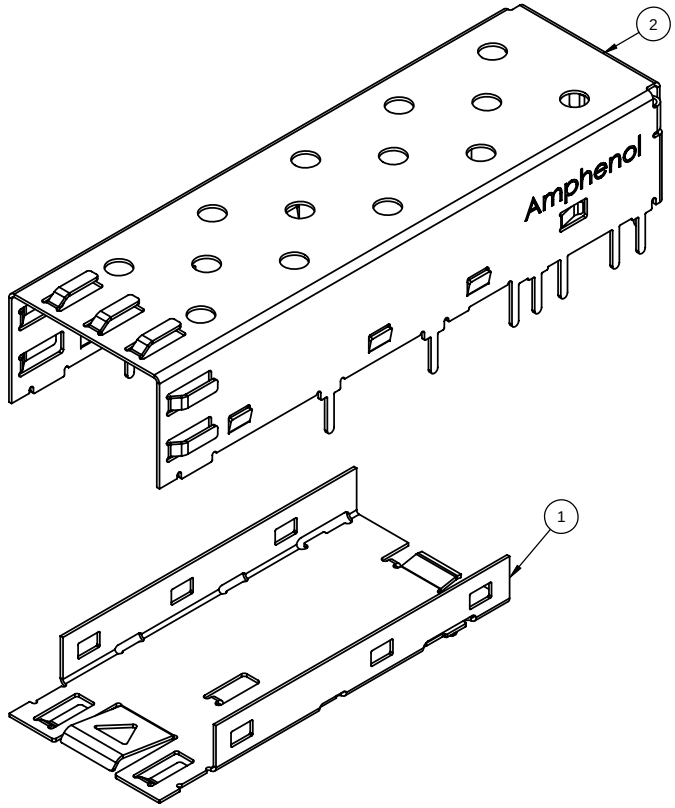
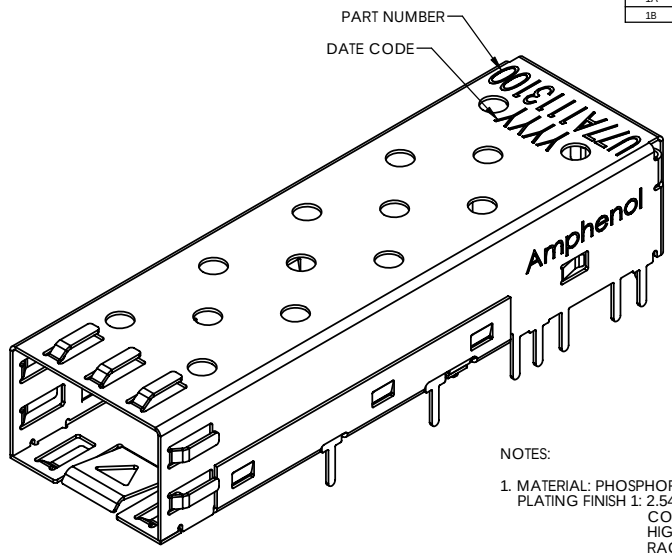
REVISIONS				
REV.	ECN	DESCRIPTION	DATE	APPROVED
1	E06105	PRODUCTION		
1A	E07096	ADD PLATING DESCRIPTION	MAY,15,07	A.GREEN
1B	E08357	PER ECN E08357	DEC,25,08	A.GREEN





DATA CONTROL RELEASE

DEPT. NO. -- 636 --

DATE: JAN,08, 2009

NOTES:

1. MATERIAL: PHOSPHOR BRONZE C51910, (SEE COMPONENTS FOR DETAILS)
   PLATING FINISH 1: 2.54-3.81 µm (100-150 µ") BRIGHT TIN MIN. (WHISKER CONTROLLED REQ'D) OVER 1.27 µm (50 µ") MIN. HIGH TEMP NICKEL UNDER PLATING OVER COPPER FLASH. RACK PLATING MAY BE REQUIRED.(BIGHT TIN IS FOR WAVE SOLDER)
   PLATING FINISH 2 :2.54-3.81 µm (100-150 µ") MATTE TIN MIN. (WHISKER CONTROLLED REQ'D) OVER 1.27 µm (50 µ") MIN. HIGH TEMP NICKEL UNDER PLATING OVER COPPER FLASH. RACK PLATING MAY BE REQUIRED.(MATTE TIN IS FOR SMT REFLOW INCLUDING THE TEMPERATURE REFLOW REQUIREMENT , THE PEAK TEMPERATURE OF REFLOW MUST BE 240° MIN. FOR 7MIN.SECONDS.) SEE PART NUMBER FOR PLATING OPTIONS.
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.

TABLE 1

CAGE P/N	ITEM 1 P/N (BOTTOM CAGE)	ITEM 2 P/N (TOP CAGE)	INK MARKING	PLATING	COMMENT
U77-A1112-100	U77-1110-3002	U77-1110-4002	U77A1112100	BRIGHT TIN,SEE NOTE1, PLATING FINISH 1	1.2 mm SOLDER PIN HEIGHT
U77-A1113-100	U77-1110-3003	U77-1110-4003	U77A1113100	BRIGHT TIN,SEE NOTE1, PLATING FINISH 1	3.2 mm SOLDER PIN HEIGHT
U77-A1114-100	U77-1110-3004	U77-1110-4004	U77A1114100	BRIGHT TIN,SEE NOTE1, PLATING FINISH 1	1.8 mm SOLDER PIN HEIGHT
U77-A1112-300	U77-1110-3002	U77-1110-4002	U77A1112300	MATTE TIN,SEE NOTE1, PLATING FINISH 2	1.2 mm SOLDER PIN HEIGHT
U77-A1113-300	U77-1110-3003	U77-1110-4003	U77A1113300	MATTE TIN,SEE NOTE1, PLATING FINISH 2	3.2 mm SOLDER PIN HEIGHT
U77-A1114-300	U77-1110-3004	U77-1110-4004	U77A1114300	MATTE TIN,SEE NOTE1, PLATING FINISH 2	1.8 mm SOLDER PIN HEIGHT

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.

DO NOT SCALE DRAWING

THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION AND SUCH INFORMATION MAY NOT BE DISCLOSED TO OTHERS FOR ANY PURPOSE OR USED FOR MANUFACTURING PUPOSES WITHOUT PERMISSION FROM AMPHENOL CANADA CORP.

ITEM No.	PART NUMBER	QTY	DESCRIPTION
2	SEE TABLE 1	1	TOP CAGE
1	SEE TABLE 1	1	BOTTOM CAGE

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS TOLERANCES ARE:
DECIMALS X.X ± 0.15, X.XX ± 0.10
ANGLES ± 1°
MATERIAL AND FINISH: SEE NOTE 1
REF.
CODE IDENT. NO. 03554

APPROVALS		DATE
DRAWN	J.SI	2006/03/02
DESIGNED	J.SI	2006/03/02
CHECKED	X	X
QA APPD	X	X
IE APP'D	A.GREEN	2006/03/02
DWG APP'D		

Amphenol Canada Corp.

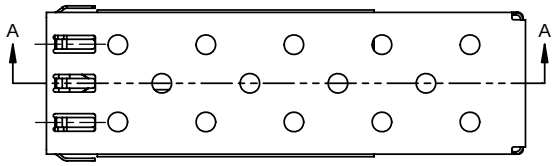
TITLE: SFP CAGE 1X1 ASSY SOLDER PINS (1.2, 1.8, 3.2 mm LONG)

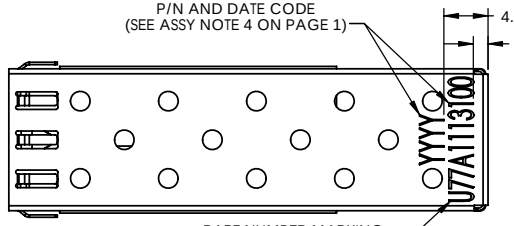
SIZE A3 | DWG. NO. U77-A111X-X00 | REV. 1B

SCALE 3:1 | PROJECT | SHEET 1 OF 2

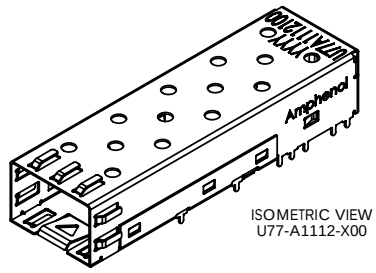
REVISIONS				
REV.	ECN	DESCRIPTION	DATE	APPROVED
1	E06105	PRODUCTION		
1A	E07096	ADD PLATING DESCRIPTION	MAY.15.07	A.GREEN
1B	E08357	PER ECN E08357	DEC.25.08	A.GREEN

DATA CONTROL RELEASE
DEPT. NO. -- 636 --
DATE: JAN.08, 2009

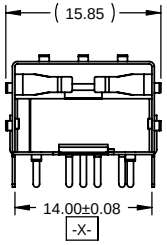


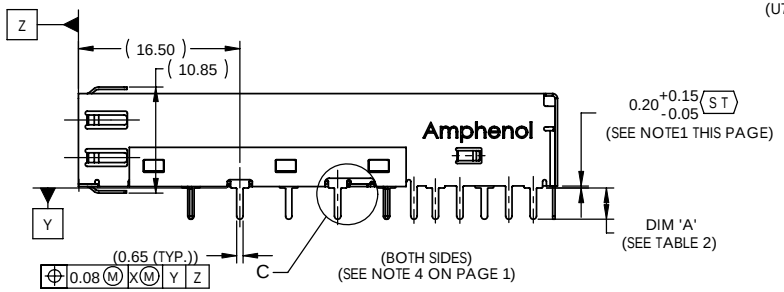


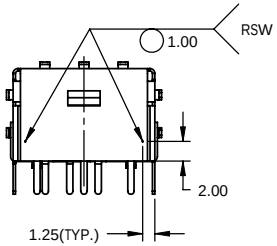
VIEW FOR PART MARKING DETAILS
(U77A1113100 SHOWN)

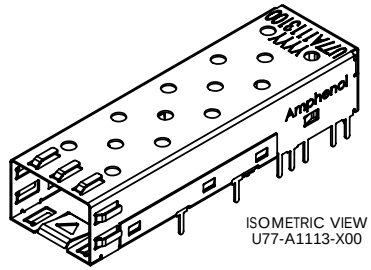


ISOMETRIC VIEW
U77-A1112-X00

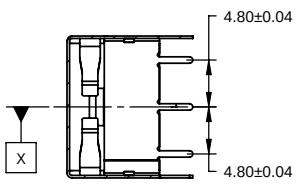




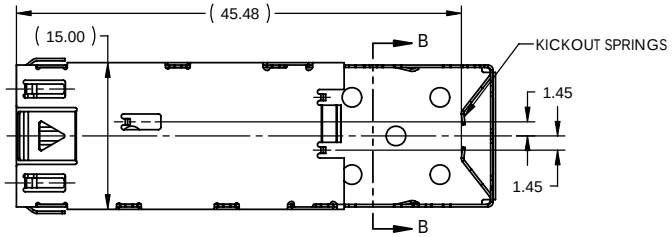


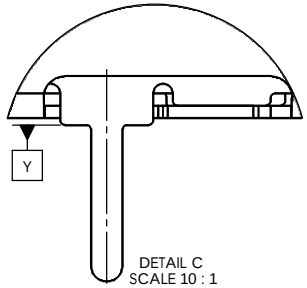


ISOMETRIC VIEW
U77-A1113-X00

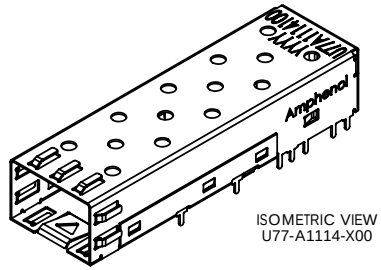


SECTION B-B

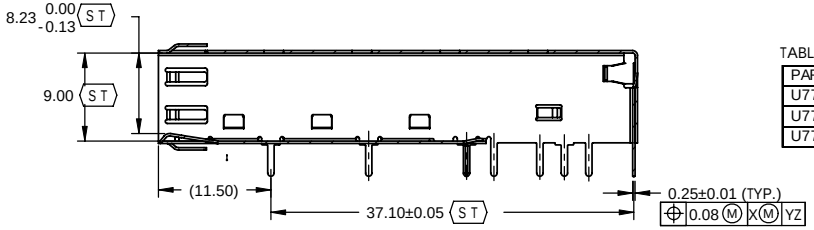




DETAIL C
SCALE 10 : 1



ISOMETRIC VIEW
U77-A1114-X00



SECTION A-A

TABLE 2

PART NUMBER	DIM 'A'
U77-A1112-X00	1.20 mm
U77-A1113-X00	3.20 mm
U77-A1114-X00	1.80 mm

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.).

DO NOT SCALE DRAWING

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS
TOLERANCES ARE:
DECIMALS X.X ± 0.15, X.XX ± 0.10
ANGLES ± 1°
MATERIAL AND FINISH: SEE NOTE 1 ON PAGE 1
REF.
CODE IDENT. NO. 03554

APPROVALS		DATE
DRAWN	J.SI	2006/03/02
DESIGNED	J.SI	2006/03/02
CHECKED	X	X
QA APPD	X	X
IE APP'D	A.GREEN	2006/03/02
DWG APP'D		

Amphenol Canada Corp.

TITLE: SFP CAGE 1X1
SOLDER PINS (1.2, 1.8, 3.2 mm LONG)

SIZE A3 | DWG. NO. U77-A111X-X00 | REV. 1B
SCALE 2:1 | PROJECT | SHEET 2 OF 2