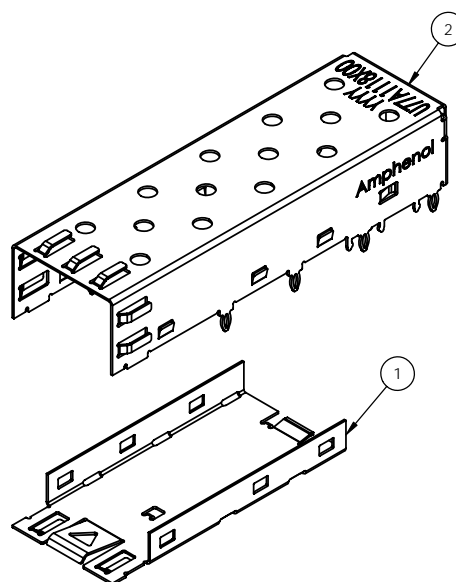


REVISIONS				
REV.	ECN/E-R	DESCRIPTION	DATE	APPROVED
1A	C04-402/2940	PRODUCTION	2005/01/28	
1B	E05251	PER ECN 05251	2005/10/28	A.G.
1C	E06368	PER ECN 06368	2006/10/17	A.G.
1D	E07096	PER ECN 07096, CHANGE PLATING SPEC	MAY 15, 07	A.G.
1E	E08257	CORRECT THE DRAWING FAULT (PER ECN E08257)	SEP 12, 08	A.G.

**DATA CONTROL  
RELEASE**

DEPT. NO. -- 636 --

DATE: SEP.17, 2008



PART NUMBER	DESCRIPTION
U77-A1118-100	BRIGHT TIN PLATING (SEE NOTE 1, PLATING FINISH 1)
U77-A1118-200	NICKEL PLATING (SEE NOTE 1, PLATING FINISH 2)

**NOTES:**

- MATERIAL: PHOSPHOR BRONZE C51910, (SEE COMPONENTS FOR DETAILS)  
PLATING FINISH 1: 2.54-3.81  $\mu$ m (100-150  $\mu$ ) BRIGHT TIN MIN. (WHISKER CONTROLLED REQ'D) OVER 2.54  $\mu$ m (100  $\mu$ ) MIN. NICKEL (BARRIER NICKEL PLATING) UNDER PLATING OVER COPPER FLASH. RACK PLATING MAY BE REQUIRED.  
PLATING FINISH 2: 2.54-3.81  $\mu$ m (100-150  $\mu$ ) NICKEL MIN. OVER COPPER FLASH. RACK PLATING MAY BE REQUIRED. SEE PART NUMBER FOR PLATING OPTION.
- ALL DIMENSIONS ARE AFTER PLATING AND TO BE FREE OF GREASE, LUBRICANTS, BURNS AND OTHER SURFACE CONTAMINANTS.
- DIMENSION MARKED WITH "ST" SHALL BE MONITORED AND CONTROLLED. THE VENDOR MUST PROVIDE THE METHOD OF CONTROL AND THEIR MEASUREMENT DATA WITH EACH SHIPMENT.
- 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.
- THE VENDOR SHALL PROVIDE THE TRAY WITH LID PACKAGE FOR THE CAGE PRIOR TO ACC APPROVAL. TRAY/LID MATERIAL: P.E.T. ANTI-STATIC POLYESTER, TRANSPARENT OR EQUIVALENT. 50 CAGES PER TRAY.

**ASSEMBLY STEPS:**

- ASSEMBLE TWO PIECES OF CAGE WITH A FIXTURE TO MAKE SURE THOSE KEY DIMENSIONS ARE CORRECT (SEE PAGE 2).
- SPOT WELDING PER DRAWING LOCATIONS (SEE PAGE 2).
- CLEAN UP OR SAND TO BLEND THE WELDING SPOTS WITH THE REST OF THE SURFACES BEFORE PLATING.



2	U77-1110-4008	1	TOP CAGE
1	U77-1110-3000	1	BOTTOM CAGE
ITEM No.	PART NUMBER	QTY	DESCRIPTION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS TOLERANCES ARE:  DECIMALS ANGLES X.X ± 0.15 ± 1° X.XX ± 0.10		APPROVALS		DATE		Amphenol Canada Corp  SFP CAGE 1X1 8 PRESS FIT / 12 EMI PINS													
		DRAWN	J.SI	2004/11/17															
		DESIGNED	J.SI	2004/11/17															
		CHECKED	X	X															
MATERIAL AND FINISH		SEE NOTE 1		QA APP'D		R.CURTIS		2004/11/19											
REF.		C04-402/2940		E APP'D		A.GREEN		2005/01/21		SIZE A3		DWG. NO.		U77-A1118-X00		REV.		1E	
CODE IDENT. NO.		03554		DWG APP'D						SCALE		2:1		PROJECT				SHEET 1 OF 2	

**DO NOT SCALE DRAWING**

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