

NOTE



All numerical values are in metric units [with U.S. customary units in brackets]. Dimensions are in millimeters. Unless otherwise specified, dimensions have a tolerance of ± 0.13 and angles have a tolerance of $\pm 2^\circ$. Figures and illustrations are for identification only and are not drawn to scale.

1. INTRODUCTION

This specification covers the requirements for application of stacked SFP Connector and Cage Assemblies to interconnect SFP fiber optic or copper transceiver modules to printed circuit (pc) boards. The SFP Connector and Cage Assembly is a pre-assembled unit available in a 2×1 , 2×4 , or 2×6 configuration in standard or low-profile. The SFP Connector and the Cage Assembly is available separately for rework purposes. SFP Connector and Cage Assemblies are also available with light pipes.

The cage assembly features compliant pin contacts for mechanical retention to the pc board and to provide electromagnetic interference (EMI) suppression, thermal vent holes, and panel ground springs. In addition, the cage assembly has a locking latch and a kick-out spring for each mating module. The locking latch holds the module in place, and the kick-out spring releases the module for removal. A dust cover (for each port) is used when the module is not mated to the cage assembly to prevent contaminants from entering the chassis. The SFP Connector and Cage Assembly is designed to be inserted into a bezel after being seated onto the pc board.

The connector consists of a housing with dual 20-position receptacle ports and compliant pin contacts on 0.8 mm centerline spacing. The housing features alignment posts that provide stability for placement on the pc board. Each receptacle port has a card entry slot that accepts a 1.0 ± 0.1 mm thick integrated circuit card housed in the mating module.

When corresponding with TE Connectivity Personnel, use the terminology provided in this specification to facilitate your inquiries for information. Basic terms and features of this product are provided in Figure 1.

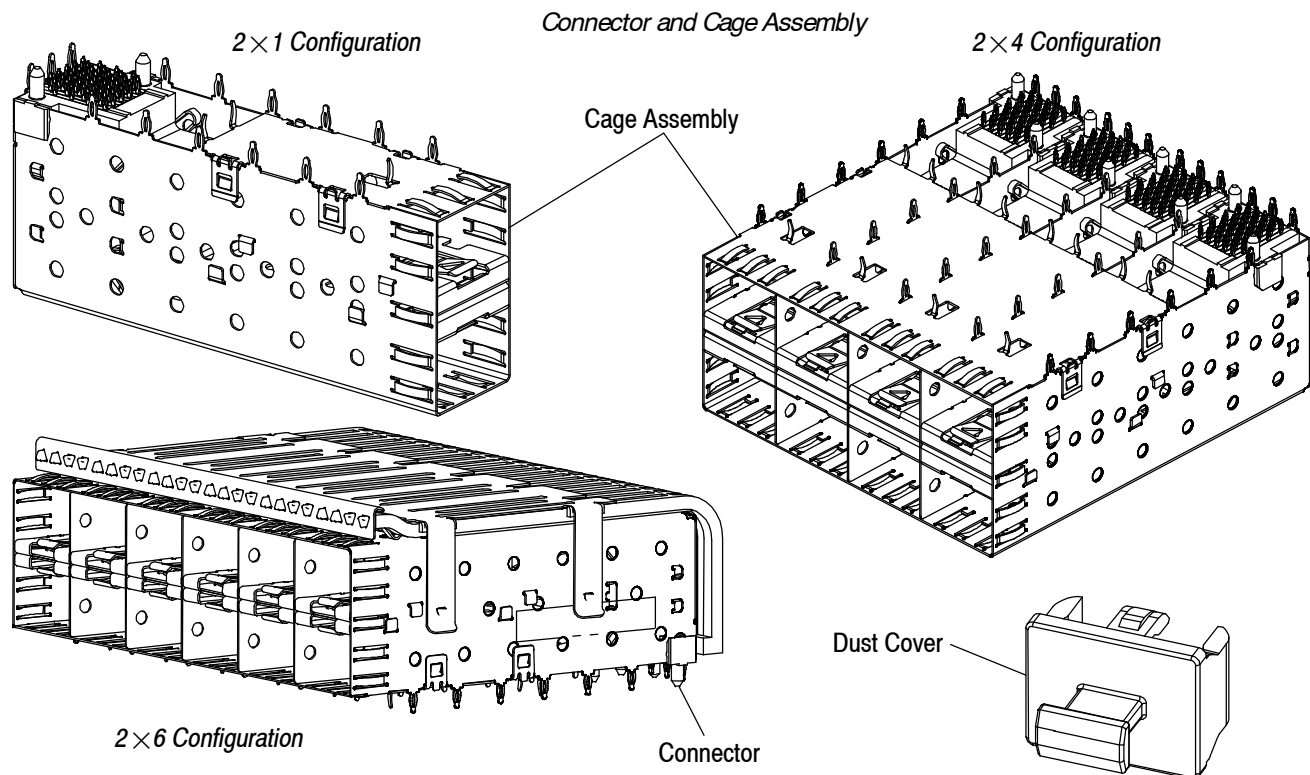


Figure 1 (cont'd)

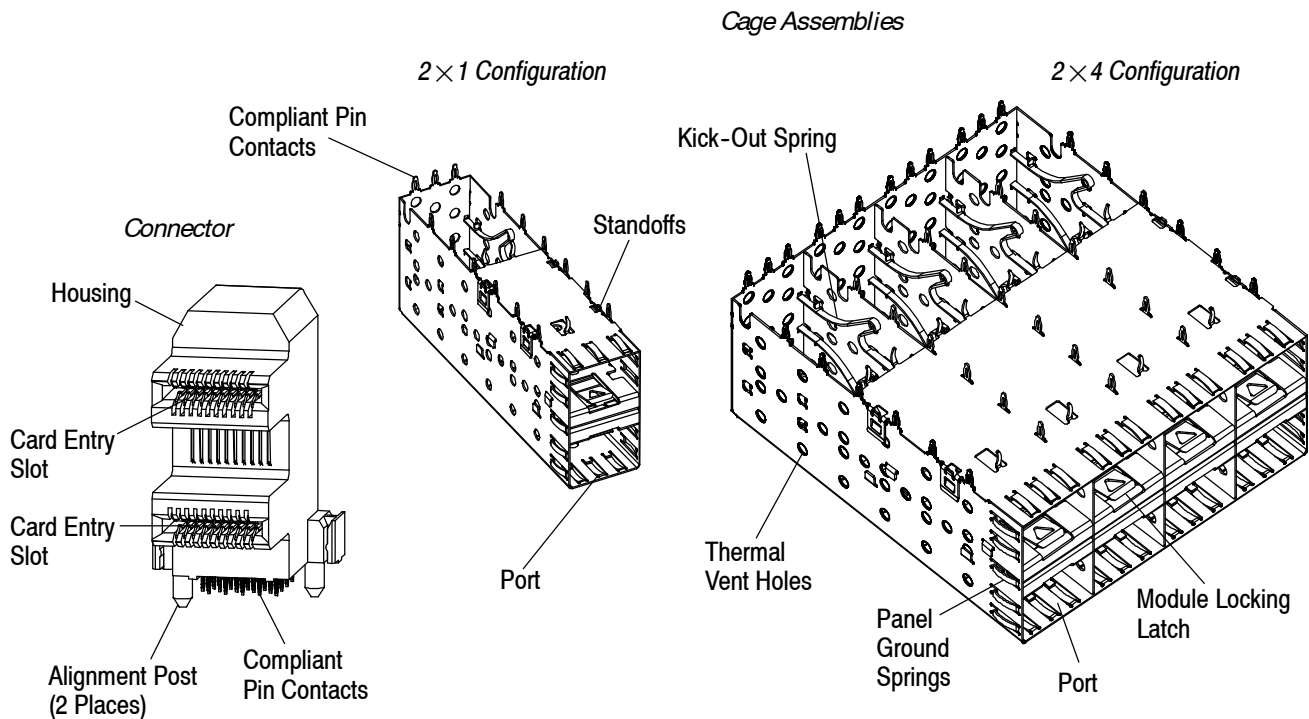


Figure 1 (end)

2. REFERENCE MATERIAL

2.1. Revision Summary

- Updated document to corporate requirements
- New logo

2.2. Customer Assistance

Reference Product Base Part Number 1658390 and Product Code K221 are representative of Stacked SFP Connector and Cage Assembly. Use of these numbers will identify the product line and expedite your inquiries through a service network established to help you obtain product and tooling information. Such information can be obtained through a local TE Representative or, after purchase, by calling Product Information at the number at the bottom of page 1.

2.3. Drawings

Customer Drawings for product part numbers are available from the service network. If there is a conflict between the information contained in the Customer Drawings and this specification or with any other technical documentation supplied by TE, the information contained in the customer drawings takes priority.

2.4. Specifications

Product Specification 108-2161 provides product performance and test information for the SFP Connector and Cage Assembly.

2.5. Instructional Material

Instruction Sheets (408-series) provide product assembly instructions or tooling setup and operation procedures. Available documents which pertain to this product are:

<u>Document Number</u>	<u>Document Title</u>
408-8848	SFP PT Connector and Cage Assembly Seating Tool Kits
408-8849	SFP Cage Assembly Extraction Tools
408-8850	SFP PT Connector Extraction Tool 1725480-1

3. REQUIREMENTS

3.1. Safety

Do not stack component packages so high that the shipping containers buckle or deform.

3.2. Limitations

The connectors are designed to operate in a temperature range of -55° to 105°C [-67° to 221°F].

The bezel requirements given in this document are specifically configured for products used in the communications industry. It is strongly recommended that this bezel configuration NOT be used for peripheral component interconnect (PCI) applications.

3.3. Material

The connector housing and chicklets (parts that hold the compliant pin contacts) are made of molded thermoplastic, UL 94-V-0. All compliant pin contacts in the connector are made of phosphor bronze underplated with nickel; plated with tin at the leads and plated with gold at the interface area. The cage assembly is made of copper alloy plated with tin. The dust cover is made of thermoplastic.

3.4. Storage

A. Ultraviolet Light

Prolonged exposure to ultraviolet light may deteriorate the chemical composition used in the connector material.

B. Shelf Life

The connector and cage assembly should remain in the shipping container until ready for use to prevent deformation to the compliant pin contacts and mounting posts. The connector and cage assemblies should be used on a first in, first out basis to avoid storage contamination that could adversely affect performance.

3.5. Chemical Exposure

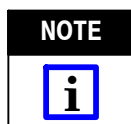
Do not store connector and cage assemblies near any chemical listed below as they may cause stress corrosion cracking in the compliant pin contacts or mounting posts.

Alkalies	Ammonia	Citrates	Phosphates	Citrates	Sulfur Compounds
Amines	Carbonates	Nitrites	Sulfur Nitrites		Tartrates

3.6. PC Board

A. Material and Thickness

The pc board material shall be glass epoxy (FR-4 or G-10). The minimum pc board thickness shall be 1.5 mm.



Contact Product Information at the number at the bottom of page 1 for suitability of other board materials.

B. Tolerance

Maximum allowable bow of the pc board shall be 0.08 mm over the length of the connector and cage assembly.

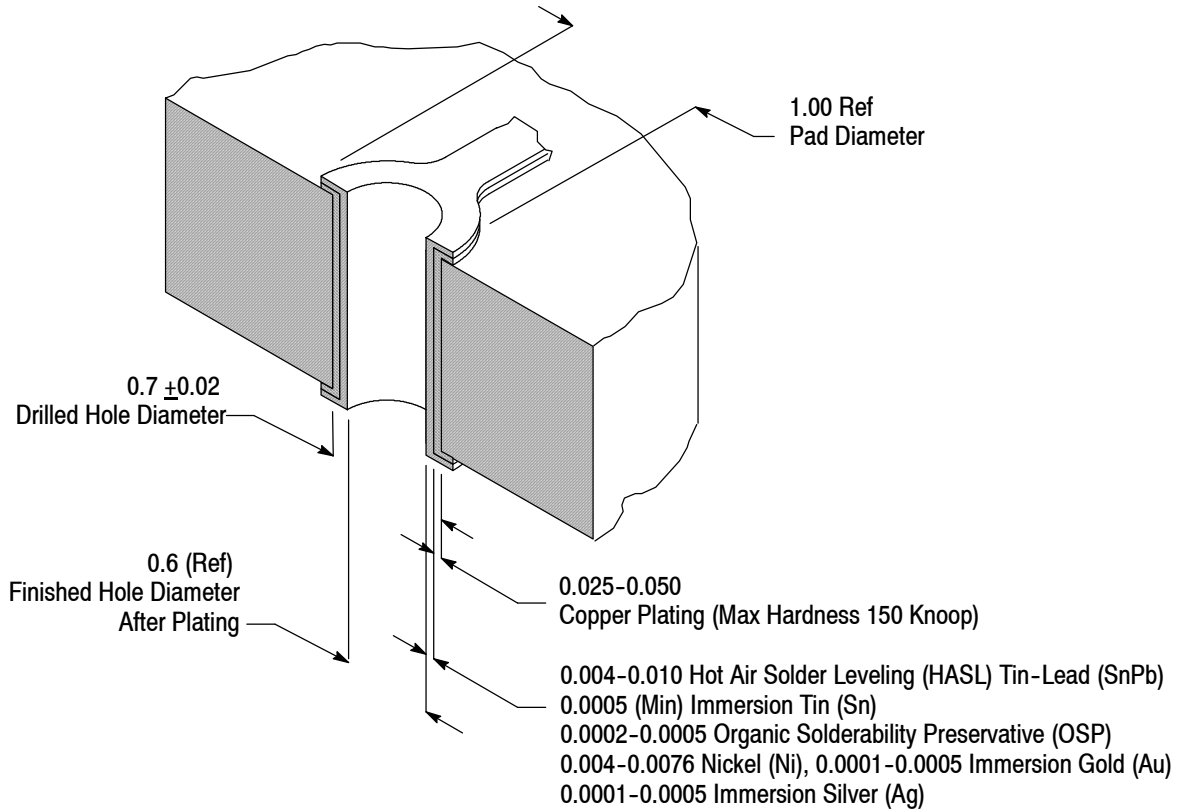
C. Hole Dimensions

The holes for the connector signal contacts and cage assembly must be drilled and plated through to dimensions specified in Figure 2.

D. Layout

The holes for the connector and cage assembly must be precisely located to ensure proper placement and optimum performance of the connector and cage assembly. Recommended hole pattern, dimensions, and tolerances are provided on the customer prints. Sample layouts are provided in Figure 3.

Recommended Hole Dimensions For Connector



Recommended Hole Dimensions For Cage Assembly

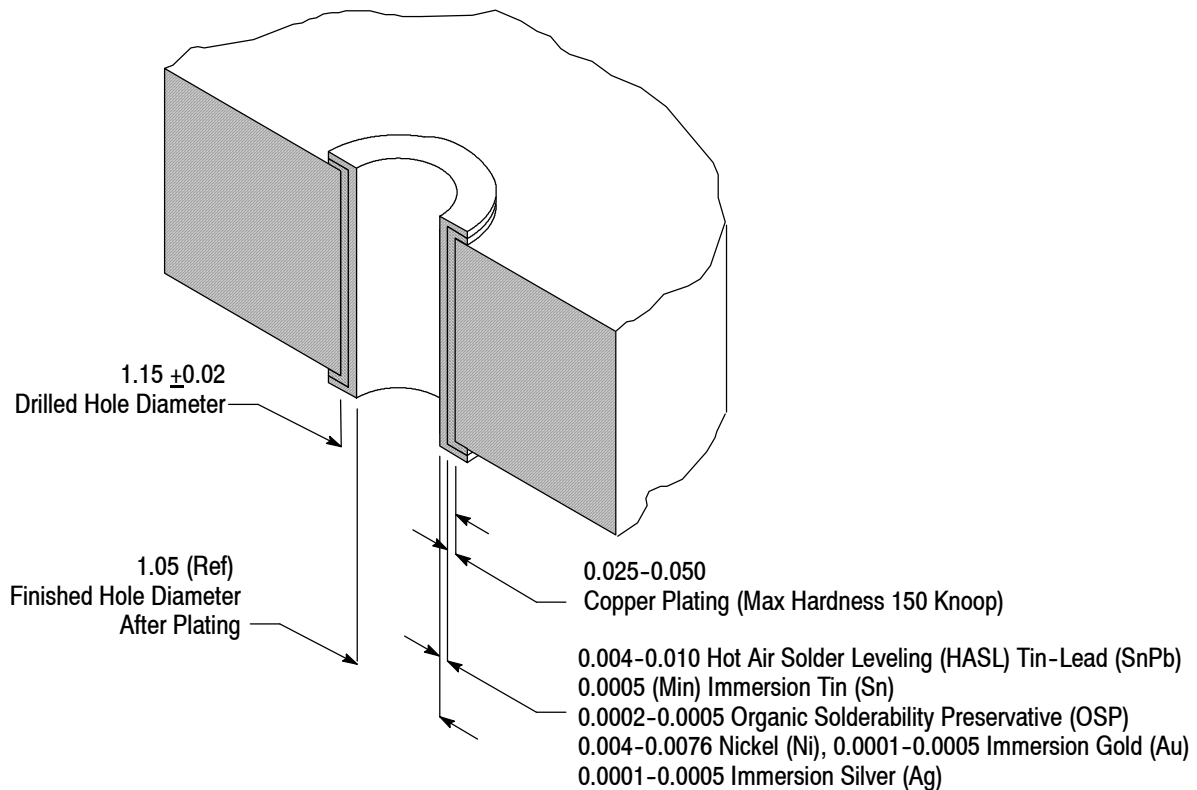
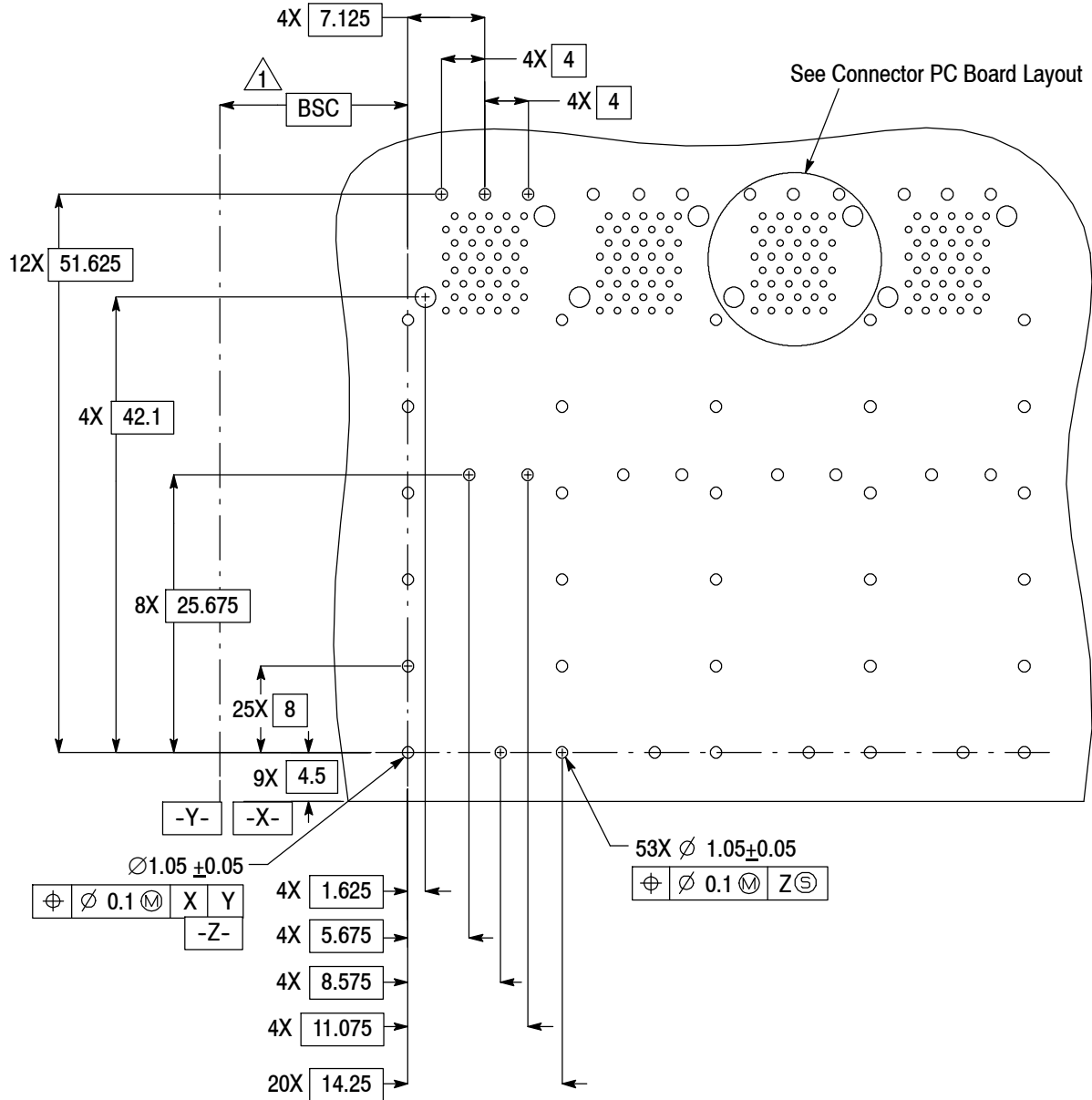


Figure 2

Connector and Cage Assembly
2x4 Configuration



Datum and Basic Dimension Determined by Customer

Figure 3 (End)

3.7. Transceiver Modules



The mating transceiver module packing size cannot exceed the width of each cage port opening. This includes the part of the transceiver that is extending outside the cage. Since the port-to-port spacing has a 14.25 mm centerline, the widest transceiver width extending outside of the cage should be less than 14 mm. This will prevent any possible interference when transceivers are inserted in adjacent ports.

3.8. Bezel



It is strongly recommended that this bezel configuration NOT be used in PCI applications. The following requirements were intended to be used in the communications industry only.

A. Thickness

The bezel thickness range shall be 0.8 through 2.6 mm.

B. Cutout

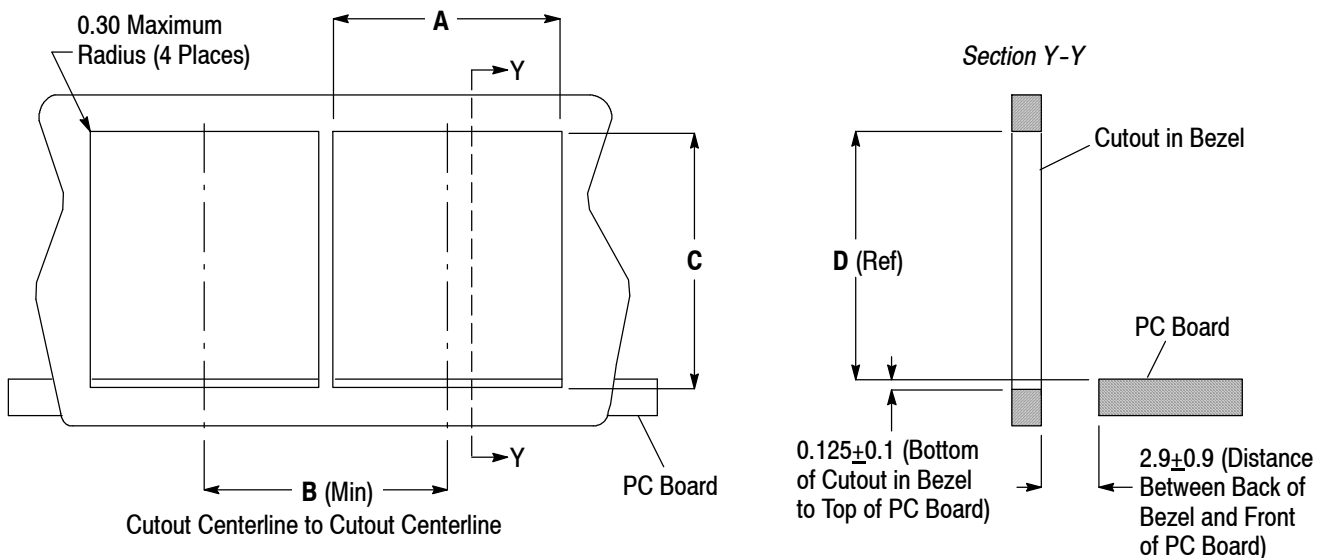
The bezel must provide a cutout that allows proper mounting of the connector and cage assembly. The cage assembly panel ground springs must be compressed by the bezel in order to provide an electrical ground between the connector and cage assembly and bezel for EMI suppression. Care must be used to avoid interference between adjacent connector and cage assemblies and other components. The minimum allowable distance between connector and cage assemblies must be considered to ensure proper assembly. Dimensions for bezel cutout and minimum allowable distance between cutouts are shown in Figure 4.

3.9. PC Board and Bezel Position

The bezel and pc board must be positioned in relation to each other to avoid interference with the function of the cage assembly module locking latch and to ensure proper function of the panel ground springs. This relationship must conform to the dimensions stated in Figure 4.

Note: Not to Scale

Recommended Bezel Cutout (Minimum Pitch) and
PC Board and Bezel Position
Bezel Thickness: 0.8-2.6 mm



CONNECTOR AND CAGE ASSEMBLY		DIMENSION (± 0.1)			
TYPE	CONFIGURATION	A	B (Min)	C	D (Ref)
Standard	2 × 1	15.25	16.5	26	25.875
	2 × 4	58	59.25	26	25.875
	2 × 6	86.5	87.75	26	25.875
Low-Profile	2 × 1	15.25	16.5	23.05	22.925
	2 × 4	58	59.25	23.05	22.925
	2 × 6	86.5	87.75	23.05	22.925

Figure 4

3.10. Placement

The following requirements also apply to connectors and cage assemblies used for rework purposes.



Connectors should be handled only by the housing to avoid deformation, contamination, or damage to the compliant pin contacts.

A. Registration

The compliant pin contacts and mounting posts must be aligned with matching holes in the pc board, then inserted into the pc board simultaneously to prevent twisting or bending of the compliant pin contacts.

B. Seating

Using proper seating force and seating height is essential to interconnection performance. The force used to seat the connector and cage assembly must be applied evenly to prevent deformation or other damage to the compliant pin contacts. The force required to seat the connector and cage assembly onto the pc board can be calculated by:

$$\text{Amount of Compliant Pin Contacts} \times 44.5 \text{ N [10 lbs]} \text{ (Force per Compliant Pin Contact)} = \text{Seating Force}$$



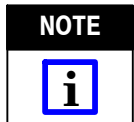
Over-driving of the connector and cage assembly will deform parts critical to the quality of the connection. Maximum force occurs prior to the connector and cage assembly bottoming on the pc board.

The *shut height* of the application tool must be specifically set for proper seating of the connector and cage assembly. The shut height can be calculated by:

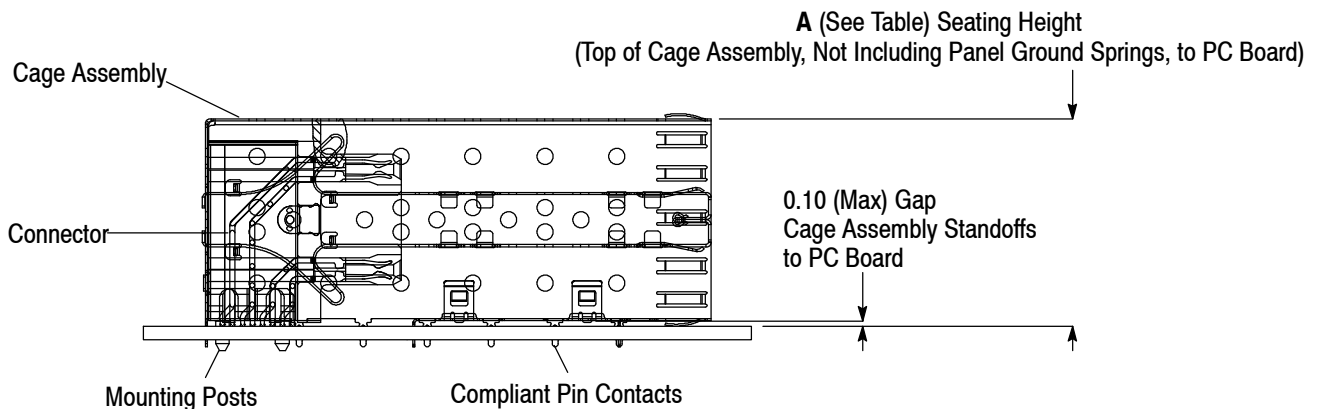
$$\text{Seating Height (Connector and Cage Assembly Seated)} + \text{Height of Seating Tool} + \text{Combined Thicknesses of PC Board and PC Board Support Fixture} = \text{Shut Height (Ram Down)}$$

The seating height, measured from the top of the cage assembly (not including the panel ground springs) to the top of the pc board, is given in Figure 5.

The connector and cage assembly must be seated on the pc board not exceeding the dimensions shown in Figure 5.



The shut height may need to be adjusted to obtain the 0.10 mm maximum gap between the standoffs of the cage assembly and the pc board.

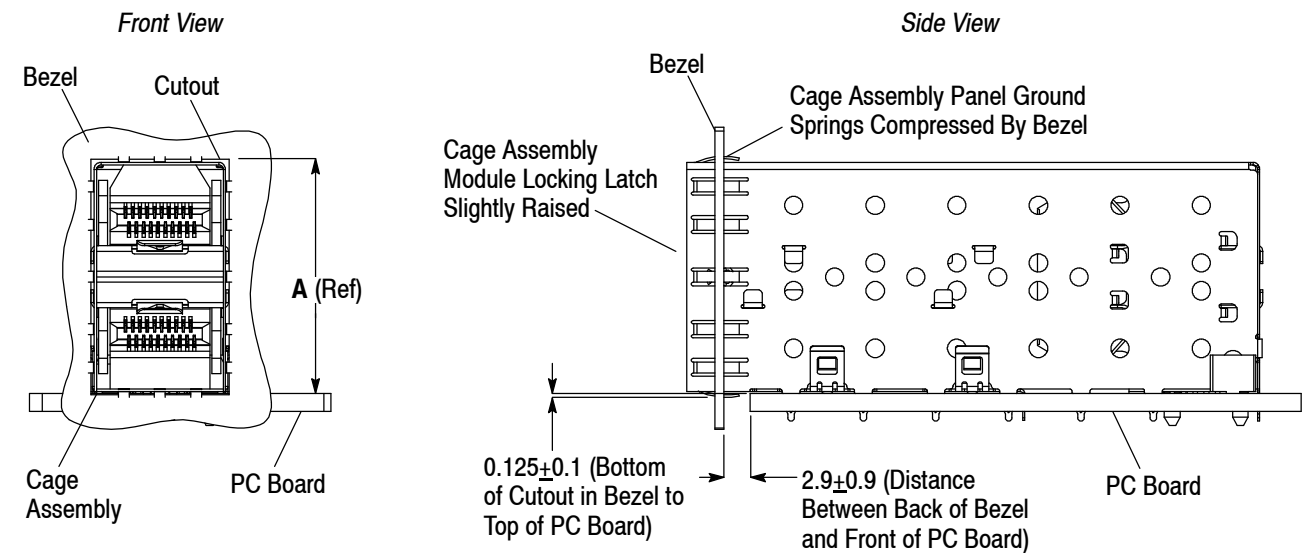


CONNECTOR AND CAGE ASSEMBLY TYPE	DIMENSION A
Standard	25.5
Low-Profile	22.55

Figure 5

3.11. Checking Assembly

After assembly, the cage assembly panel ground springs must be compressed by the bezel. A slight bow in the cage assembly is permitted. The bezel must not interfere with the function of the module locking latch. The bezel and pc board must be positioned according to the dimensions shown in Figure 6.



CONNECTOR AND CAGE ASSEMBLY TYPE	DIMENSION A ± 0.1 mm (REF)
Standard	25.875 mm
Low-Profile	22.925 mm

Figure 6

3.12. Dust Cover

A dust cover must be installed into its respective port when the module is not mated with the cage assembly.

3.13. Repair and Rework

Damaged or defective connector and cage assemblies must be removed and replaced.

If repair or rework to the pc board requires soldering after the connector and cage assembly has been seated onto the pc board, the following must apply:

— After soldering, removal of fluxes, residues, and activators is necessary. Consult with the supplier of the solder and flux for recommended cleaning solvents. Cleaners must be free of dissolved flux and other contaminants. Even when using a “no clean” solder paste, it is imperative that the contact interface be kept clean of flux and residue (since it acts as an insulator).



Consideration must be given to toxicity and other safety requirements recommended by the solvent manufacturer. Refer to the manufacturer’s Material Safety Data Sheet (MSDS) for characteristics and handling of cleaners. Trichloroethylene and Methylene Chloride is not recommended because of harmful occupational and environmental effects. Both are carcinogenic (cancer-causing).

— Air drying is recommended. Otherwise, make sure that temperature limitations are not exceeded: -55° to 105° C [-67° to 221° F]. Excessive temperatures may cause housing degradation.

4. QUALIFICATION

SFP Connectors are Recognized by Underwriters Laboratories Inc. (UL) in File No. E28476.

5. TOOLING

Tooling part numbers and instructional material packaged with the tooling are given in Figure 7.

5.1. Seating Tool Kits

The seating tool kits (each consists of a seating tool and wall support) are used to seat the connector and cage assembly onto the pc board. The seating tool and wall support are also available separately. For rework purposes, the seating tool can be used to seat the cage assembly. Flat rock tooling is needed to insert the connector during rework.

5.2. Extraction Tool

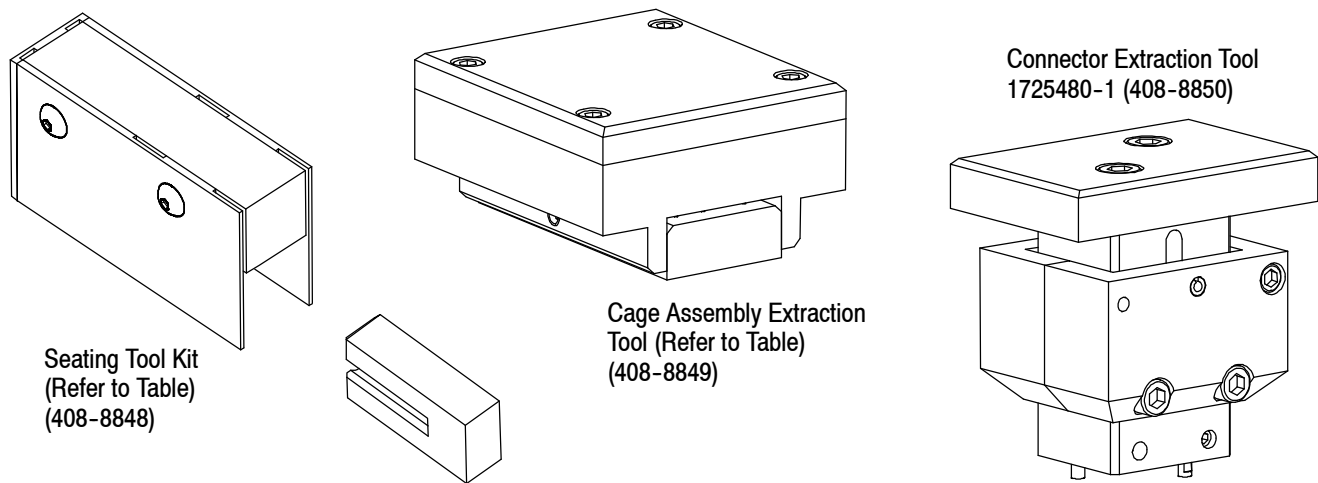
The extraction tool is used to remove the cage assembly or connector from the pc board by pushing the contacts out of their holes without overstressing the contacts.

5.3. Application Tool

Power for the seating tools and extraction tools must be provided by an application tool (with a ram) capable of supplying a downward force of 44.5 N [10 lb] per contact. For available application tools, call Product Information at the number at the bottom of page 1.

5.4. PC Board Support Fixture

A pc board support must be used with the seating tool and the extraction tool. The support fixture provides proper support for the pc board and protects the pc board and the connector and cage assembly from damage. The support fixture must be customer designed. It is recommended that the support fixture be at least 25.4 mm longer and wider than the pc board and have flat surfaces with holes or a channel large enough and deep enough to receive any protruding components of the connector and cage assembly.



CONNECTOR AND CAGE ASSEMBLY		SEATING TOOL KIT	CAGE ASSEMBLY EXTRACTION TOOL
TYPE	CONFIGURATION		
Standard	2×1	1490197-2	1725194-2
	2×4	1490197-1	1725194-1
	2×6	1804875-1	1804086-1
Low-Profile	2×1	1725616-1	1725194-2
	2×4	1725618-1	1725194-1
	2×6	1804419-1	1804086-1

Figure 7

6. VISUAL AID

Figure 8 shows a typical application of stacked a SFP Connector and Cage Assembly. This illustration should be used by production personnel to ensure a correctly applied product. Applications which DO NOT appear correct should be inspected using the information in the preceding pages of this specification and in the instructional material shipped with the product or tooling.

**Note: Connector and Cage Assembly 2 × 4 Configuration Shown
Requirements Also Apply to 2 × 1 Configuration and 2 × 6 Configuration**

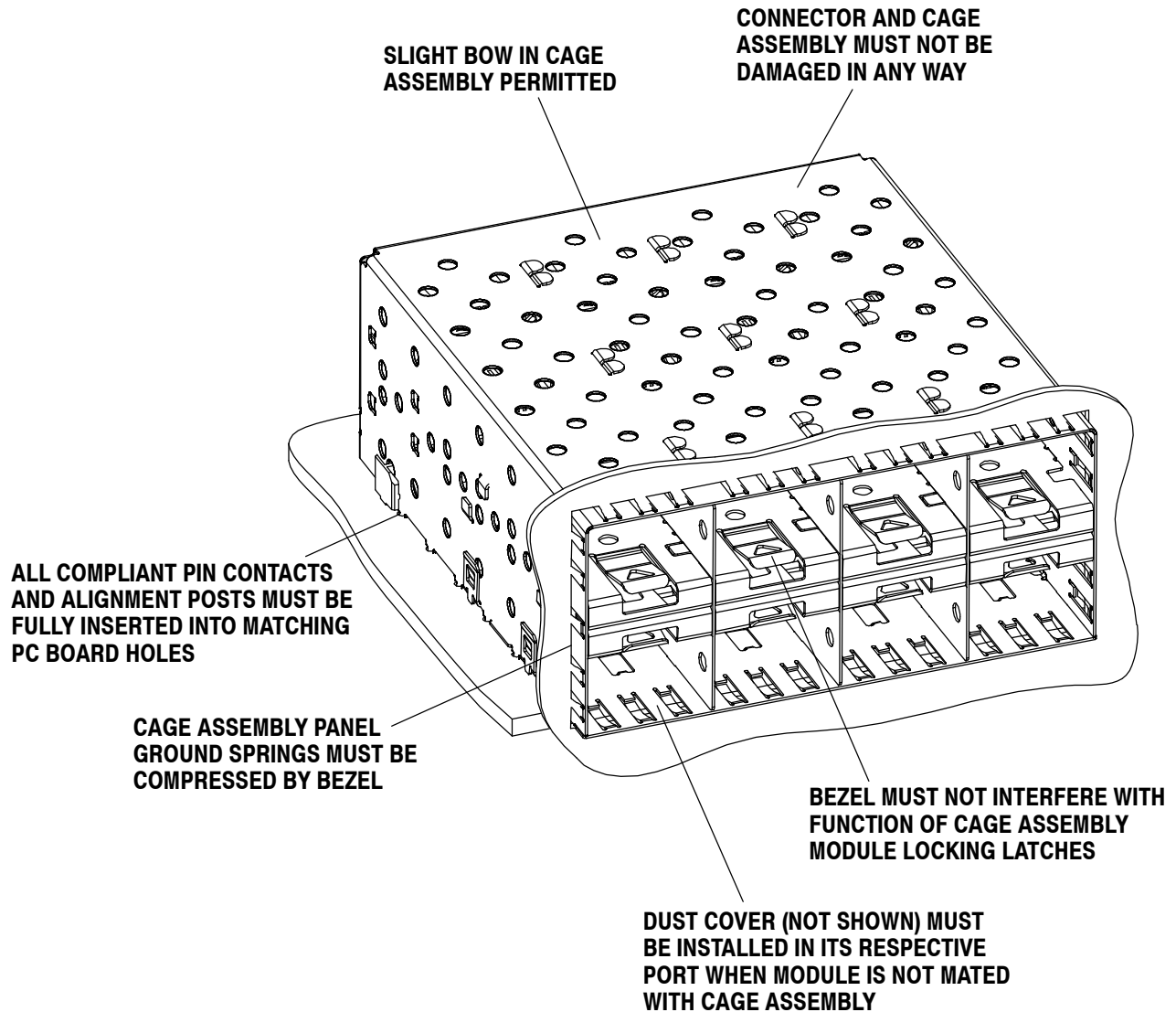


FIGURE 8. VISUAL AID