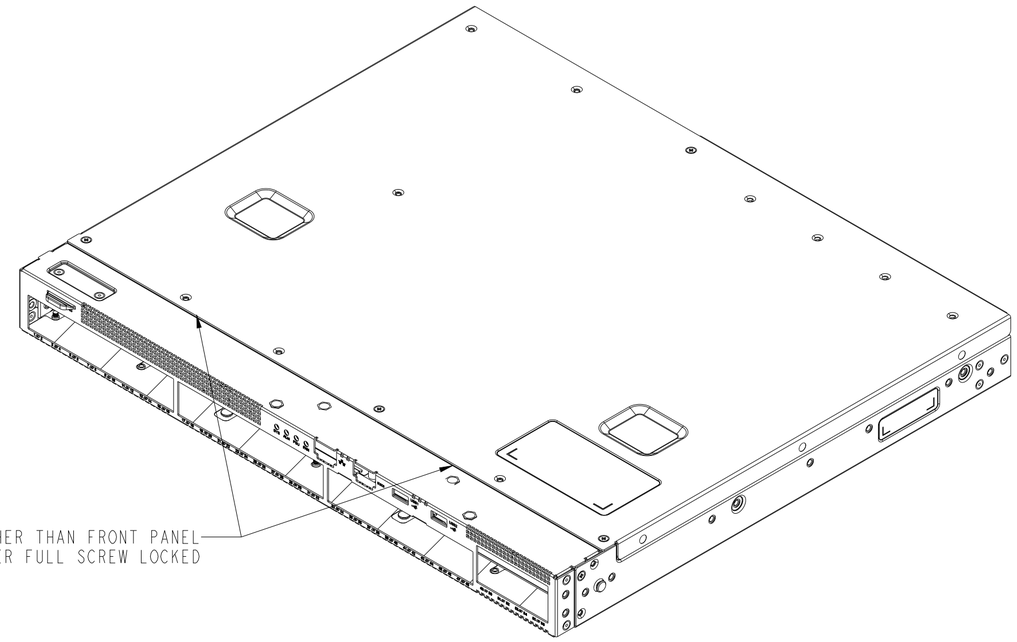
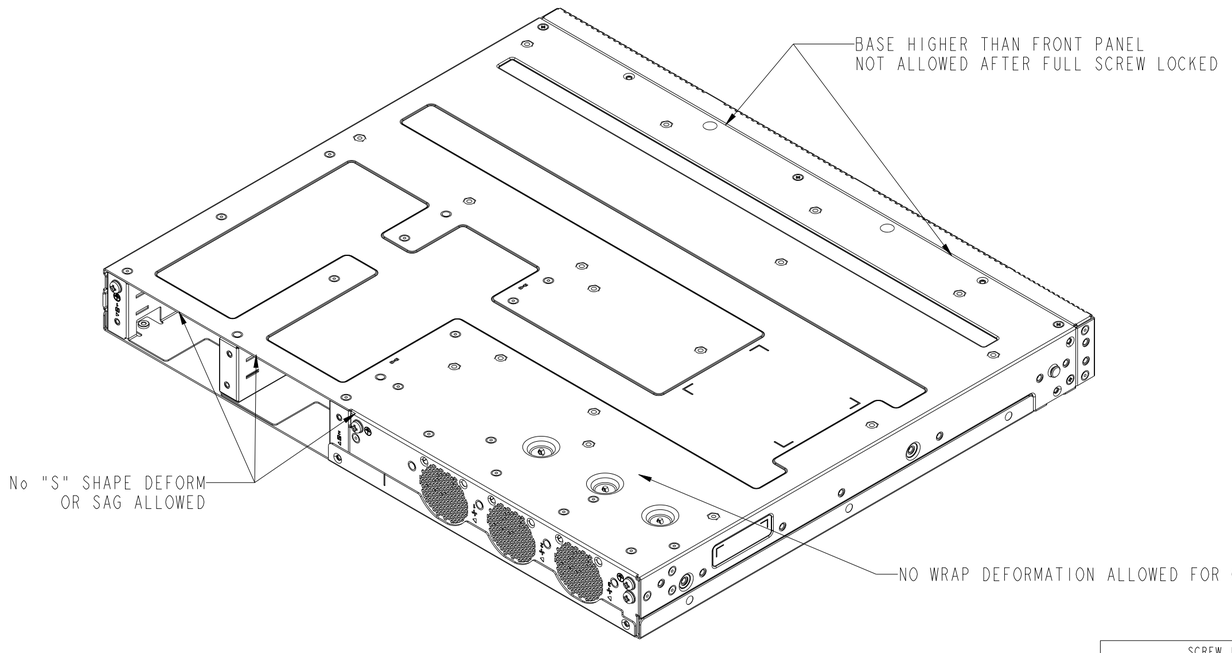
REV.	ECN NO.	DESCRIPTION	DATE	DESIGNED	APPROVED
01		INITIAL RELEASE.	2021/10/12	Penn Pan	



SCALE 0.400



SCALE 0.400

NOTES: UNLESS OTHERWISE SPECIFIED.
1. ALL DIMENSIONS UNIT IS MM. DEFAULT TOLERANCE AFTER ASSEMBLY:
   THIS DRAWING SHALL BE INTERPRETED IN ACCORDANCE WITH ASME Y14.5 M-1994.
   ASSEMBLY TOLERANCE: +/- 0.25 WITHIN RANGE OF 0~<200MM.
   ASSEMBLY TOLERANCE: +/- 0.35 WITHIN RANGE OF 200~<400MM.
   ASSEMBLY TOLERANCE: +/- 0.50 WITHIN RANGE OF >400MM.
2. THE MANUFACTURING PROCESS OR HANDLING OF THIS MATERIAL
   REQUIRES SPECIAL HEALTH AND SAFETY PRECAUTIONS.
3. PART SHALL BE FREE OF OIL, STAINS, OR OTHER CONTAMINANTS.
4. MATERIAL(S) AND FINISH(ES) USED IN THIS PRODUCT MUST COMPLY WITH EU ROHS.
5. NON-SERIALIZED LABEL TO BE LOCATED APPROXIMATELY AS SHOWN ON ASSEMBLY PART WILL CONTAIN PN,REV,PN BARCODE,MFG LOATION,AND MFG DATE.
6. THE ASSEMBLY DIMENSION FAI REPORT ARE REQUIRED FOR ALL LOT BUILD BEFORE SHIPMENT. FAI TO MEASURE 5 PCS SAMPLES (CNC OR HT) FOR ALL DIMENSIONS ON 2D DRAWING, AND INSPECT ALL MODULAR SLOTS AND CTF DIMENSIONS TO USE GO-NGO GUAGE.
7. THE ASSEMBLY CPK FOLLOWS 4-SIGMA STANDARD FOR HARD TOOLING PRODUCTION, AND MEASURE 32 PCS SAMPLES FOR CTF DIMENSIONS WITH OVAL MARKS ON ASSEMBLY DRAWING. IF CPK CAN NOT MEET 1.33, USE GO-NGO GUAGE TO INSPECT FOR EACH LOT SHIPMENT, BUT ALL CTF DIMENSION MEASUREMENT RESULT MUST BE WITHIN THE DESIGN SPEC.
8. CHASSIS BOTTOM SAG AND TOP BOW WILL FOLLOW THE ADDITIONAL REQUIREMENT TO MEASURE.
9. All CTF DIMENSIONS AND CHASSIS BOTTOM FLATNESS ARE REQUIRED TO BE SAMPLING INSPECTED BY SUPPLIER AND CELESTICA MFG SITE IQC. AT LEAST, CTF DIMENSIONS (WITH OVAL MARKS) SHALL INCLUDE ALL SLOTS HEIGHT & WIDTH, CHASSIS HEIGHT & WIDTH, FUNCTIONAL FEATURE LOCATION & PITCH, ETC ON THE DRAWING.
10. ALL DEFORMING GAP BETWEEN EDGES OR SURFACES AFTER ASSEMBLY ARE PERMITTED MAX 0.3MM WHICH IS CAUSED BY SUPPLIER ASSEMBLY PROCESS IF NO DEFINITION IS FOUND ON THE DRAWING.
11. THE FINISHED PARTS ARE SUITABLY PROTECTED TO PREVENT THE DAMAGE OR DEFORMING DURING SHIPMENT.
12. CERTIFICATION OF COMPLIANCE, MATERIAL TYPE AND UL FLAME RATING SHALL BE PROVIDED IN PPAP REPORT.
13. ALL SCREW TORQUES ARE REQUIRED TO MARK ON THE DRAWING OR REFER TO THE TABLE OF RECOMMENDED TORQUE.
14. ALL COUNTERSUNK RIVETS OR SCREWS OR SWAGES SHALL BE FLUSH OR BELOW THE METAL SURFACE.RIVETS SHALL BE INSTALLED CORRECTLY TO ENSURE NO LOOSE MOVEMENT OR ROTATION.
15. PAINTING OR ARTWORK (IF APPLICABLE) SHALL BE ADDED ON INDICATED SURFACES.
    NO COATING OR PAINTING AT THE AREA OF NOT SPECIFIED ON THE DRAWING.
    DETAIL INFORMATION IS AVAILABLE ON THE SEPARATE SPEC OR DRAWING.
16. AFTER THE ORIGINAL CELESTICA ENGINEERING APPROVAL HAS BEEN GRANTED, THE VENDOR SHALL NOTIFY CELESTICA ENGINEERING IN WRITING PRIOR TO THE IMPLEMENTATION OF ANY CHANGE TO THE PRODUCT OR PRODUCT QUALITY ASSURANCE PROGRAM.
17. PRODUCT FOLLOWS GDS WHITEBOX PRODUCT APPEARANCE INSPECTION STANDARD DOC0102006.
    PRODUCT ACCEPTS CYCLIC CORROSION TEST TO APPEAR RED RUST AFTER MIN 8 HOURS, AND CAN ACCEPT WHITE RUST TO TEST IN 8 HOURS.
18. ALL HARDWARE TO BE INSTALLED PER MANUFACTURER'S SPECIFICATION. ZINC PLATING THICKNESS IS MINIMUM 5 UM FOR ALL HARDWARES AND THE CUSTOMIZED PARTS.
19. ALL EXPOSED HOLES AND EDGES TO BE COINED FROM TOOLING TO INSURE SMOO
    WITHOUT BURRS, AND THE BURR OF NON-EXPOSED EDGE NOT EXCEED 10% MATERIAL
20. WHEN USING PRE-PLATED MATERIALS FOR METAL THICKNESS LESS THAN AND
    EQUAL TO 1.2MM, ONLY PERMIT TO HAVE THE NON-CONTINUOUS RUST ON CUTTING
    SURFACE WITH LESS THAN 20% OF SURFACE AREA WHERE END-USER CAN SEE THEM.
    ALL METAL THICKNESS OF OVER 1.2MM,THE OIL-BASED SILVER PAINTING
    (RoHS COMPLIANCE) IS PERMITTED TO USE ON CUTTING EDGES.
    ALSO THE WHOLE PART CAN BE ZINC PLATED, OR CLEAN-DRY PROCESS
    (ANTIRUST LIQUID SC-6008), OR BLACK PAINTING AS DRAWING DEFINITION.
    THICKNESS IF NOT SPECIFIED ON 2D DRAWING.
21. ALL EXPOSED EDGES MUST MEET THE SAFE HANDLING REQUIREMENTS SPECIFIED
    IN UL 1439. IN ADDITION, INDICATED EDGES MUST ALSO NOT CUT THROUGH
    THE FIRST LAYER OF THE TESTER (EXPOSING THE WHITE LAYER).
22. PLEASE FOLLOW THE 3D CAD FILE FOR COMPLETE PART INFORMATION TO MAKE TOOLING.
23. FULL LOADING SYSTEM SAG&BOW NEEDS TO MEET THE HEIGHT REQUIREMENT OF 1U,
    TOP BOW: 0.2MAX; BOTTOM SAG: 0.3MAX.
24. THE CONTACT AREA WITH IRON PARTS WHERE EMI GASKET IS PASTED NEEDS TO AVOID PAINTING.

SCREW INSTALL RECOMMENDED TORQUE								
THREAD TYPE	M2	M2.5	M3	M3.5	M4	M5	#6-32	Thumbscrew
HARD MATERIAL (kgf.cm,+/-0.5)	1.5	3	5.5	8	12	14	8	3.5
HARD MATERIAL (lbf.in,+/-0.5)	1.3	2.5	4.5	7	10	12	7	3

PARAMETERS THAT WILL CAUSE THE TORQUE TO LOWER.
1. Thin female thread (Press in style nut).
2. Extruded and tapped hole on thin sheet metal.
3. Tapped hole on soft material (die casting).
4. Insert in plastic.
PARAMETERS THAT WILL CAUSE THE TORQUE TO HIGHER.
1. Screw thread with Nylok.
2. Requirement from the shock and viberation or pack testing.

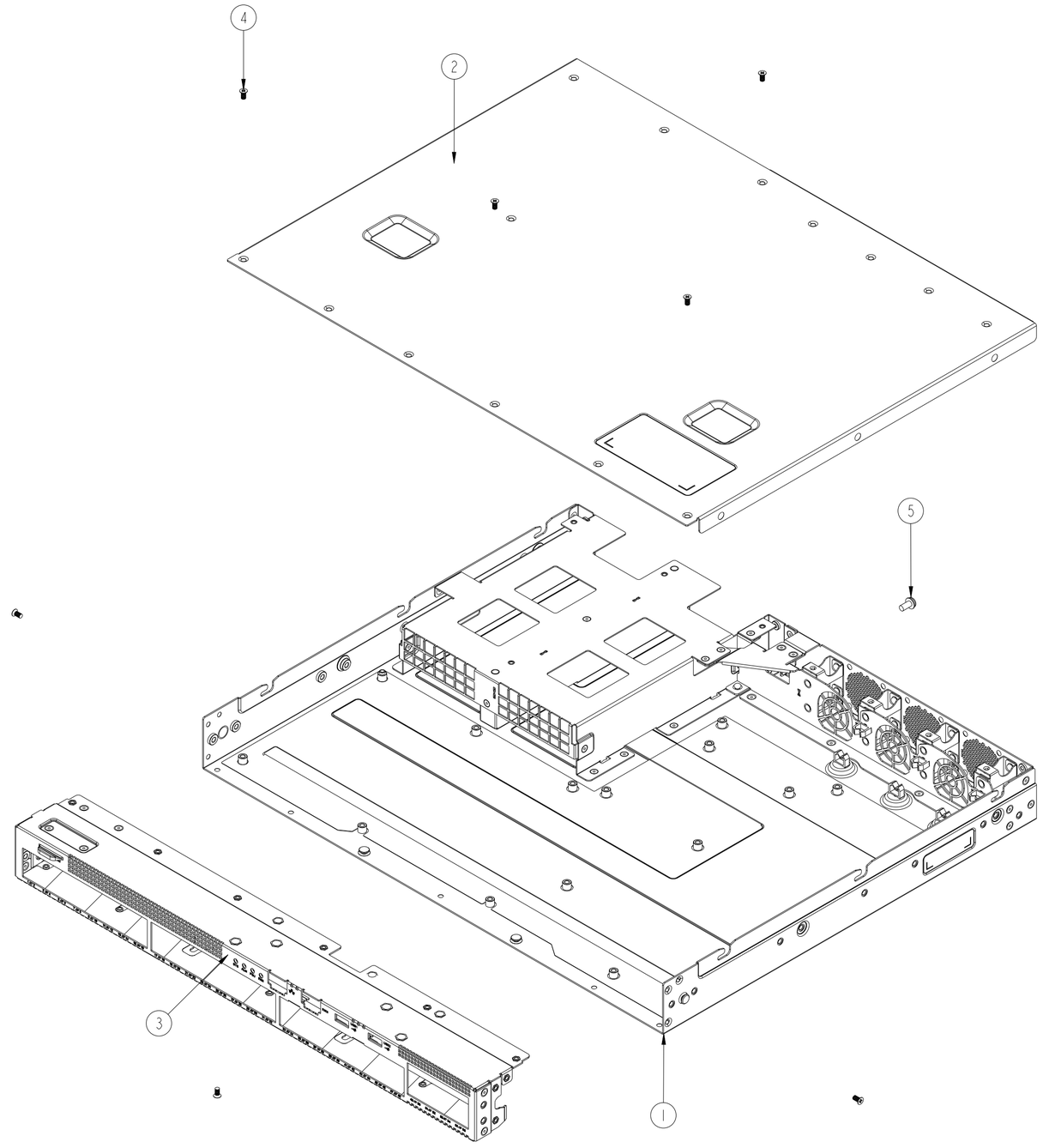
ITEM	P/N	Rev	Description	Qty	Vendor	Note
6	R3059-K2003-01	01	MYLAR, CHASSIS, SIDE, RAIL	2		
5	GT21-03066-01_SCREW,M4,GRD	01	SCRW, GRD, M4, M0	4		
4	G340-10014-01	01	FLAT SCREW M3	9		
3	R3059-F2003-03	01	ASSY, PANEL, FRONT, CHASSIS, M0	1		
2	R3059-F2002-03	01	ASSY, CVR, TOP, CHASSIS, M0	1		
1	R3059-F2001-03	01	ASSY,CHASSIS, L3, SWITCH, M0	1		

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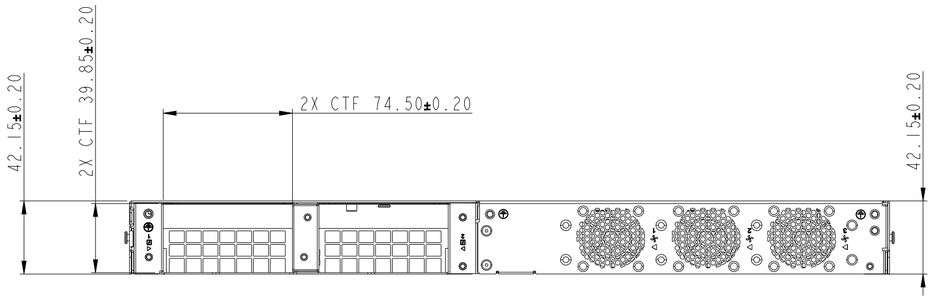
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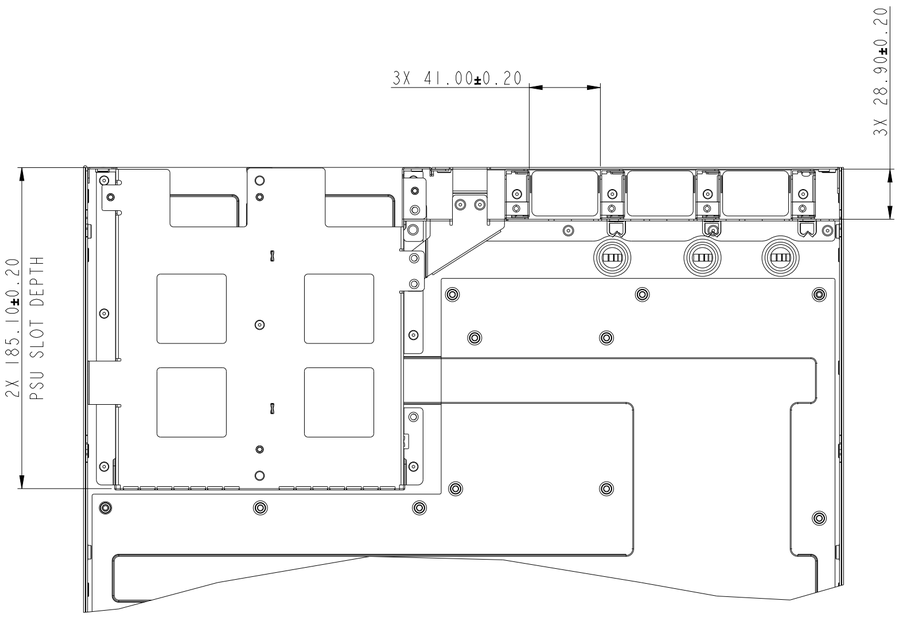
SIZE	3RD ANGLE	NOT TO SCALE
A2		UNIT: MM

DESCRIPTION	ASSY,CHASSIS,L5,1U,SWITCH,M0			SHEET	
PART NUMBER	R3059-F0001-03	REV./VER.	01/.0		1/3



SCALE 0.400



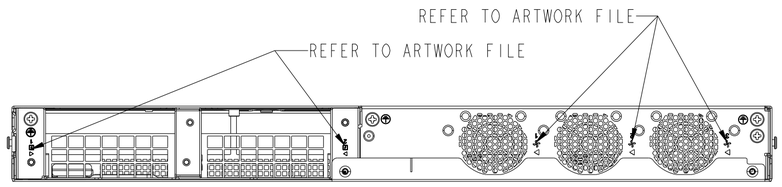


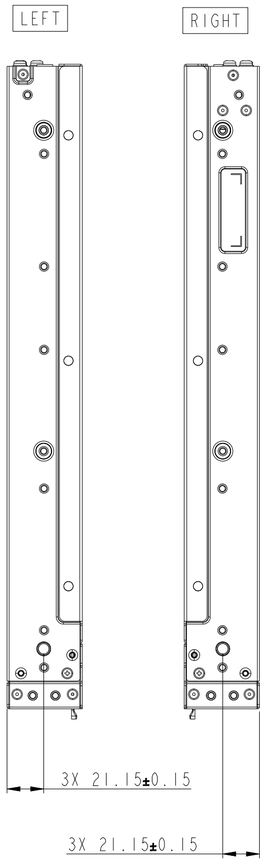
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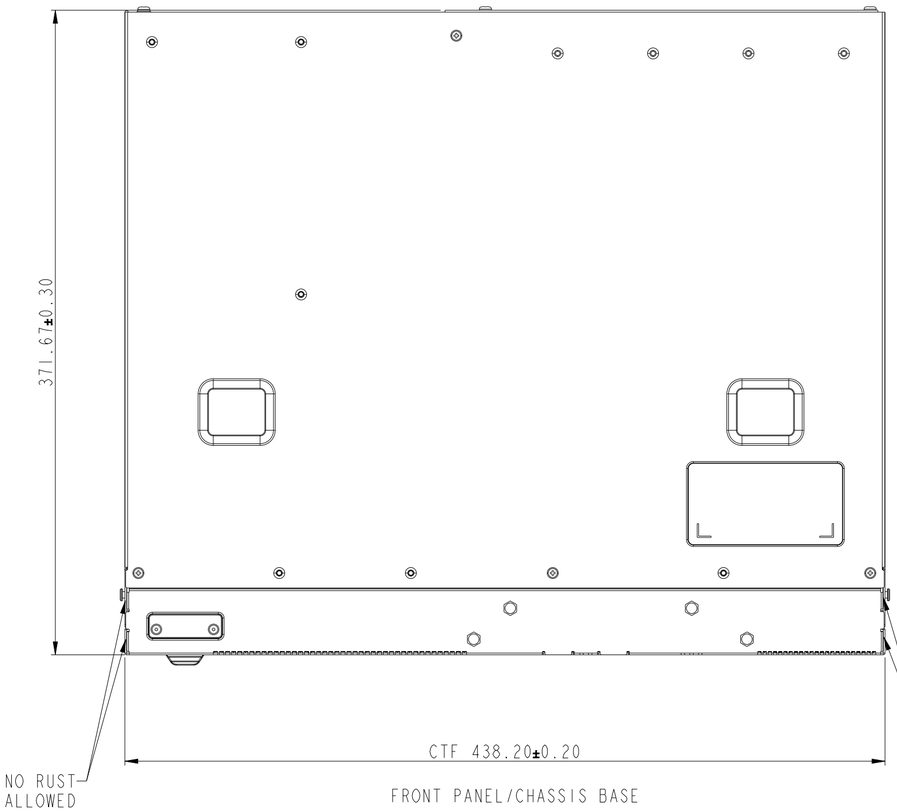
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GDS (GLOBAL DESIGN SERVICE)

DESCRIPTION			
ASSY,CHASSIS,L5,IU,SWITCH,MO			
SIZE A2	PART NUMBER R3059-F0001-03	REV./VER. 01/.0	SHEET 2/3

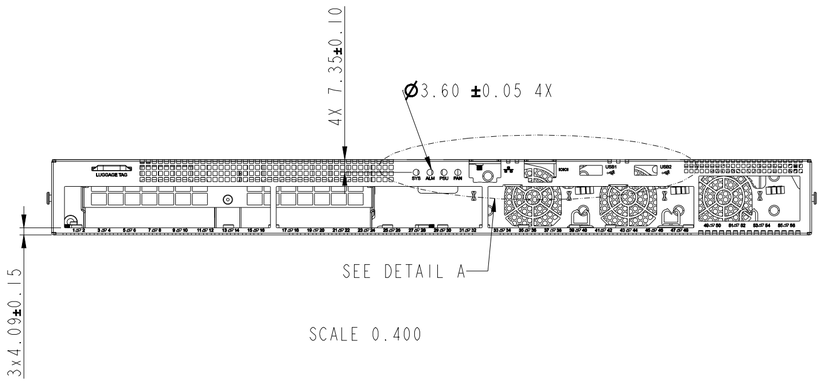




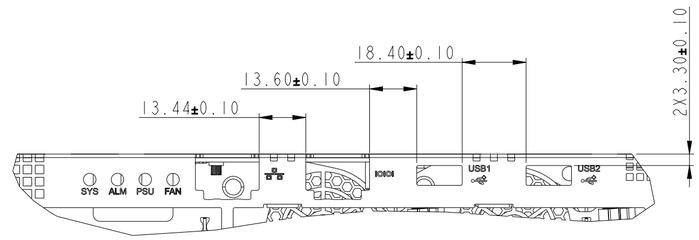


FRONT PANEL/CHASSIS BASE

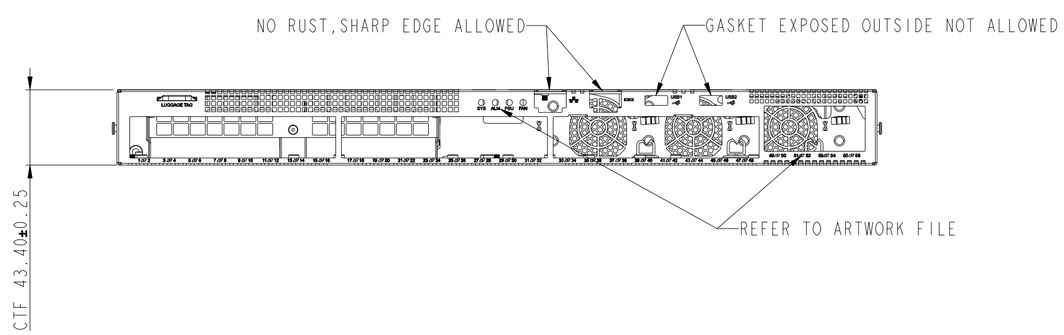
SCALE 0.400



SCALE 0.400



DETAIL A
SCALE 0.800



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GDS (GLOBAL DESIGN SERVICE)

DESCRIPTION			
ASSY,CHASSIS,L5,1U,SWITCH,M0			
SIZE A2	PART NUMBER R3059-F0001-03	REV./VER. 01/.0	SHEET 3/3