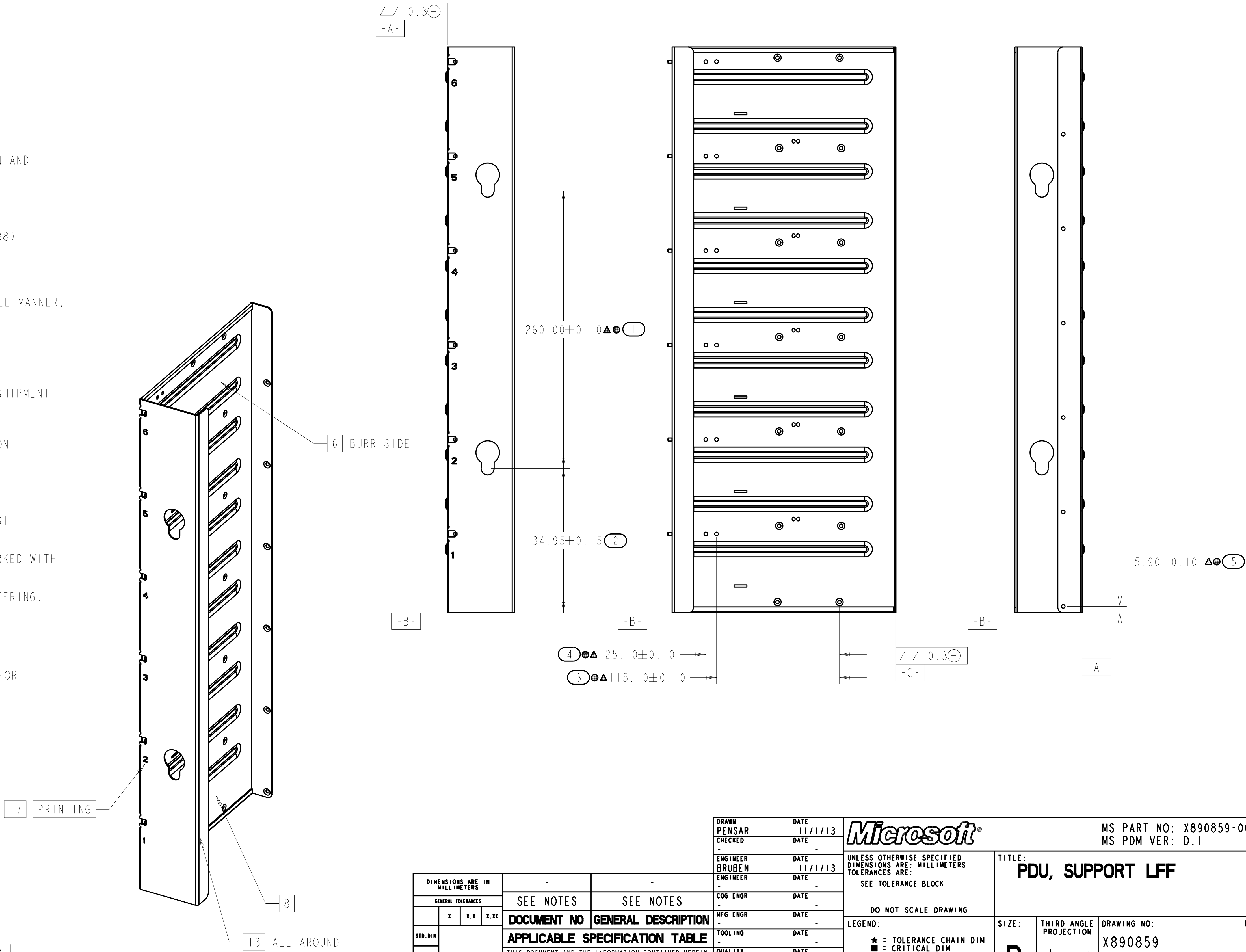


NOTES UNLESS OTHERWISE SPECIFIED:

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: 1.20±0.08mm
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: (1563.522 GRAMS), (55.161 OZ)
4. PART SHALL BE CLEAN AND FREE OF CONTAMINANTS, METAL FLAKES, AND OIL.
- 5 AS DIMENSIONED OR 3.60. 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)
- 49:8] 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 RADII AND RELIEFS SHALL COMPLY TO ELECTRONIC DATABASE.
15. CARRY POINTS SHALL BE RECESSED BY 0.25mm MAX. TOOLING HOLES OR OTHER DEVIATIONS REQUIRE 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: ±1.0°

17 MARK TEXT IN DATABASE IN PERMANENT AND LEGIBLE MANNER LOCATED WHERE INDICATED IN DATABASE. CHARACTERS SHALL BE A MINIMUM OF 3.0MM TALL.

18. VENDOR MODIFICATION OF HOLE FEATURE SIZING AND TOLERANCES FOR PRESS-IN HARDWARE IS ALLOWED FOR VENDOR SPECIFIC HARDWARE PER MICROSOFT APPROVAL.
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 MEAUREMENTS REQUIRED AT ENGINEERING REQUEST.

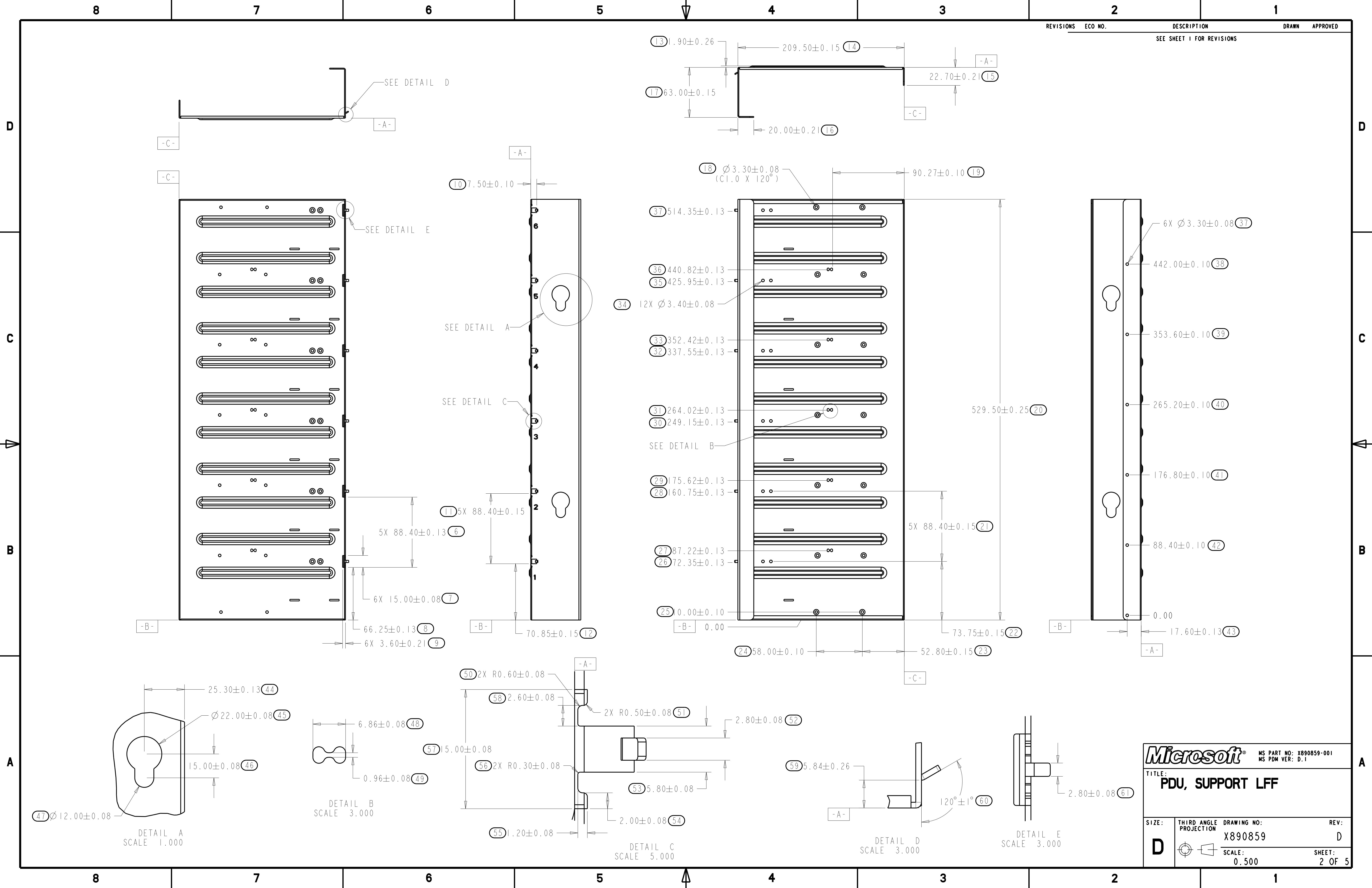


DIMENSIONS ARE IN MILLIMETERS			-	-
GENERAL TOLERANCES			SEE NOTES	SEE NOTES
STD. DIM	X	X.X	DOCUMENT NO	GENERAL DESCRIPTION
ANGLE	SEE NOTES		APPLICABLE SPECIFICATION TABLE	
RADIUS			THIS DOCUMENT AND THE INFORMATION CONTAINED HEREIN ARE PROPRIETARY TO MICROSOFT CORPORATION AND SHALL NOT BE USED BY, OR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

DRAWN PENSAR	DATE 11/1/13
CHECKED -	DATE -
ENGINEER BRUBEN	DATE 11/1/13
ENGINEER -	DATE -
COG ENGR -	DATE -
MFG ENGR -	DATE -
TOOLING -	DATE -
QUALITY -	DATE -
RELEASED -	DATE -

Microsoft	
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	

MS PART NO: X890859-001 MS PDM VER: D.1		TITLE: PDU, SUPPORT LFF	
SIZE: D	THIRD ANGLE PROJECTION 	DRAWING NO: X890859	REV: D
SCALE: 0.500		SHEET: 1 OF 5	



Microsoft		MS PART NO: X890859-001 MS PDM VER: D.1	
TITLE: PDU, SUPPORT LFF			
SIZE: D	THIRD ANGLE PROJECTION	DRAWING NO: X890859	REV: D
SCALE: 0.500		SHEET: 2 OF 5	

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REVISIONS ECO NO. DESCRIPTION DRAWN APPROVED

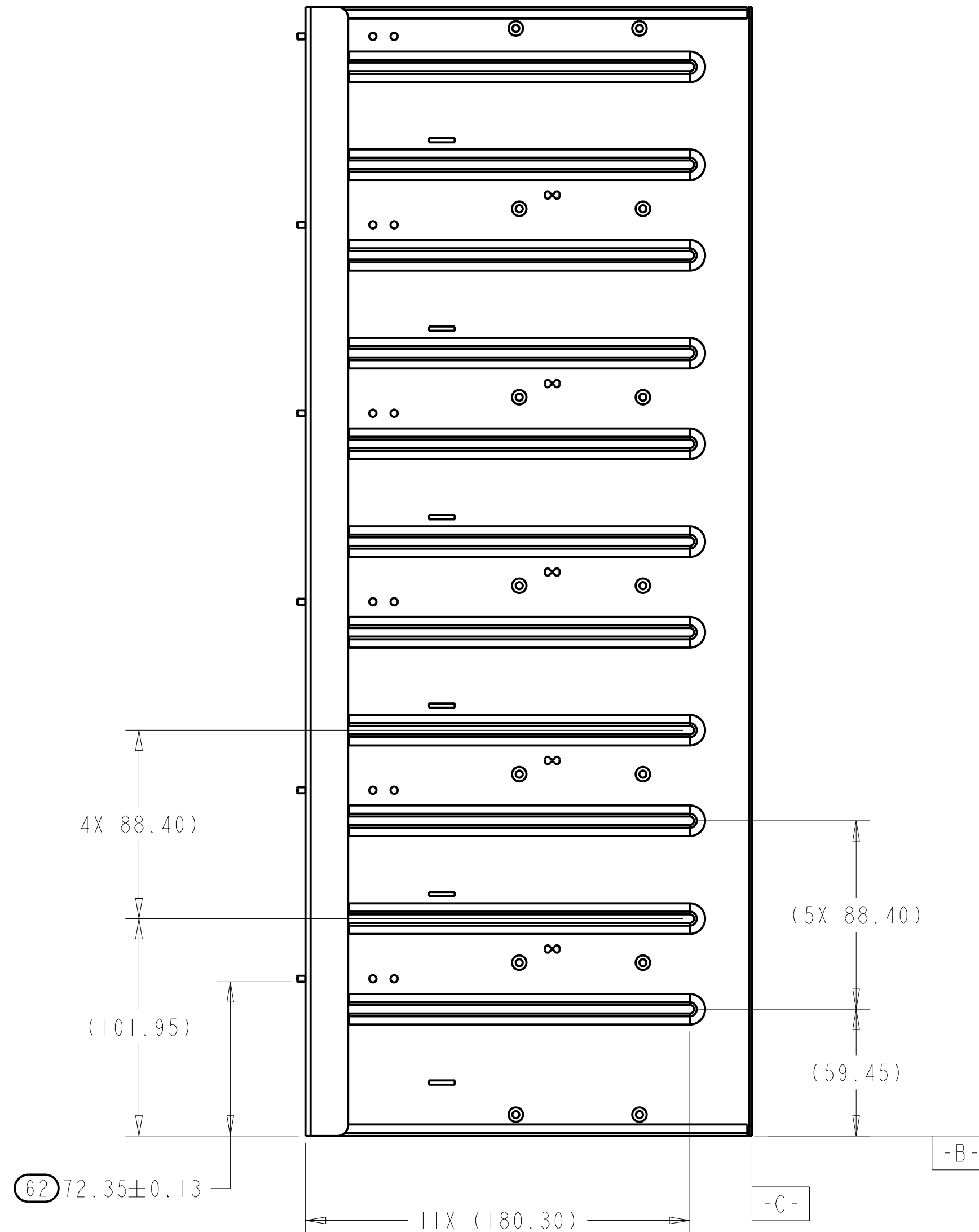
SEE SHEET 1 FOR REVISIONS



SECTION B-B

SEE DETAIL F

(63) 120° ± 1°

DETAIL F
SCALE 5.000**Microsoft**MS PART NO: X890859-001
MS PDM VER: D.1TITLE:
PDU, SUPPORT LFF

SIZE: D	THIRD ANGLE PROJECTION 	DRAWING NO: X890859	REV: D
SCALE: 0.500			SHEET: 3 OF 5

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REVISIONS

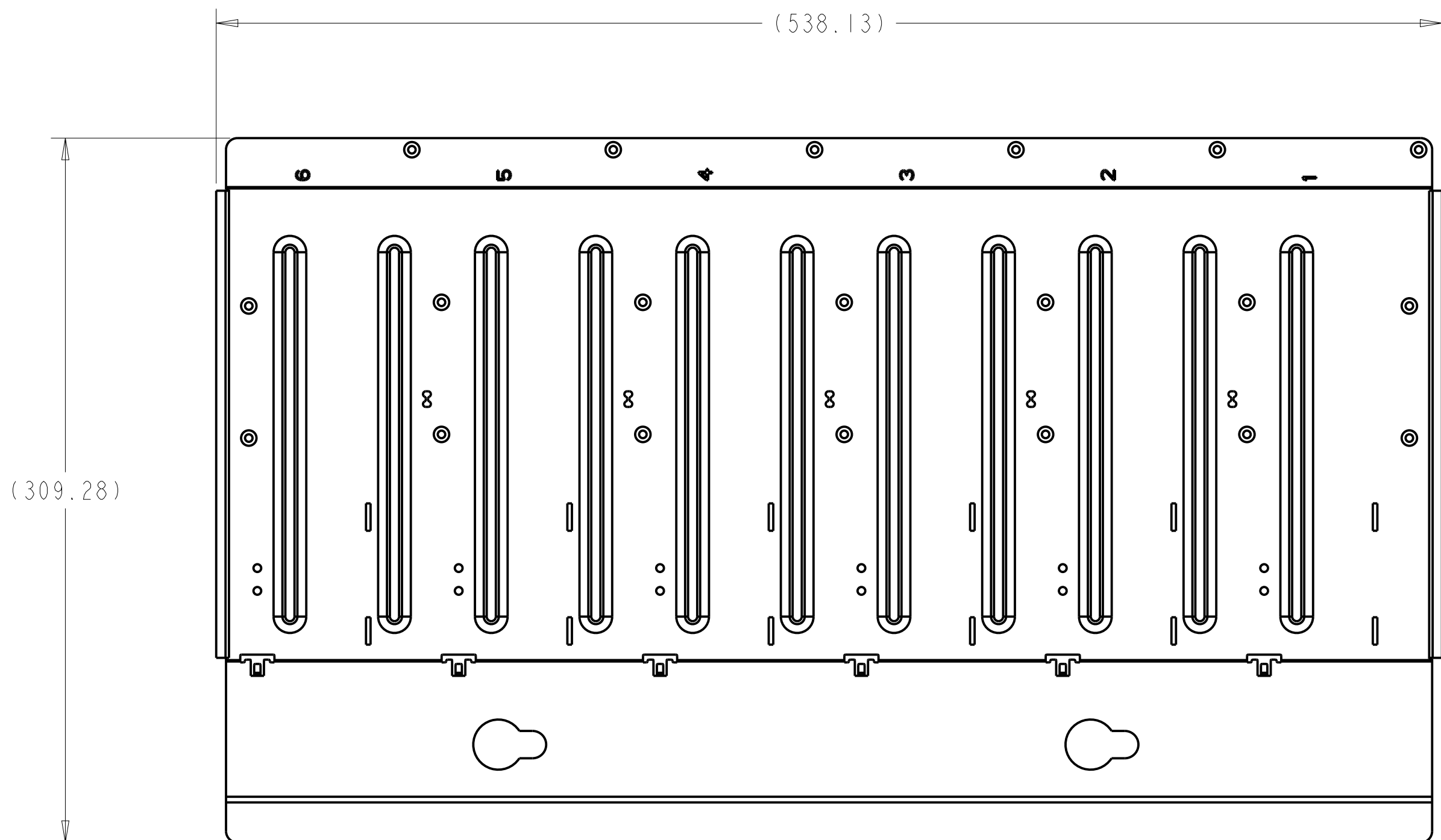
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DESCRIPTION

DRAWN

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SEE SHEET 1 FOR REVISIONS



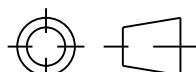
FLAT PATTERN

MicrosoftMS PART NO: X890859-001
MS PDM VER: D.1

TITLE:

PDU, SUPPORT LFF

SIZE:

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PROJECTION

DRAWING NO:

X890859SCALE:
0.500

REV:

D

SHEET:

4 OF 5

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REVISIONS

ECO NO.

DESCRIPTION

DRAWN

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SEE SHEET 1 FOR REVISIONS

DIM ID	SHEET	ZONE	DIM TYPE
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2	1	B3	
3	1	B4	▲●
4	1	B4	▲●
5	1	B1	▲●
6	2	B6	
7	2	B6	
8	2	B6	
9	2	B6	
10	2	D6	
11	2	B6	
12	2	B5	
13	2	D5	
14	2	D4	
15	2	D3	
16	2	D4	
17	2	D5	
18	2	D4	
19	2	D3	
20	2	C2	
21	2	B3	
22	2	B3	
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33	2	C5	
34	2	C5	
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36	2	C5	
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38	2	D1	
39	2	C1	
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42	2	B1	
43	2	B1	
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47	2	A8	
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54	2	A5	
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DIM ID	SHEET	ZONE	DIM TYPE
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Microsoft®

MS PART NO: X890859-001

MS PDM VER: D.1

TITLE:

PDU, SUPPORT LFF

SIZE:

D

THIRD ANGLE PROJECTION

DRAWING NO:

X890859

REV:

D

SCALE:

0.500

SHEET:

5 OF 5