

REVISION HISTORY				
REV	ECO	DESCRIPTION	DATE	DRW/CHK
A		INITIAL RELEASE NPRO 005286	01APR18	TJM/TJM
C	008685	UPDATE TO INCLUDE ADDITIONAL ANTENNA AND POWER PLUG	15MAY18	TJM/TJM
D	009082	UPDATED SUBASSEMBLIES	10SEP18	TJM/TJM
E	009375	UPDATED NOTES AND TOLERANCES	01DEC18	TJM/TJM

- ASSEMBLY TORQUE VALUES:
 #4-40 FLATHEAD COUNTERSUNK SCREWS: 2.9±0.5 IN-LBS
 #4-40 PANHEAD SEMS SCREWS: 6.5±0.5 IN-LBS
 #6-32 SCREWS: 8.0±0.5 IN-LBS
 #4-40 THUMBSCREWS: 6.5±0.5 IN-LBS
 SMA NUTS (BRASS): 9.0±1.0 IN-LBS

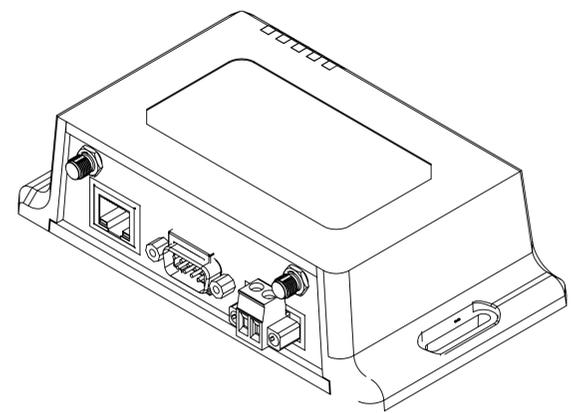
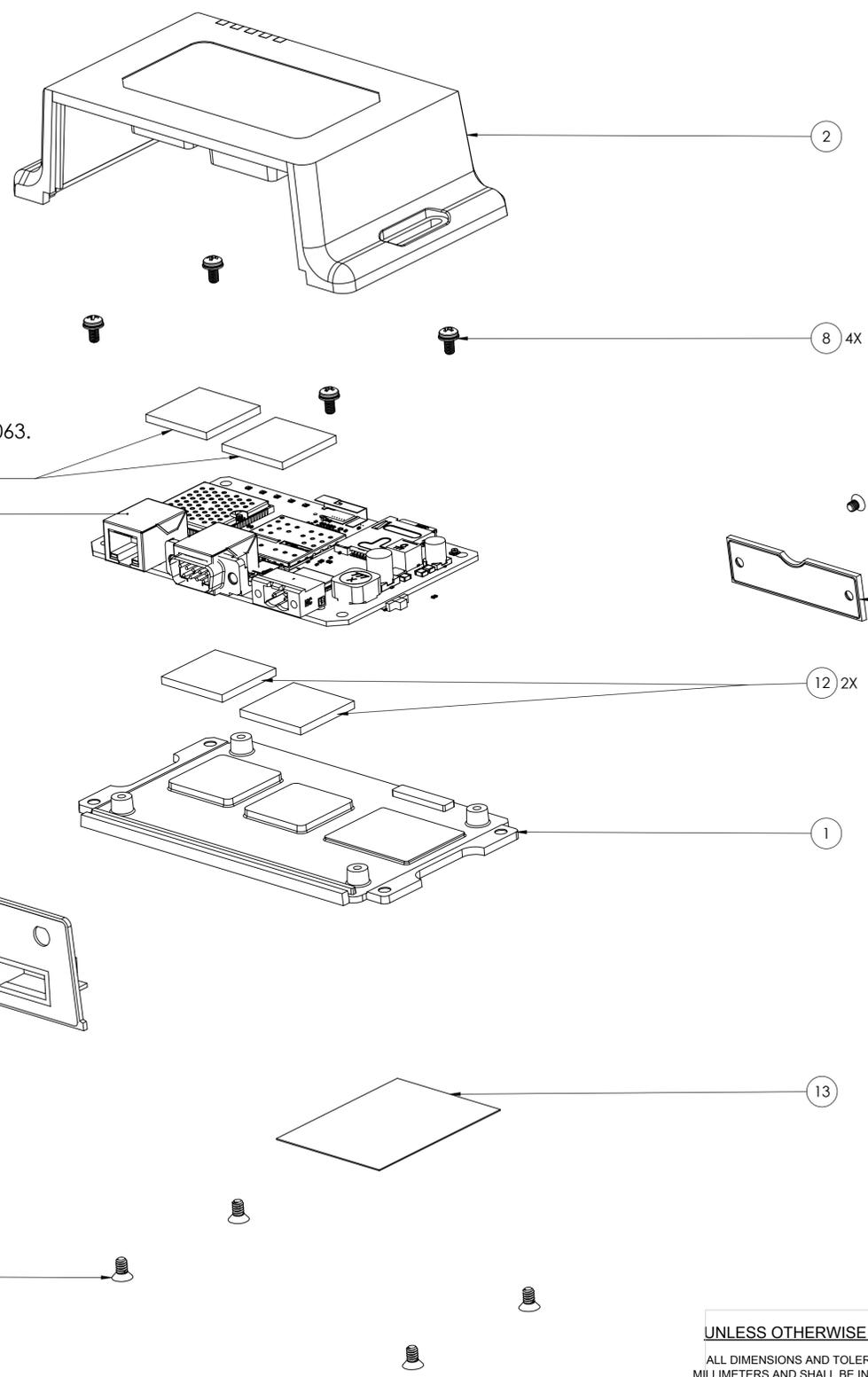
2. INSTALL PER MANUFACTURER'S RECOMMENDATIONS.

3. SEE MANUFACTURING WORK INSTRUCTIONS FOR FURTHER DETAIL.

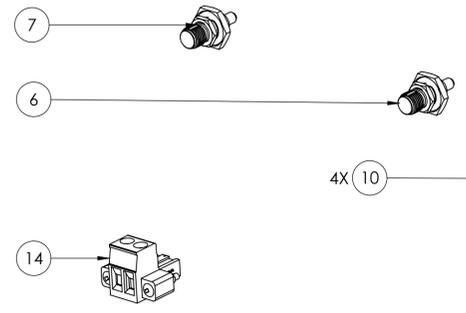
- AT THE TIME OF FABRICATION, MANUFACTURING PROCESS AND MATERIALS SHALL COMPLY WITH THE CURRENT REVISION OF THE FOLLOWING REGULATIONS:
 - EU AND CHINA RoHS DIRECTIVES.
 - REACH SVCH DIRECTIVES.
 - SECTION 1502 OF THE U.S. DOOD-FRANK WALL STREET REFORM AND CONSUMER PROTECTION ACT REGARDING CONFLICT MINERALS.

- SUPPLIER SHALL MEET REQUIREMENTS DEFINED IN DIGI SUPPLIER QUALITY HANDBOOK 96007159. PART SHALL MEET DIGI COSMETIC FINISH SPECIFICATION DEFINED IN WI 96000063. ALL OUTSIDE SURFACES OF PART SHALL MEET SURFACE CLASS A REQUIREMENTS DEFINED IN WI 96000063. COLOR APPRAISAL SHALL BE INSPECTED PER WI 96000664.

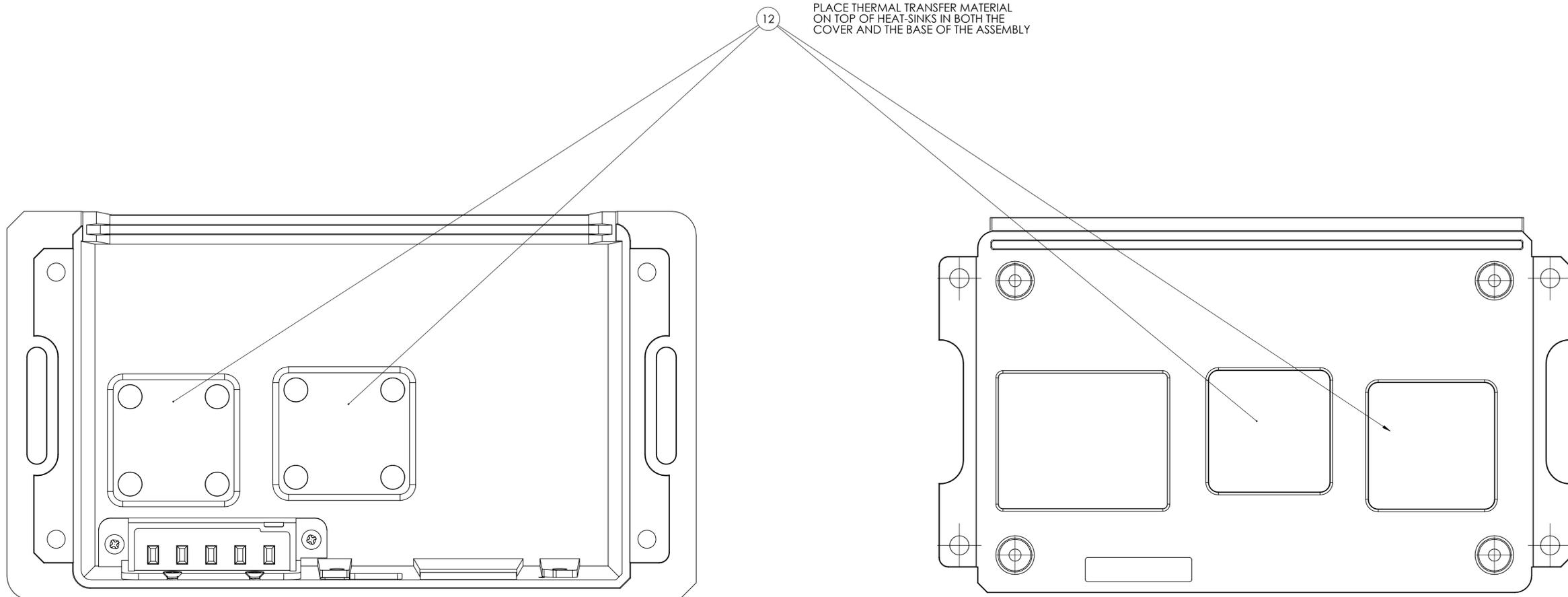
6. SEE B.O.M. FOR POPULATION OPTIONS.



ISOMETRIC VIEW FOR REFERENCE ONLY



UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS AND TOLERANCES ARE IN MILLIMETERS AND SHALL BE INTERPRETED PER ASME Y14.5M - 1994 DRAWING TOLERANCES ARE AS FOLLOWS: FRACTIONS ±1/64 DECIMALS .X ±.5 ANGLES ±1° .XX ±.30 .XXX ±.010 THIRD ANGLE PROJECTION	DESIGNER/ENGINEER: T.MILLER	DATE: 1/4/2018	DIGI INTERNATIONAL 11001 BREN ROAD EAST MINNETONKA, MN 55343	
	HW ENGINEER: M.STOREY	DATE: 1/4/2018		TITLE DWG, ASSY IX14
	MFG/OPS: A.SURI	DATE: 1/4/2018	SIZE D	CAGE CODE 08TP3
	DRAFTER: T.MILLER	DATE: 1/4/2018	DWG NO: 50001959-XX	REV E
PRODUCT MANAGER: S.GEKHT	DATE: 1/4/2018	SCALE NTS	DO NOT SCALE DRAWING SHEET 1 OF 3	



**THERMAL INTERFACE MATERIAL
PLACEMENT VIEW**

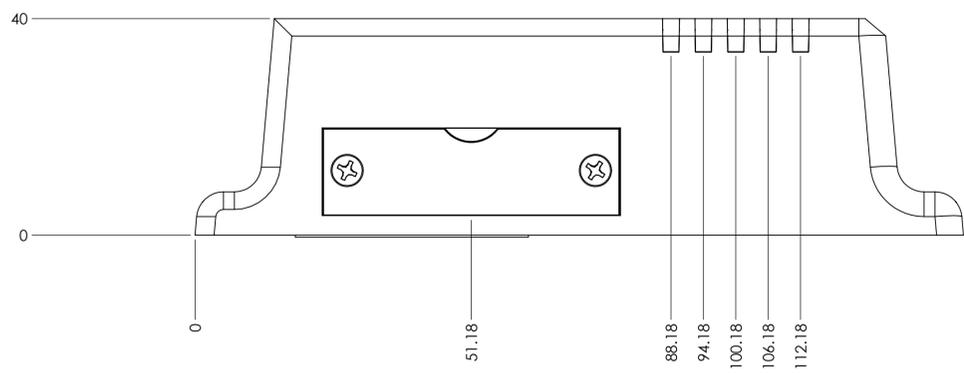
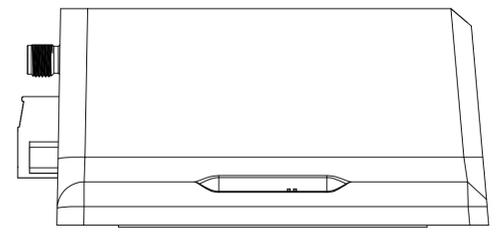
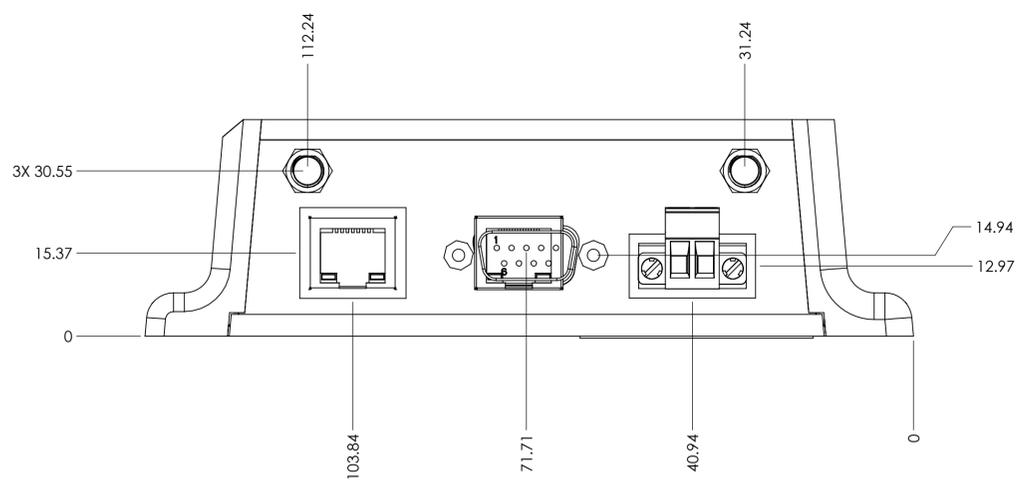
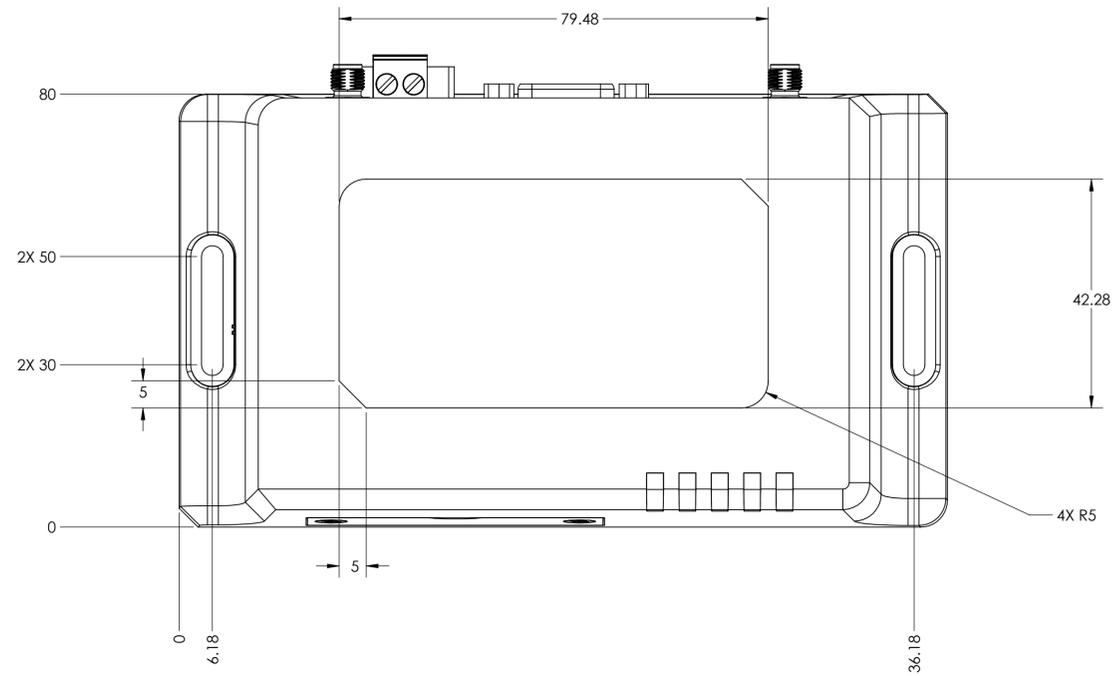
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11001 BREN ROAD EAST
MINNETONKA, MN 55343

TITLE
DWG, ASSY IX14

SIZE D	CAGE CODE 08TP3	DWG NO: 50001959-XX	REV E
SCALE NTS	DO NOT SCALE DRAWING		SHEET 2 OF 3

 ASSEMBLY NOTES

1. ASSEMBLY TORQUE VALUES:
 #4-40 SCREWS: 6.5_#_0.5 IN-LBS
 #6-32 SCREWS: 8.0_#_0.5 IN-LBS
 #8-32 SCREWS: 17.0_#_0.5 IN-LBS
 #10-32 SCREWS: 28.0_#_1.0 IN-LBS
 SMA NUTS (BRASS): 9.0_#_1.0 IN-LBS
 SMA NUTS (STAINLESS): 12-15 IN-LBS
 TNC NUTS (5/8"): 35-40 IN-LBS
 TNC NUTS (9/16"): 22-25 IN-LBS
 2. INSTALL PER MANUFACTURER'S RECOMMENDATIONS.
 2. SEE MANUFACTURING WORK INSTRUCTIONS FOR FURTHER DETAIL.
 3. BAG AND TAG LOOSE HARDWARE FOR SHIPPING OR STORAGE.
- (THREADED INSERTS)
4. INSTALL PER NASM 33537, USING PRIMER TT-P-1757, TYPE I, CLASS C OR N, COLOR OPTIONAL, OR MIL-PRF-23377, TYPE I OR II, CLASS C, ON DISSIMILAR METAL INTERFACE SURFACES ONLY.
 5. FINISHED PART SHALL BE ROHS COMPLIANT PER 2011/65/EU. THE FACILITY PERFORMING THIS WORK SHALL PERFORM TESTS OR OBTAIN TESTING INFORMATION THAT CONFIRMS COMPLIANCE. TEST RECORDS SHALL BE MADE AVAILABLE UPON REQUEST.



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SCALE NTS	DO NOT SCALE DRAWING		SHEET 3 OF 3