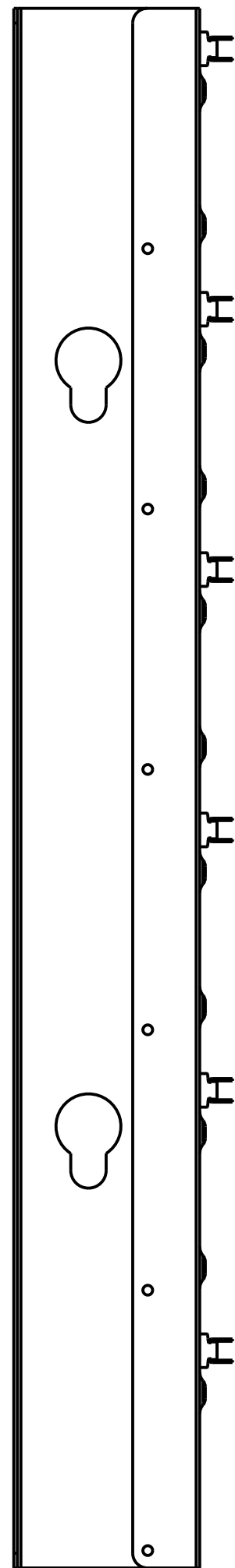
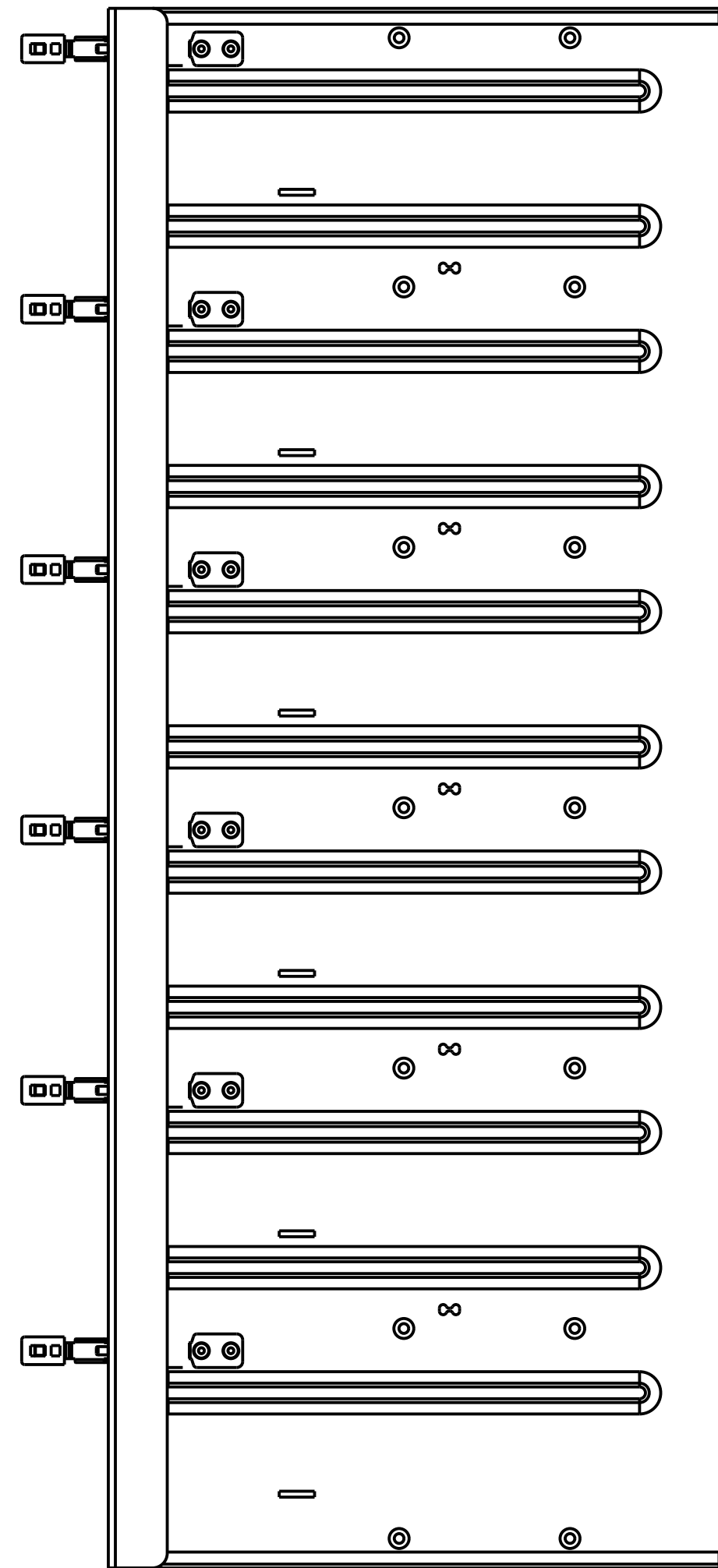
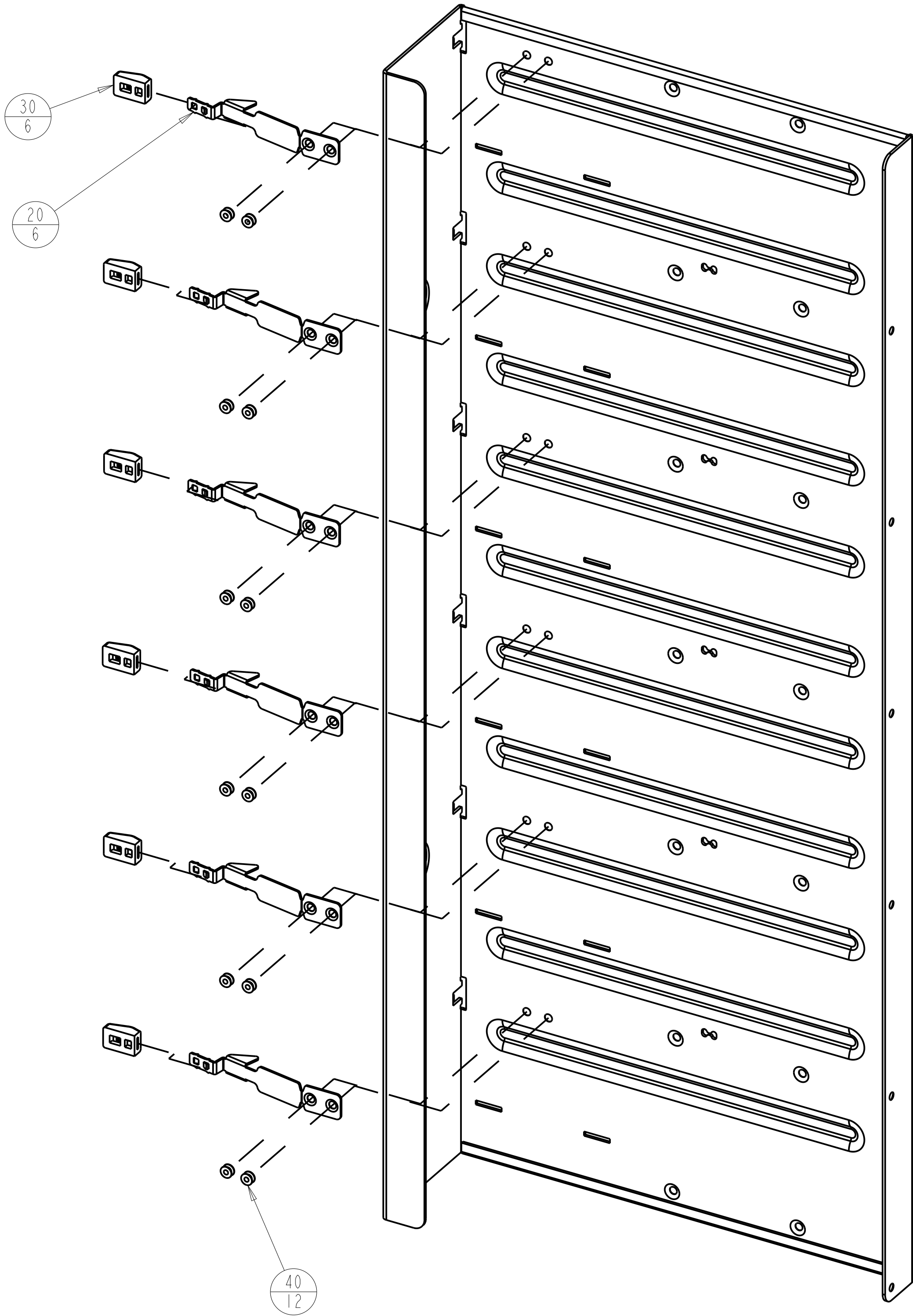
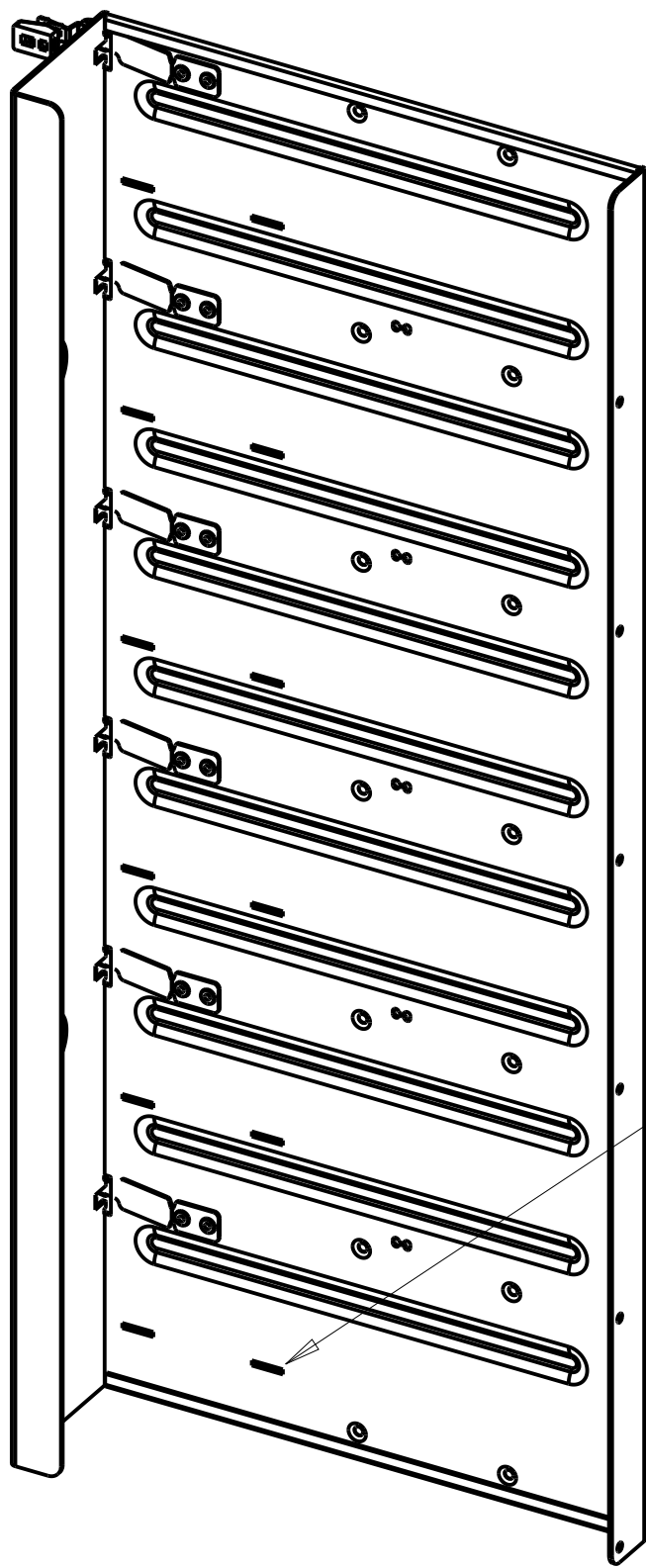


NOTES (UNLESS OTHERWISE SPECIFIED):

- DRAWINGS ARE FOR INSPECTION PURPOSES ONLY. ACTUAL PART SHALL CONFORM TO THE FOLLOWING 3D ELECTRONIC FILE: X890857-PDU-HOLDER-LFF-ASSY-REVC.ASM
- PART SHALL BE CLEAN AND FREE OF CONTAMINANTS, METAL FLAKES, AND OIL.
- ACCESSIBLE SHARP EDGES NOT PERMITTED. BURR SHALL BE TOWARDS SURFACE INDICATED. MAX BURR SIZE TO BE 10% OF MATERIAL THICKNESS AND IN COMPLIANCE WITH UL1439 STANDARD ON ALL ACCESSIBLE EDGES.
- REFERENCE THE LATEST REVISION OF THE FOLLOWING DOCUMENTS FOR INSPECTION AND ACCEPTANCE CRITERIA:
A. MICROSOFT METAL QUALIFICATION PROCESS (D00435)
B. MICROSOFT SHEET METAL PART WORKMANSHIP STANDARDS (D00034)
C. MICROSOFT RESTRICTED SUBSTANCES FOR HARDWARE PRODUCTS (H00594)
D. MICROSOFT RESTRICTED SUBSTANCES CONTROL SYSTEM (H00642)
E. MICROSOFT PAINTED PRODUCT WORKMANSHIP AND TEST SPECIFICATION (H00388)
F. MICROSOFT SYSTEM EMC DESIGN RULES AND GUIDELINES (D00755)
- FAI IQC/OQC FIXTURES REQUIRED AND MUST BE APPROVED BY MICROSOFT ENGINEERING. FREE STATE INSPECTION CONDITIONS REQUIRED FOR FAI. ON-GOING PROCESS CONTROL INSPECTIONS SHALL BE DONE IN FREE STATE.
- THE FOLLOWING INFORMATION SHALL BE MARKED IN A PERMANENT AND LEGIBLE MANNER, LOCATED WHERE INDICATED. CHARACTERS SHALL BE A MINIMUM OF 3.0mm TALL.
A. MICROSOFT ASSEMBLY NUMBER
B. CURRENT REVISION
- PARTS SHALL BE PACKAGED FOR SUPPLIER INTERNAL DISTRIBUTION.
- FLATNESS SHALL BE DEFINED AS 0.13MM/25.4MM X 25.4MM
- ASSEMBLY:
A. PSU CAGE LATCH (ITEM 20) (X6) SHALL BE FIXED TO PDU SUPPORT (ITEM 10) USING DUAL FLAT RIVET (ITEM 40) (X12).
B. PSU LATCH CAP (ITEM 30) (X6) SHALL BE ASSEMBLED TO PSU LATCH (ITEM 20) (X6).
ALL ASSEMBLY MUST MEET THE REQUIREMENTS IN NOTE 10 BELOW.
- METHOD OF JOINING ASSEMBLY AND QUANTITY OF JOINTS SHALL COMPLY WITH THE FOLLOWING SPECIFICATIONS:
A. MINIMUM PUSH OUT FORCE 68 KGF (150 LBS)
B. MINIMUM PULL OUT FORCE 63.5 KGF (140 LBS)
C. MINIMUM TORQUE OUT FORCE 20 KGF-CM (17 LBS-IN)
D. MINIMUM LATERAL LOAD FORCE 91 KG (200 LBS) (FORCE EXERTED ON TOP EDGE)
- TOLERANCE KEY FOR NON-DIMENSIONED ITEMS:
ASSEMBLED STANDOFFS: $\pm 1.0^{\circ}$



BOM SHOWN IS FOR REFERENCE ONLY. SEE TEAM CENTER FOR COMPLETE BOM.

40	RIVET, DUAL, FLAT	12	X881053
30	LATCH CAP, PSU	6	X885953
20	LATCH, PSU CAGE	6	X885952
10	PDU, SUPPORT LFF	1	X890859
ITEM	DESCRIPTION	QTY	DRAWING NUMBER

DIMENSIONS ARE IN MILLIMETERS		-	-
GENERAL TOLERANCES		SEE NOTES	SEE NOTES
STD. DIM	X X.X X.XX	DOCUMENT NO	GENERAL DESCRIPTION
ANGLE	SEE NOTES	APPLICABLE SPECIFICATION TABLE	
RADIUS		THIS DOCUMENT AND THE INFORMATION CONTAINED HEREIN ARE PROPRIETARY TO MICROSOFT CORPORATION AND SHALL NOT BE USED BY, OR DISCLOSED IN WHOLE OR IN PART TO ANYONE OUTSIDE OF MICROSOFT CORPORATION WITHOUT THE PRIOR WRITTEN PERMISSION OF MICROSOFT CORPORATION.	

DRAWN	DATE
PENSAR	11/11/13
CHECKED	DATE
ENGINEER	DATE
BRUBEN	11/11/13
ENGINEER	DATE
COG ENGR	DATE
MFG ENGR	DATE
TOOLING	DATE
QUALITY	DATE
RELEASED	DATE

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE: MILLIMETERS TOLERANCES ARE: SEE TOLERANCE BLOCK	
DO NOT SCALE DRAWING	
LEGEND: ★ = TOLERANCE CHAIN DIM □ = CRITICAL DIM ○ = TOOLING DIM △ = PROCESS DIM Ⓢ = DIMENSION ID	

Microsoft		MS PART NO: X890857-001 MS PDM VER: C.1	
TITLE: ASSY, PDU HOLDER, LFF		SIZE: D	THIRD ANGLE PROJECTION
DRAWING NO: X890857		REV: C	SHEET: 1 OF 1
SCALE: 0.750			