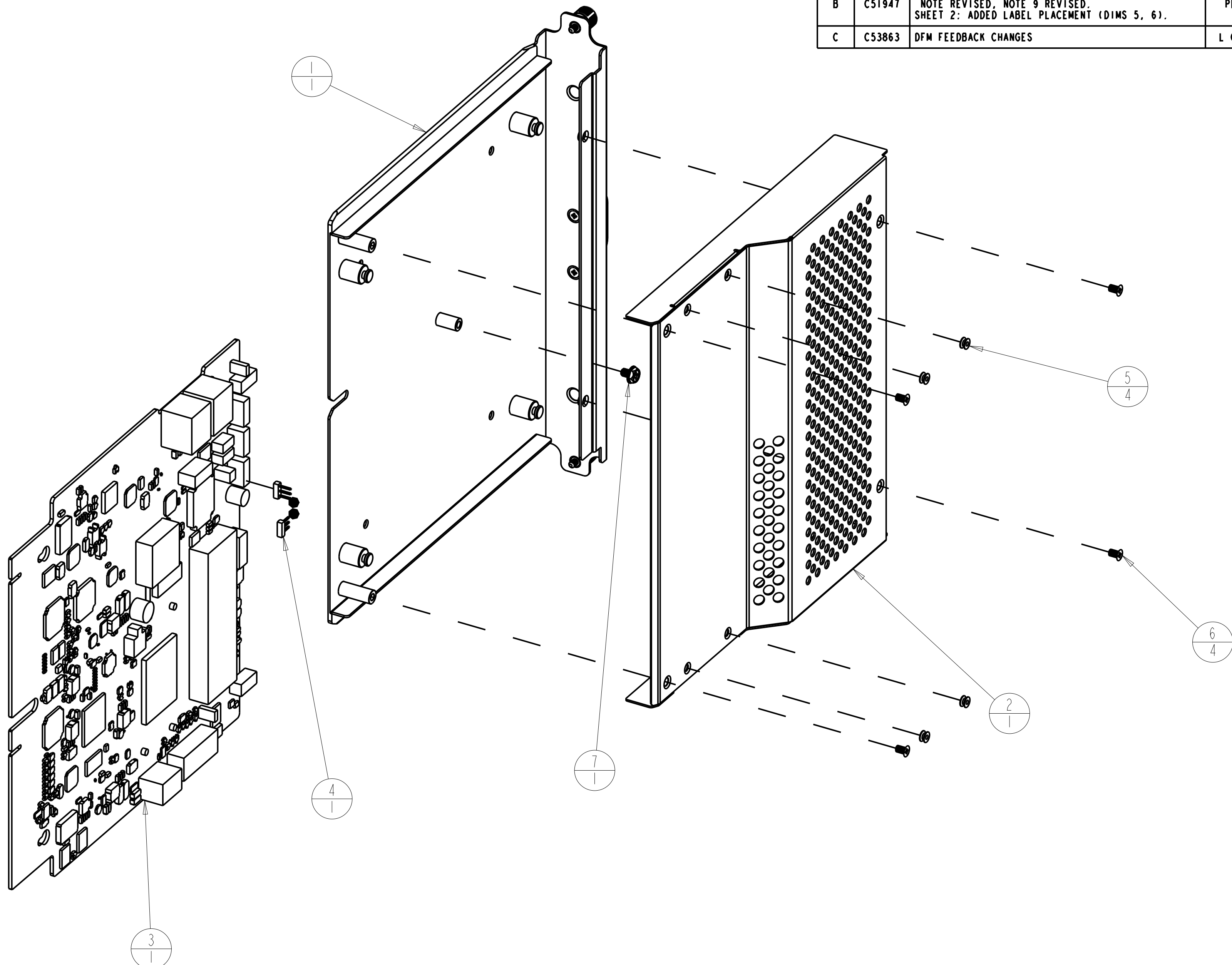
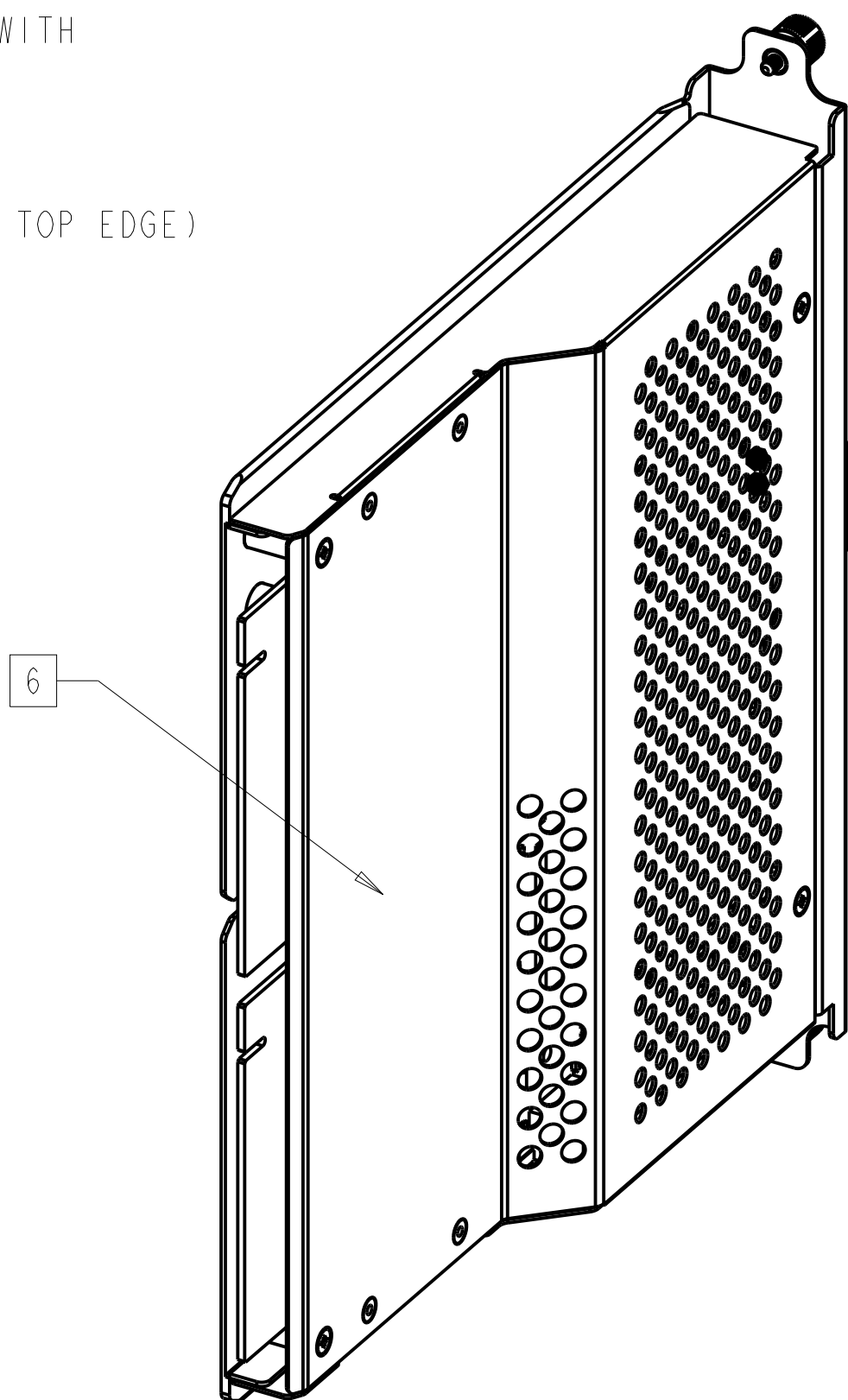




NOTES (UNLESS OTHERWISE SPECIFIED):

1. DRAWINGS ARE FOR INSPECTION PURPOSES ONLY. ACTUAL PART SHALL CONFORM TO THE FOLLOWING 3D ELECTRONIC FILE: X873061-CHASSIS-MANAGER-ASSY-REV-C.ASM
2. PART SHALL BE CLEAN AND FREE OF CONTAMINANTS, METAL FLAKES, AND OIL.
3. 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.
4. 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)
5. FAI IOC/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.
6. 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
7. PARTS SHALL BE PACKAGED FOR SUPPLIER INTERNAL DISTRIBUTION.
8. FLATNESS SHALL BE DEFINED AS 0.13mm/25.4mm X 25.4mm.
9. ASSEMBLY:
- A. SWITCH CABLE ASSY (ITEM 4) SHALL BE PLUGGED IN TO CHASSIS MANAGER PCBA (ITEM 3).
  - B. CHASSIS MANAGER PCBA (ITEM 3) SHALL BE SLOTTED INTO STANDOFFS ON TRAY ASSY (ITEM 1) AND SECURED WITH #6 X L3/16 SCREW (ITEM 7).
  - C. RIVET, DUAL, FLAT (ITEM 5) (X4) SHALL BE INSTALLED TO TOP COVER (ITEM 2).
  - D. TOP COVER (ITEM 2) SHALL BE FIXED TO TRAY ASSY (ITEM 1) USING 6/32 X L5/32 SCREW (ITEM 6) (X4).
  - E. REGULATORY LABEL (ITEM 8) SHALL BE ADHERED TO TOP COVER (ITEM 2).
10. SCREW TORQUE SPECIFICATION 5 KGF-CM. SCREW MUST BE FLUSH OR BELOW OUTER SURFACE.
11. 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 65 KG (143 LBS) (FORCE EXERTED ON TOP EDGE)
12. TOLERANCE KEY FOR NON-DIMENSIONED ITEMS:
- HOLE DIAMETER:  $\pm 0.08$
  - HOLE TO HOLE:  $\pm 0.13$
  - HOLE TO EDGE:  $\pm 0.13$
  - EDGE TO EDGE:  $\pm 0.13$
  - HOLE TO BEND:  $\pm 0.13$
  - EDGE TO BEND:  $\pm 0.21$
  - BEND TO BEND:  $\pm 0.26$
  - EMBOSS DEPTH:  $\pm 0.26$
  - ANGLE:  $\pm 1.0^\circ$
  - ASSEMBLED STANDOFFS:  $\pm 1.0^\circ$
- 6



REV	ECO NO	DESCRIPTION	DRAWN	APVD DATE
A	C50993	INITIAL RELEASE.	PENSAR	8/2/13
B	C51947	SHEET 1: ITEM 8 ADDED TO BOW TABLE, BOW NOTE REVISED. NOTE 9 REVISED. SHEET 2: ADDED LABEL PLACEMENT (DIMS 5, 6).	PENSAR	10/14/13
C	C53863	DFM FEEDBACK CHANGES	L CANNON	3/14/14

BOM SHOWN IS FOR REFERENCE ONLY, SEE TEAM CENTER FOR COMPLETE BOM			
7	SCREW, #6 X 3/16 L, 32 TPI (UNC), H-HEAD, NYLOK,STEEL	1	X882323
6	SCREW, 6/32 X 5/32 L, F-HEAD, NYLOK, STEEL	4	X879139
5	RIVET, DUAL, FLAT	4	X881053
4	ASSY, CABLE, SWITCH	1	X879141
3	PCBA, CHASSIS MANAGER	1	X873064
2	COVER, TOP, TRAY, BOARD, CM	1	X882363
1	TRAY, BOTTOM, SUB-ASSY	1	X873062
ITEM	DESCRIPTION	QTY	DRAWING NUMBER

DRAWN		DATE				MS PART NO: X873061-001	
PENSAR		8/2/13				MS PDM VER: C.1	
CHECKED		DATE		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE: MILLIMETERS TOLERANCES ARE: SEE TOLERANCE BLOCK		TITLE: <h1>CHASSIS MANAGER ASSY</h1>	
-		-					
ENGINEER		DATE		DO NOT SCALE DRAWING			
BRUBEN		8/2/13					
ENGINEER		DATE		LEGEND:		SIZE: <h1>D</h1>	
-		-					
COG ENGR		DATE		★ = TOLERANCE CHAIN DIM ■ = CRITICAL DIM ● = TOOLING DIM ▲ = PROCESS DIM ▴ = DIMENSION ID		THIRD ANGLE PROJECTION 	
-		-					
MFG ENGR		DATE		DRAWING NO: <h1>X873061</h1>		REV: <h1>C</h1>	
-		-					
TOOLING		DATE		SCALE: <h1>0.750</h1>		SHEET: <h1>1 OF 2</h1>	
-		-					
QUALITY		DATE					
-		-					
RELEASED		DATE					
-		-					

DIMENSIONS ARE IN MILLIMETERS			-	-
GENERAL TOLERANCES			SEE NOTES	SEE NOTES
	X	X.X	DOCUMENT NO	GENERAL DESCRIPTION
STD. DIM			APPLICABLE SPECIFICATION TABLE	
ANGLE	SEE NOTES		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.	
RADIUS				

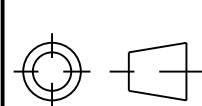
**Microsoft®**

MS PART NO: X873061-001  
MS PDM VER: C.1

LE: **CHASSIS MANAGER ASSY**

★ = TOLERANCE CHAIN DIM  
■ = CRITICAL DIM  
● = TOOLING DIM  
▲ = PROCESS DIM  
⑩ = DIMENSION ID

**SIZE:**



DRAWING NO:  
X87306

**REV:**

SCALE :  
0.750

SHEET:  
1 OF

8

7

6

5

4

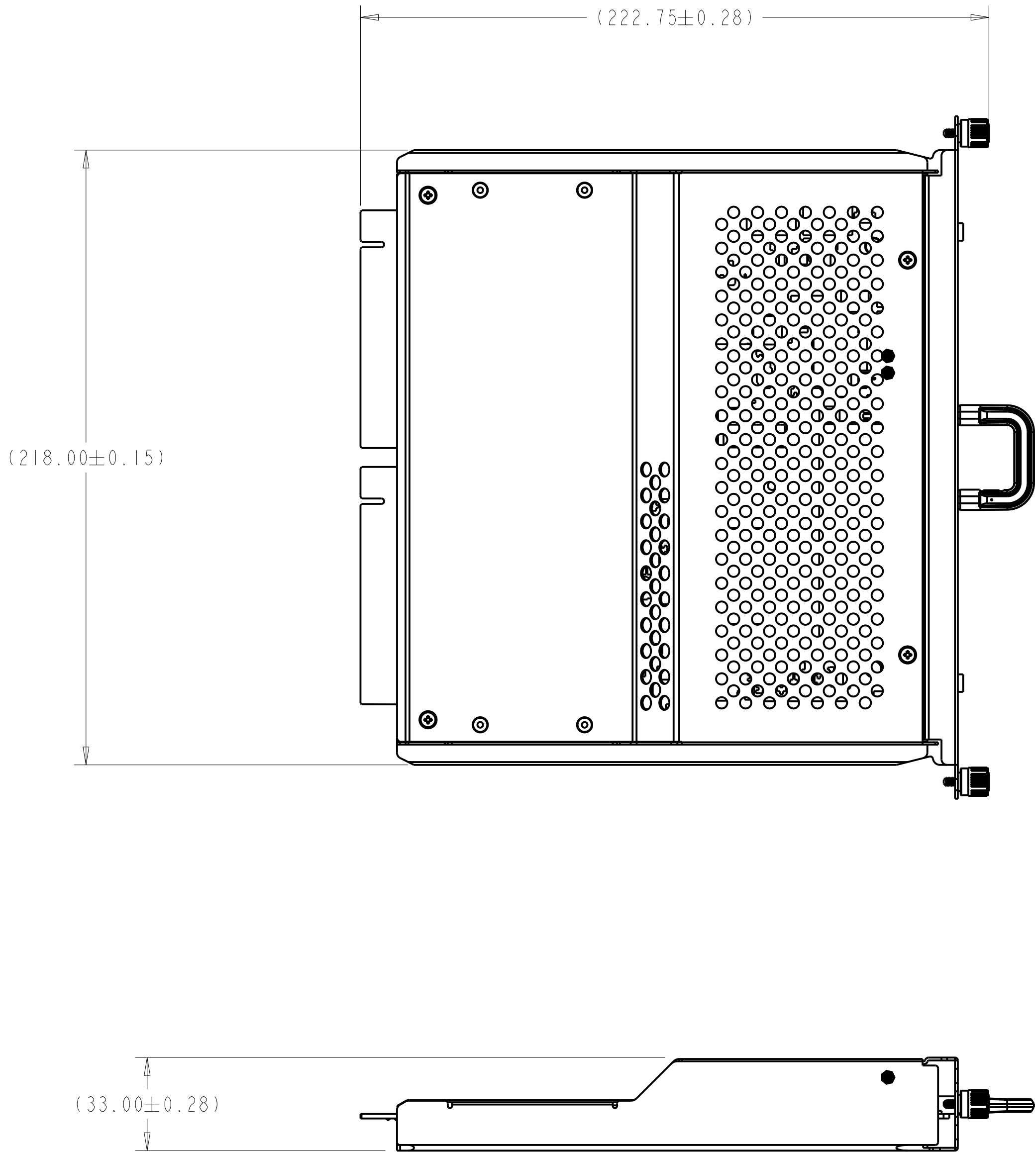
3

2

1

REVISIONS ECO NO. DESCRIPTION DRAWN APPROVED

SEE SHEET 1 FOR REVISIONS



Microsoft®

MS PART NO: X873061-001  
MS PDM VER: C.1

TITLE:  
**CHASSIS MANAGER ASSY**

SIZE: <b>D</b>	THIRD ANGLE PROJECTION	DRAWING NO: <b>X873061</b>	REV: <b>C</b>
SCALE: <b>0.750</b>			SHEET: <b>2 OF 2</b>