

| REV | ECO NO | DESCRIPTION | DRAWN | APVD DATE |
|-----|--------|---|-------------|-----------|
| A | - | INITIAL RELEASE | PENSAR | 7/5/13 |
| B | - | DFW FEEDBACK CHGS. DELETE FLATNESS SPEC | MG PETERSON | 28FEB2014 |
| C | - | UPDATED NOTE 1, ADDED NOTE 19, MOD TOLS 1,3 | N. TOLCHIN | 5/14/14 |

NOTES UNLESS OTHERWISE SPECIFIED:

1. INTERPRET DRAWING PER ASME Y14.100. DRAWING IS FOR INSPECTION PURPOSES ONLY.
ACTUAL PART GEOMETRY IS CONTROLLED BY 3D CAD DATABASE.
2. MATERIAL: HOT-DIPPED-GALV-STEEL-SGCC
THICKNESS: 1.00±0.1mm
HARDNESS: 50-60 ROCKWELL B
SPECIFICATION: JIS G3302
PLATING/COATING: ZCS(A)X, ZINC COATING MASS: Z08, MINIMIZED SPANGLE,
SKIN PASSED, CHROMATE (ANTI-FINGER PRINT) TREATED, UNOILED
MATERIAL SHALL CONTAIN 0.02% MIN TO 0.15% MAX CARBON.
3. PART WEIGHT: (350.275 GRAMS), (12.358 OZ)
4. PART SHALL BE CLEAN AND FREE OF CONTAMINANTS, METAL FLAKES, AND OIL.

18. AS DIMENSIONED OR Ø3.60. STANDARD TOLERANCE APPLIES.
19. DIMENSIONS AND TOLERANCES NOT MARKED CRITICAL, TOOLING OR PROCESS SHALL BE CONSIDERED REFERENCE DIMENSIONS. ONLY CRITICAL, TOOLING AND PROCESS DIMENSIONS ARE REQUIRED TO BE COMPLIANT FOR FAI. ADDITIONAL MEASUREMENTS REQUIRED AT ENGINEERING REQUEST.

- 5 AS DIMENSIONED OR Ø3.60. STANDARD TOLERANCE APPLIES.
- 6 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.
7. 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)
 - G. MICROSOFT METAL STAMPING DIE MINIMUM TOOL GUIDELINES (D02520)
 - H. MICROSOFT METAL STAMPING DIE MAINTENANCE GUIDELINE (D02522)

- 8 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 PART NUMBER
 - B. CURRENT REVISION
 - C. MANUFACTURING DATE CODE (DD MMM YYYY)
 - D. SUPPLIER ID (SUPPLIER ID LOCATION)

9. VENDOR SHALL SUPPLY A CERTIFICATE OF REGULATORY COMPLIANCE WITH EACH SHIPMENT THAT INCLUDES THE FOLLOWING INFORMATION:
- A. NAME OF THE SUPPLIER
 - B. PRODUCTION DATE
 - C. MATERIAL MANUFACTURER'S NAME OR TRADE NAME AND MATERIAL DESIGNATION
 - D. NAME OF THE COMPANY BUYING THE PRODUCT
 - E. PART NUMBER AND REVISION
 - F. PURCHASE ORDER NUMBER
 - G. SHIPMENT DATE
 - H. QUANTITY OF PARTS SHIPPED
 - I. MANUFACTURER REPRESENTATIVE'S NAME, SIGNATURE OR FUNCTION TO ATTEST TO THE ACCURACY OF THE INFORMATION.

10. PART TOOLING IS THE PROPERTY OF MICROSOFT AND SHALL BE PERMANENTLY MARKED WITH "PROPERTY OF MICROSOFT", THE PART NUMBER, AND THE TOOL ASSET NUMBER.
11. 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.

12. PARTS SHALL BE PACKAGED FOR SUPPLIER INTERNAL DISTRIBUTION.

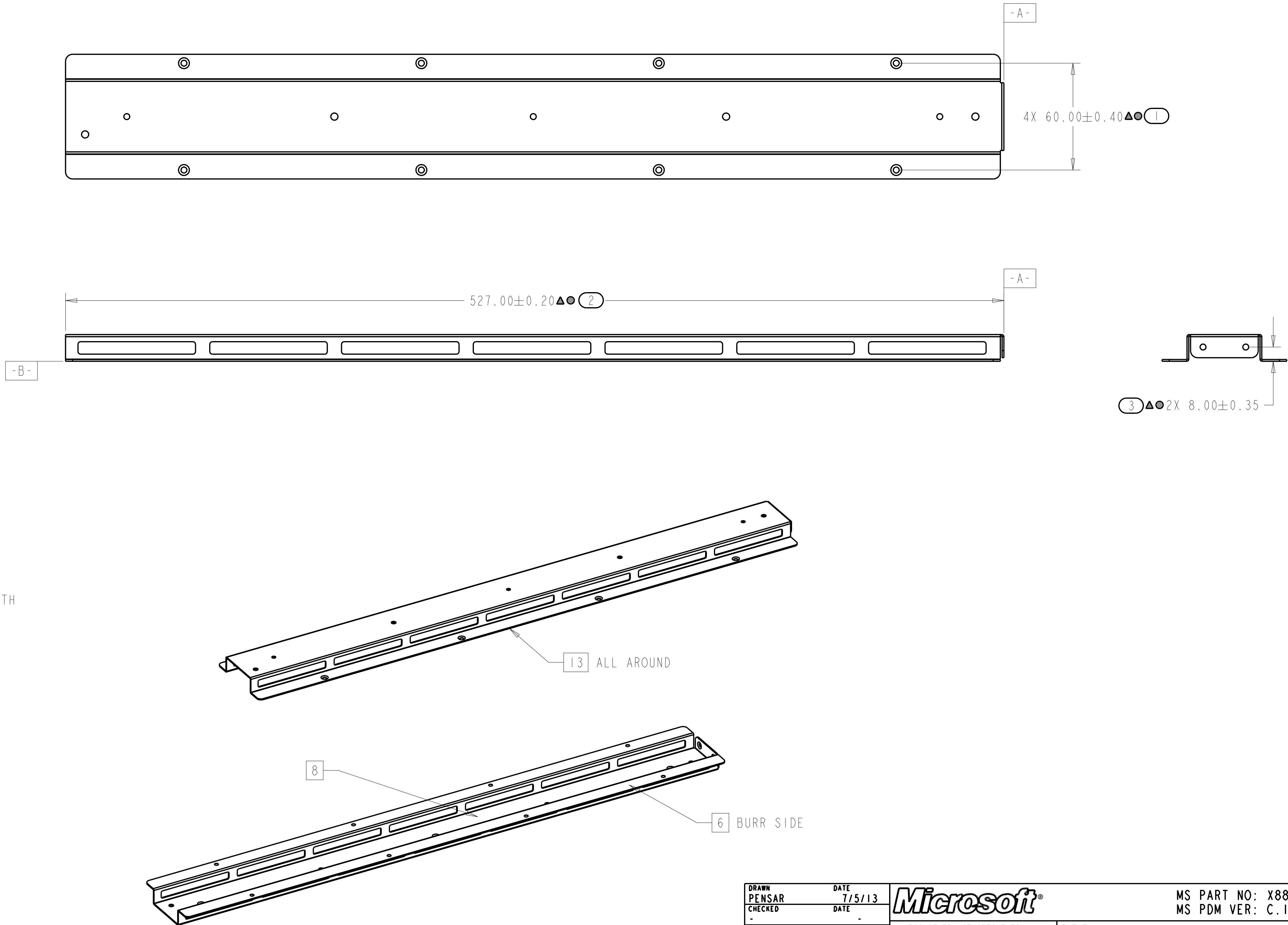
- 13 COIN EDGES WHERE INDICATED TO REMOVE SHARP EDGES. BREAKS IN COINING FOR CARRYING WEBS REQUIRE APPROVAL OF MICROSOFT ENGINEERING.

14. BEND RADIUS AND RELIEFS SHALL COMPLY TO ELECTRONIC DATABASE.

15. CARRY POINTS SHALL BE RECESSED BY 0.25mm MAX. ANY DEVIATION REQUIRES APPROVAL BY MICROSOFT ENGINEERING.



16. TOLERANCE KEY FOR NON-DIMENSIONED ITEMS:
HOLE DIAMETER: PUNCH DIRECTION ± 0.08
CHAMFERED HOLE DIAMETER: BURR SIDE ± 0.15
HOLE TO HOLE: ± 0.13
HOLE TO EDGE: ± 0.13
EDGE TO EDGE: ± 0.13
HOLE TO BEND: ± 0.13
EDGE TO BEND: ± 0.21
BEND TO BEND: ± 0.26
EMBOSS DEPTH: ± 0.26
ANGLE: $\pm 1.0^\circ$

17. VENDOR MODIFICATION OF HOLE FEATURE SIZING AND TOLERANCES FOR PRESS-IN HARDWARE IS ALLOWED FOR VENDOR SPECIFIC HARDWARE PER MICROSOFT APPROVAL.



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

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|----------|--------|
| DRAWN | DATE |
| PENSAR | 7/5/13 |
| CHECKED | DATE |
| - | - |
| ENGINEER | DATE |
| BRUBEN | 7/5/13 |
| ENGINEER | DATE |
| - | - |
| COG ENGR | DATE |
| - | - |
| MFG ENGR | DATE |
| - | - |
| TOOLING | DATE |
| - | - |
| QUALITY | DATE |
| - | - |
| RELEASED | DATE |
| - | - |

| | | | |
|--|--|--|--|
|  | | MS PART NO: X881044-001 MS PDM VER: C.1 | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE: MILLIMETERS TOLERANCES ARE: SEE TOLERANCE BLOCK | | TITLE: <h1>SIDE WALL BEAM</h1> | |
| DO NOT SCALE DRAWING | | MS PART NO: X881044-001 MS PDM VER: C.1 | |
| LEGEND: <ul style="list-style-type: none"> ★ = TOLERANCE CHAIN DIM ■ = CRITICAL DIM ● = TOOLING DIM ⬢ = PROCESS DIM Ⓢ = DIMENSION ID | | SIZE: <h1>D</h1> | THIRD ANGLE PROJECTION  |
| | | DRAWING NO: <h1>X881044</h1> | REV: <h1>C</h1> |
| | | SCALE: <h1>0.750</h1> | SHEET: <h1>I OF 4</h1> |

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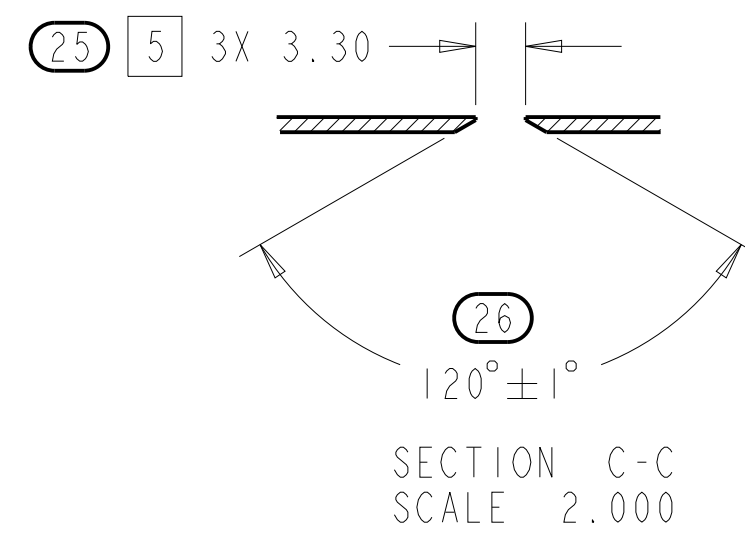
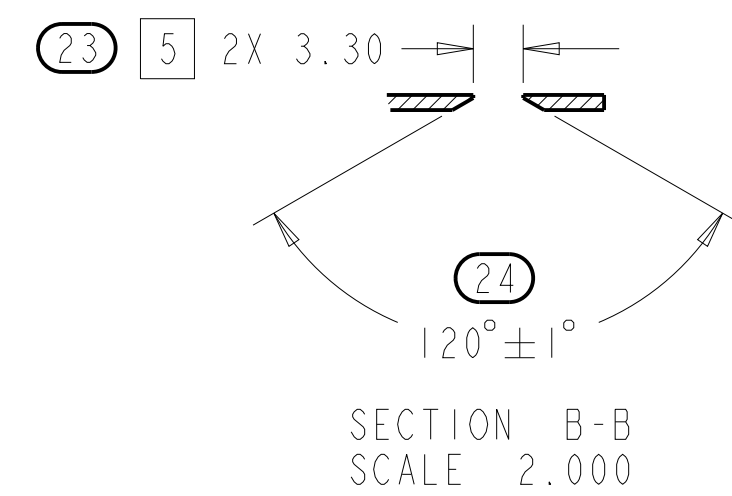
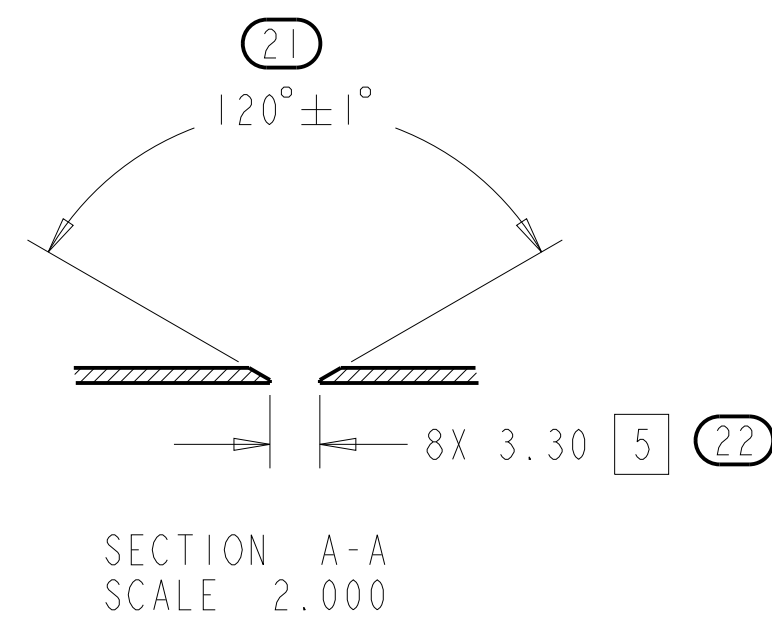
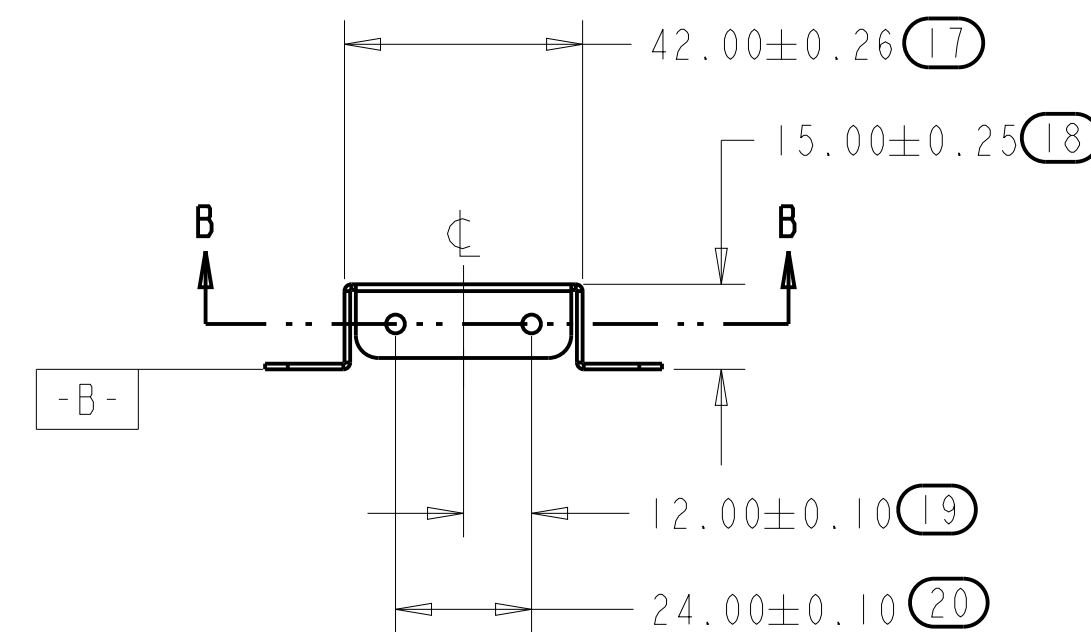
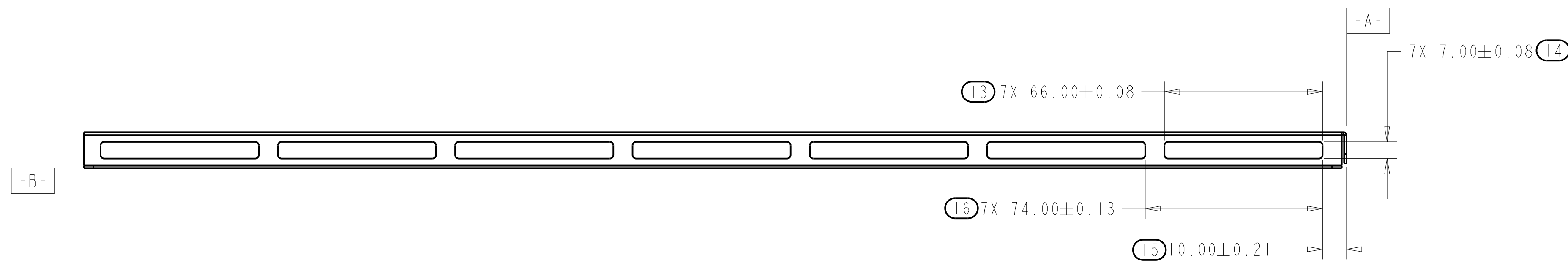
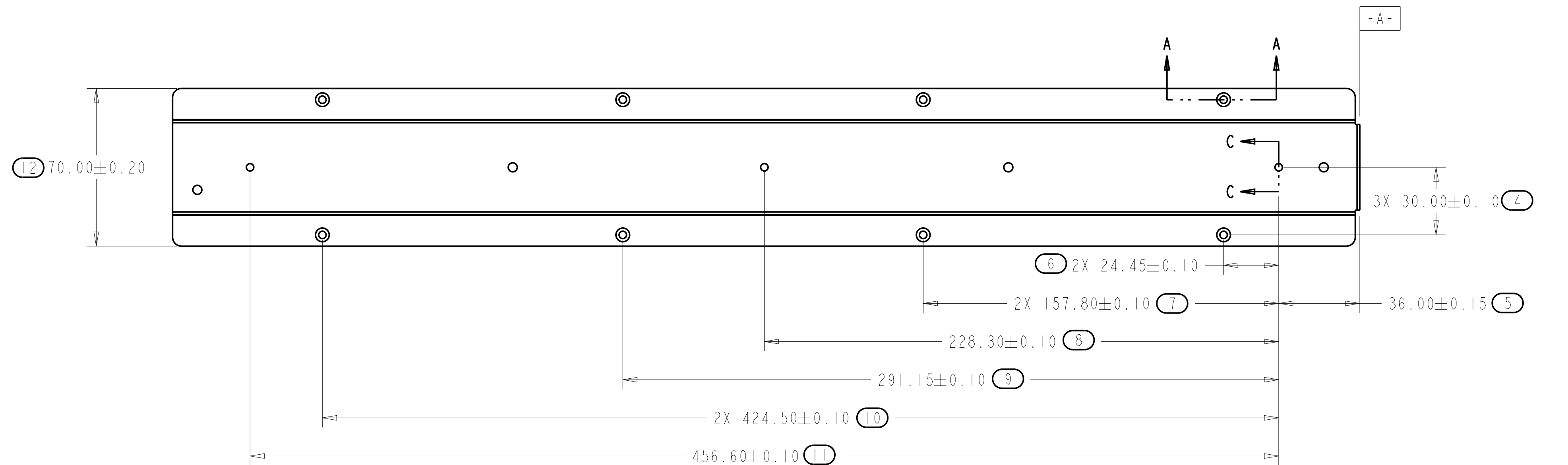
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REVISIONS ECO NO. DESCRIPTION DRAWN APPROVED

SEE SHEET 1 FOR REVISIONS



Microsoft®

MS PART NO: X881044-001
MS PDM VER: C.1TITLE:
SIDE WALL BEAM

| | | | |
|-----------------|---------------------------|------------------------|------------------|
| SIZE: D | THIRD ANGLE PROJECTION | DRAWING NO: X881044 | REV: C |
| SCALE: 0.750 | | | SHEET: 2 OF 4 |

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REVISIONS

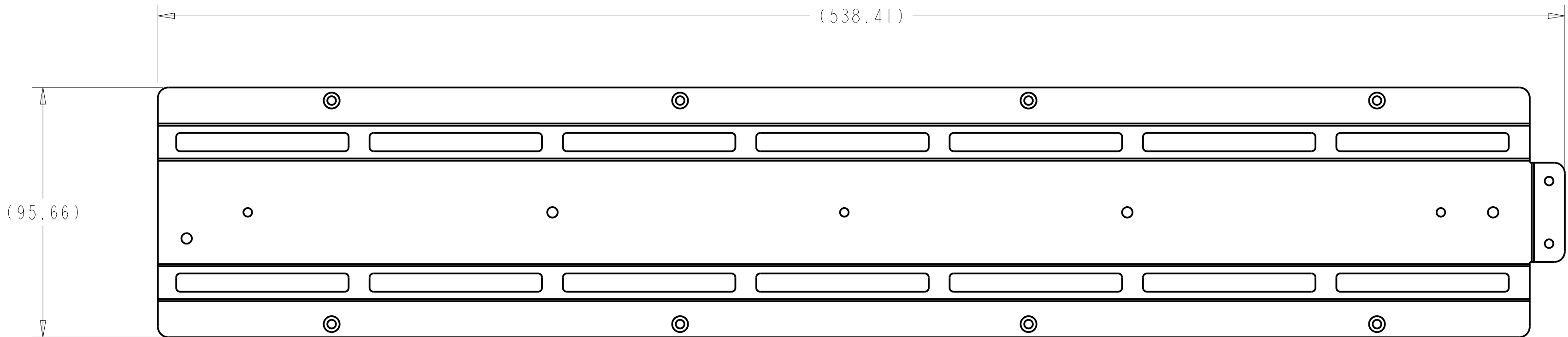
ECO NO.

DESCRIPTION

DRAWN

APPROVED

SEE SHEET 1 FOR REVISIONS



FLAT PATTERN

Microsoft®

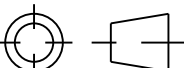
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MS PDM VER: C.1

TITLE:
SIDE WALL BEAM

SIZE:

D

THIRD ANGLE
PROJECTION



DRAWING NO:

X881044

REV:

C

SCALE:
0.750

SHEET:

3 OF 4

