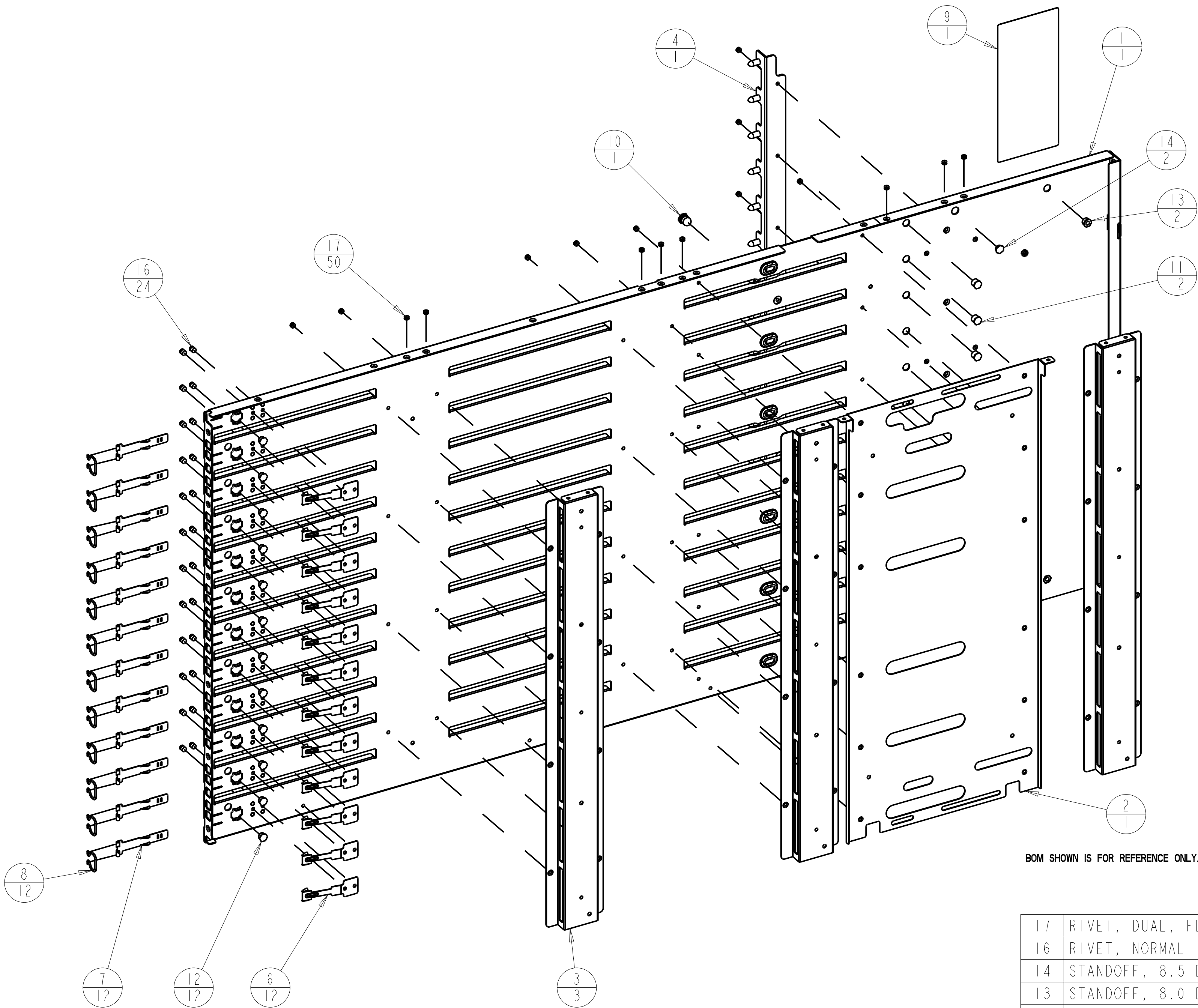


NOTES (UNLESS OTHERWISE SPECIFIED):

- DRAWINGS ARE FOR INSPECTION PURPOSES ONLY. ACTUAL PART SHALL CONFORM TO THE FOLLOWING 3D ELECTRONIC FILE: X873046-SIDE-WALL-R-ASSY-REV.C.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 IOC/OOC 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.
- SCREW TORQUE SPECIFICATION 5 KGF-CM. SCREW MUST BE FLUSH OR BELOW OUTER SURFACE.
- 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)
- TOLERANCE KEY FOR NON-DIMENSIONED ITEMS:
ASSEMBLED STANDOFFS: ±1.0°



BOM SHOWN IS FOR REFERENCE ONLY.

17	RIVET, DUAL, FLAT	50	X881053
16	RIVET, NORMAL	24	X880935
14	STANDOFF, 8.5 DIA x 3.9 L, STEEL, FLUSH MOUNT, SHOULDER	2	X881041
13	STANDOFF, 8.0 DIA x 5.0 L, STEEL, FLUSH MOUNT, M5	2	X881042
12	STANDOFF, 8.0 DIA x 4.9 L, STEEL, FLUSH MOUNT, SHOULDER	12	X881052
11	PIN, STOP, 8.0 DIA x 7.0 L, STEEL, FLUSH MOUNT	12	X881040
10	PIN, GUIDE, SHOULDER, BULLET NOSE, 9.0 DIA x 13.0 L, STEEL, FLUSH MOUNT	1	X881046
9	LABEL, TRAY NUMBER	1	X879152
8	C-RING, LATCH, SIDE WALL	12	X881047
7	SLIDE, LATCH, SIDE WALL	12	X881048
6	LATCH, SIDE WALL	12	X881050
4	BRKT, SUPP, SIDE WALL, R, ASSY	1	X881055
3	SIDE WALL BEAM	3	X881044
2	BRACKET, REINFORCE, SIDE WALL	1	X881051
1	BRACKET, SIDE WALL RIGHT	1	X881045
ITEM	DESCRIPTION	QTY	DRAWING NUMBER

<div>DIMENSIONS ARE IN MILLIMETERS</div> <div>GENERAL TOLERANCES</div> <table><tr><td></td><td>X</td><td>X.X</td><td>X.XX</td></tr></table> <div>STD. DIM</div> <div>ANGLE</div> <div>RADIUS</div>					X	X.X	X.XX	<div>DRAWN PENSAR CHECKED -</div> <div>ENGINEER BRUBEN ENGINEER -</div> <div>COG ENGR -</div> <div>MFG ENGR -</div> <div>TOOLING -</div> <div>QUALITY -</div> <div>RELEASED -</div>				<div>DATE 7/12/13</div> <div>DATE 7/12/13</div> <div>DATE -</div> <div>DATE -</div> <div>DATE -</div> <div>DATE -</div> <div>DATE -</div> <div>DATE -</div>				<div>Microsoft®</div> <div>MS PART NO: X873046-001 MS PDM VER: C.1</div>			
					X	X.X	X.XX												
<div>SEE NOTES</div> <div>SEE NOTES</div> <div>DOCUMENT NO</div> <div>GENERAL DESCRIPTION</div> <div>APPLICABLE SPECIFICATION TABLE</div> <div>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.</div>				<div>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE: MILLIMETERS TOLERANCES ARE: SEE TOLERANCE BLOCK</div> <div>DO NOT SCALE DRAWING</div>				<div>TITLE: SIDE WALL R ASSY</div>											
<div>LEGEND:</div> <div>★ = TOLERANCE CHAIN DIM ■ = CRITICAL DIM ● = TOOLING DIM ▲ = PROCESS DIM Ⓢ = DIMENSION ID</div>				<div>SIZE: D</div> <div>THIRD ANGLE PROJECTION </div>				<div>DRAWING NO: X873046</div> <div>SCALE: 0.330</div>				<div>REV: C</div> <div>SHEET: 1 OF 2</div>							

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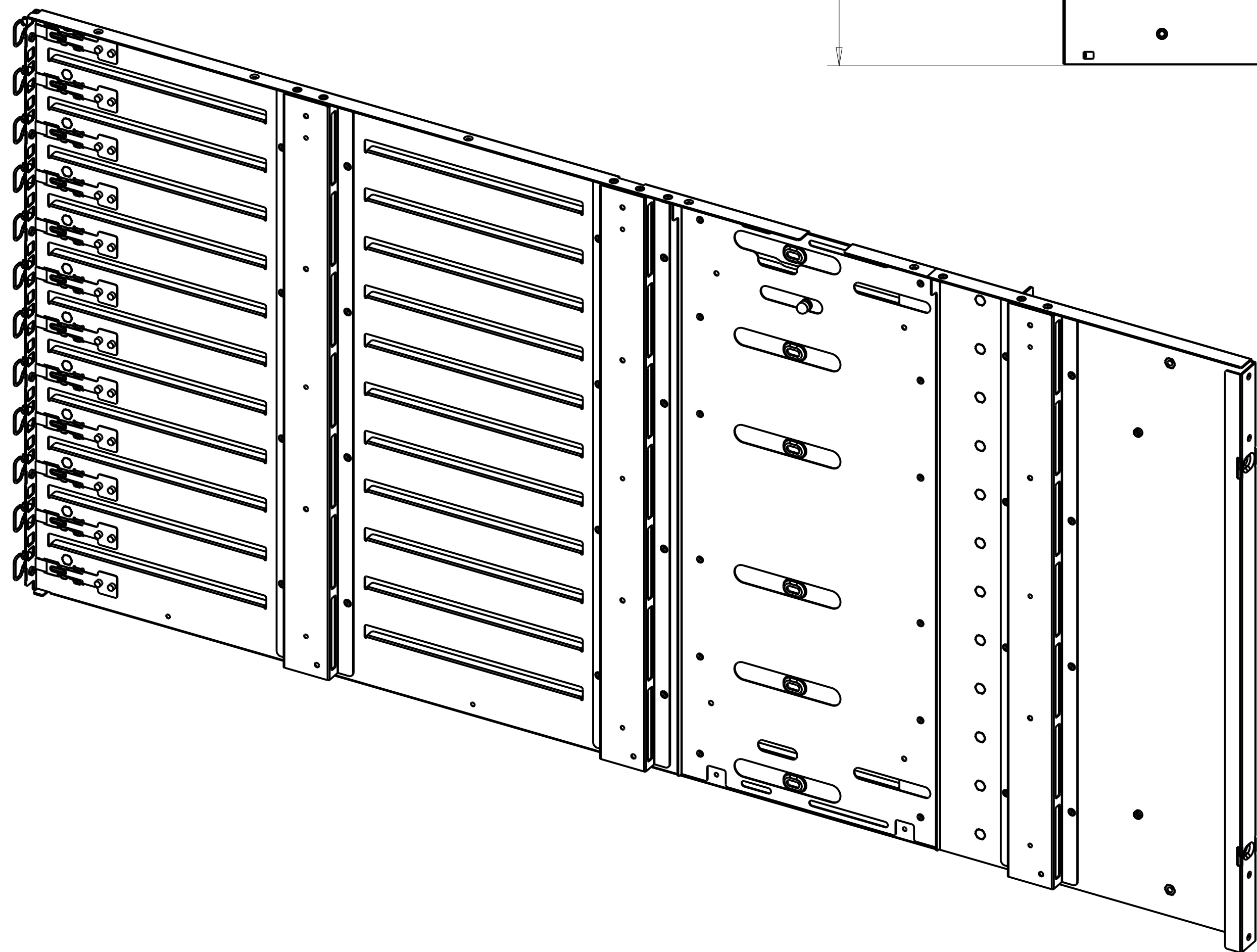
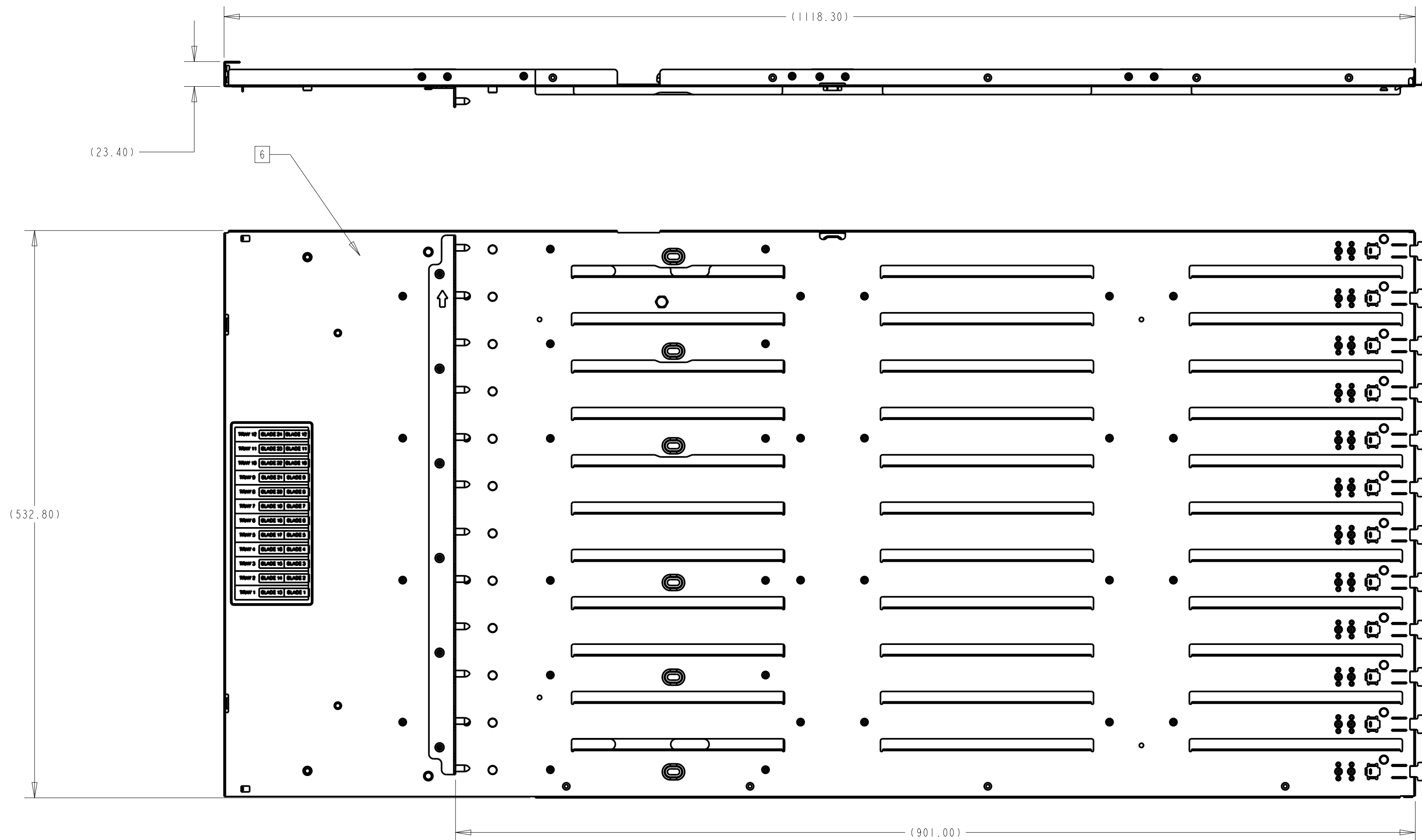
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REVISIONS ECO NO. DESCRIPTION DRAWN APPROVED

SEE SHEET 1 FOR REVISIONS



Microsoft®

MS PART NO: X873046-001
MS PDM VER: C.1TITLE:
SIDE WALL R ASSY

SIZE: D	THIRD ANGLE PROJECTION	DRAWING NO: X873046	REV: C
SCALE: 0.330			SHEET: 2 OF 2