

NOTES (UNLESS OTHERWISE SPECIFIED):

1. DRAWINGS ARE FOR INSPECTION PURPOSES ONLY. ACTUAL PART SHALL CONFORM TO THE FOLLOWING 3D ELECTRONIC FILE: X891481-SIDE-WALL-L-LFF-ASSY-REV.FASM
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 ULI439 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 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.

- 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:

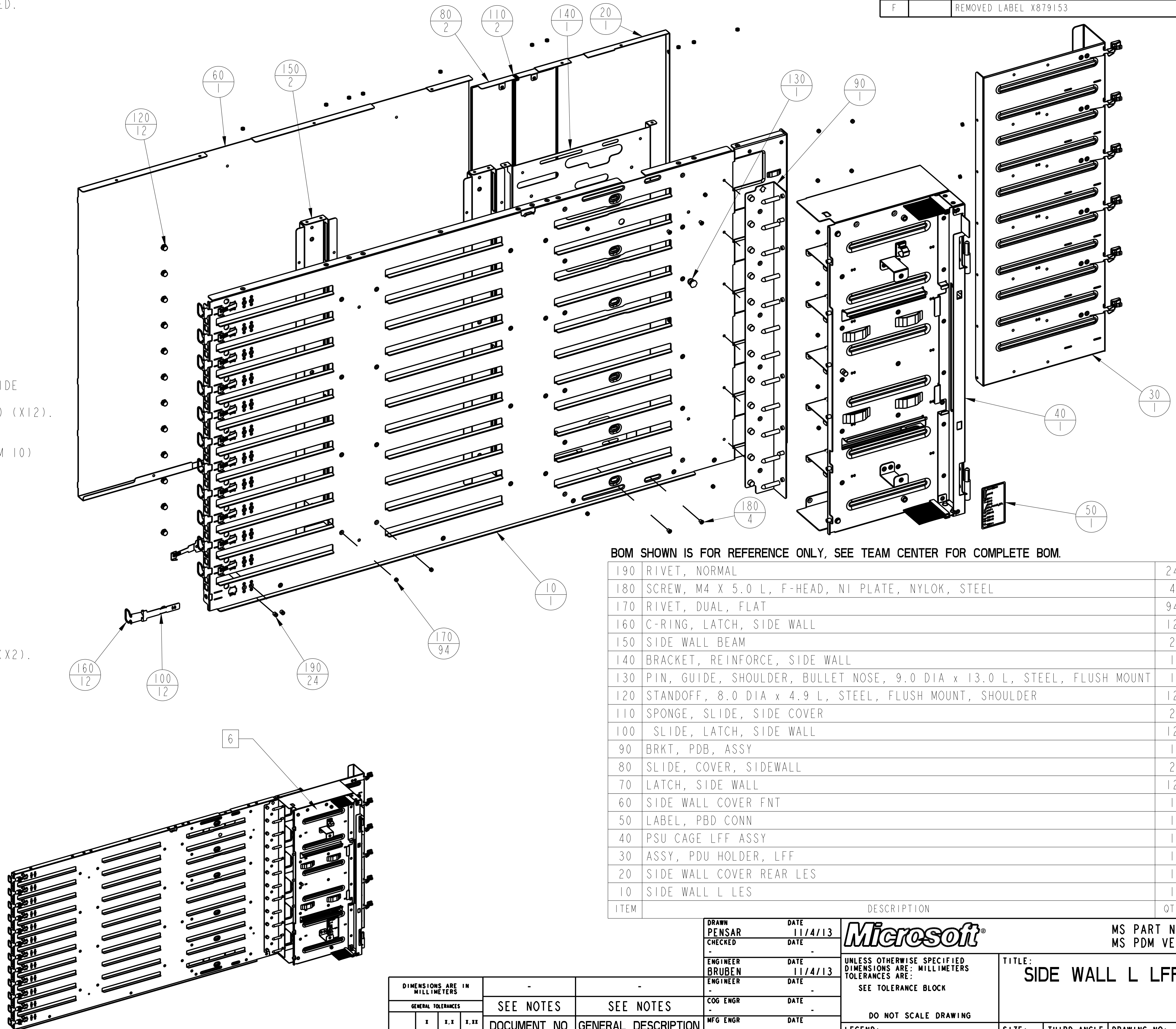
- A. GUIDE PIN (ITEM 130 AND STANDOFF (ITEM 120) (X12) SHALL BE PRESSED INTO SIDE WALL BRKT (ITEM 10).
- B. LATCH C-RING (ITEM 160) (X12) SHALL BE INSTALLED ON LATCH SLIDE (ITEM 100) (X12).
- C. LATCH SLIDE (ITEM 100) (X12) AND LATCH (ITEM 70) (X12) SHALL BE FIXED TO SIDE WALL BRKT USING NORMAL RIVET (ITEM 190) (X24).
- D. SIDE WALL REINFORCE BRKT (ITEM 140) SHALL BE FIXED TO SIDE WALL BRKT (ITEM 10) USING DUAL FLAT RIVET (ITEM 170, X14).
- E. SIDE WALL BEAM (ITEM 150, X2) SHALL BE FIXED TO SIDE WALL BRKT (ITEM 10) USING DUAL FLAT RIVET (ITEM 170, X20).
- F. PSU CAGE ASSY (ITEM 40) SHALL BE FIXED TO SIDE WALL BRKT (ITEM 10) USING DUAL FLAT RIVET (ITEM 170) (X14).
- G. PDB BRKT ASSY (ITEM 90) SHALL BE FIXED TO SIDE WALL BRKT (ITEM 10) USING DUAL FLAT RIVET (ITEM 170) (X6).
- H. PDU HOLDER ASSY (ITEM 30) SHALL BE FIXED TO SIDE WALL BRKT (ITEM 10) AND PSU CAGE ASSY (ITEM 40) USING DUAL FLAT RIVET (ITEM 170) (X30).
- I. N/A
- J. FRONT COVER (ITEM 60) SHALL BE FIXED TO SIDE WALL BRKT (ITEM 10) USING DUAL FLAT RIVET (ITEM 170) (X13).
- K. REAR COVER (ITEM 20) SHALL BE FIXED TO SIDE WALL BRKT (ITEM 10) USING DUAL FLAT RIVET (ITEM 170) (X4).
- L. SLIDE SPONGE (ITEM 110) (X2) SHALL BE INSTALLED ON COVER SLIDE (ITEM 80) (X2).
- M. COVER SLIDE (ITEM 80) (X2) SHALL BE FIXED TO SIDE WALL BRKT (ITEM 10) USING M4 X 5mm SCREW (ITEM 180) (X4).
- N. CONN LABEL (ITEM 50) SHALL BE FIXED TO PSU CAGE ASSY (ITEM 40).

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:  
ASSEMBLED STANDOFFS:  $\pm 1.0^\circ$

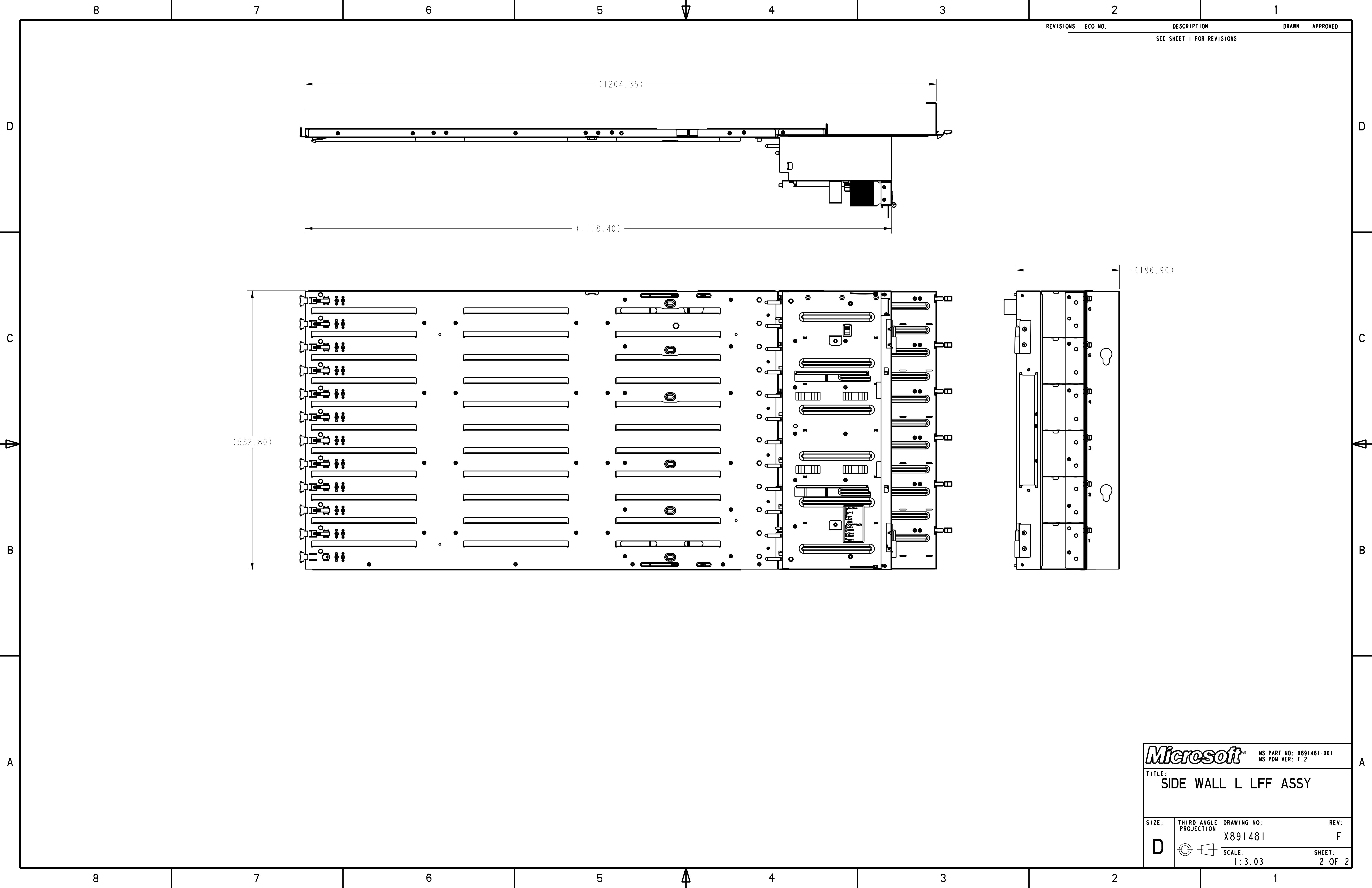
REV	ECO NO	DESCRIPTION	DRAWN	APVD DATE
A		INITIAL RELEASE.	PENSAR	11/6/13
B		REMOVED SHEET 3, ADDED REF DIMS	BROILI	3/13/14
C		REMOVED X891056 AND X879154 (CABLE DUCT)	BROILI	7/1/14
D		CHANGED X891480 3D. SEE X891480 2D	BROILI	7/11/14
E		CHANGED LES NAME TO LFF	BROILI	9/16/14
F		REMOVED LABEL X879153	BROILI	9/16/14



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

190	RIVET, NORMAL	24	X880935
180	SCREW, M4 X 5.0 L, F-HEAD, NI PLATE, NYLOK, STEEL	4	X881063
170	RIVET, DUAL, FLAT	94	X881053
160	C-RING, LATCH, SIDE WALL	12	X881047
150	SIDE WALL BEAM	2	X881044
140	BRACKET, REINFORCE, SIDE WALL	1	X881051
130	PIN, GUIDE, SHOULDER, BULLET NOSE, 9.0 DIA x 13.0 L, STEEL, FLUSH MOUNT	1	X881046
120	STANDOFF, 8.0 DIA x 4.9 L, STEEL, FLUSH MOUNT, SHOULDER	12	X881052
110	SPONGE, SLIDE, SIDE COVER	2	X881068
100	SLIDE, LATCH, SIDE WALL	12	X881048
90	BRKT, PDB, ASSY	1	X881079
80	SLIDE, COVER, SIDEWALL	2	X881073
70	LATCH, SIDE WALL	12	X881050
60	SIDE WALL COVER FNT	1	X881071
50	LABEL, PBD CONN	1	X879151
40	PSU CAGE LFF ASSY	1	X891480
30	ASSY, PDU HOLDER, LFF	1	X890857
20	SIDE WALL COVER REAR LES	1	X887746
10	SIDE WALL L LES	1	X885961
ITEM	DESCRIPTION	QTY	DRAWING NUMBER

<div><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></div> <div>SEE NOTES</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>					X	X.X	X.XX	<div><div>DRAWN</div><div>PENSAR</div><div>CHECKED</div><div>-</div><div>ENGINEER</div><div>BRUBEN</div><div>ENGINEER</div><div>-</div><div>COG ENGR</div><div>-</div><div>MFG ENGR</div><div>-</div><div>TOOLING</div><div>-</div><div>QUALITY</div><div>-</div><div>RELEASED</div><div>-</div></div> <div><div>DATE</div><div>11/4/13</div><div>DATE</div><div>-</div><div>DATE</div><div>11/4/13</div><div>DATE</div><div>-</div><div>DATE</div><div>-</div><div>DATE</div><div>-</div><div>DATE</div><div>-</div><div>DATE</div><div>-</div></div>	
					X	X.X	X.XX		
<div><div>UNLESS OTHERWISE SPECIFIED</div><div>DIMENSIONS ARE: MILLIMETERS</div><div>TOLERANCES ARE:</div><div>SEE TOLERANCE BLOCK</div><div>DO NOT SCALE DRAWING</div></div> <div><div>LEGEND:</div><div>★ = TOLERANCE CHAIN DIM</div><div>● = CRITICAL DIM</div><div>■ = TOOLING DIM</div><div>□ = PROCESS DIM</div><div>Ⓢ = DIMENSION ID</div></div>		<div><div>TITLE:</div><div>SIDE WALL L LFF ASSY</div></div> <div><div>SIZE:</div><div>D</div></div> <div><div>THIRD ANGLE PROJECTION</div><div></div></div> <div><div>DRAWING NO:</div><div>X891481</div><div>SCALE:</div><div>1:3.03</div></div> <div><div>REV:</div><div>F</div><div>SHEET:</div><div>1 OF 2</div></div>							
<div><div>MS PART NO: X891481-001</div><div>MS PDM VER: F.2</div></div>									



REVISIONS	ECO NO.	DESCRIPTION	DRAWN	APPROVED
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SEE SHEET 1 FOR REVISIONS

Microsoft

MS PART NO: X891481-001  
MS PDM VER: F.2

TITLE:  
SIDE WALL L LFF ASSY

SIZE: D	THIRD ANGLE PROJECTION	DRAWING NO: X891481	REV: F
SCALE: 1:3.03			SHEET: 2 OF 2