

1. DRAWINGS ARE FOR INSPECTION PURPOSES ONLY. ACTUAL PART SHALL CONFORM TO THE FOLLOWING 3D ELECTRONIC FILE: X873083-FAN-TRAY-ASSY-REVD.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 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.

7. FLATNESS SHALL BE DEFINED AS 0.13mm/25.4mm X 25.4mm.

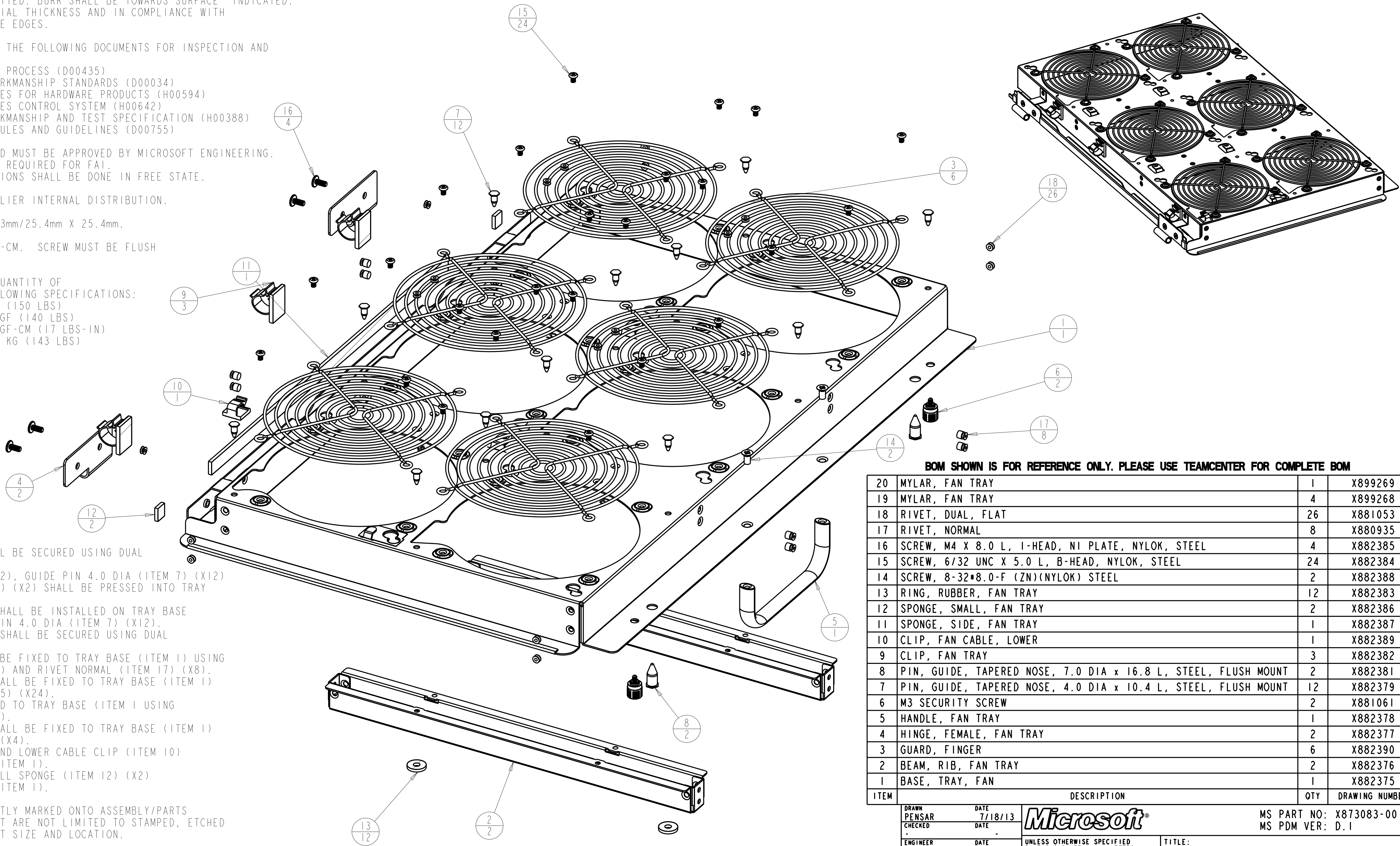
9. METHOD OF JOINING ASSEMBLY AND QUANTITY OF JOINTS SHALL COMPLY WITH THE FOLLOWING SPECIFICATIONS:

- 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)


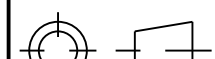
### III. ASSEMBLY:

12. FAN NUMBERING SHOULD BE PERMANENTLY MARKED ONTO ASSEMBLY/PARTS AS SHOWN. METHODS CAN INCLUDE BUT ARE NOT LIMITED TO STAMPED, ETCHED OR LABELED. REFERENCE 3D FPR FONT SIZE AND LOCATION.

REV	ECO NO	DESCRIPTION	DRAWN	APVD DATE
A		INITIAL RELEASE	PENSAR	7/18/13
B		DFW FEEDBACK CHANGES	L CANNON	3/14/14
C		ADDED MYLAR TO CABLE HOLES	B BROILI	8/12/14
D		MOVED LOWER CABLE CLIP (SEE 3D)	B BROILI	8/12/14



BOM SHOWN IS FOR REFERENCE ONLY. PLEASE USE TEAMCENTER FOR COMPLETE BOM			
20	MYLAR, FAN TRAY	1	X899269
19	MYLAR, FAN TRAY	4	X899268
18	RIVET, DUAL, FLAT	26	X881053
17	RIVET, NORMAL	8	X880935
16	SCREW, M4 X 8.0 L, I-HEAD, NI PLATE, NYLOK, STEEL	4	X882385
15	SCREW, 6/32 UNC X 5.0 L, B-HEAD, NYLOK, STEEL	24	X882384
14	SCREW, 8-32*8.0-F (ZN)(NYLOK) STEEL	2	X882388
13	RING, RUBBER, FAN TRAY	12	X882383
12	SPONGE, SMALL, FAN TRAY	2	X882386
11	SPONGE, SIDE, FAN TRAY	1	X882387
10	CLIP, FAN CABLE, LOWER	1	X882389
9	CLIP, FAN TRAY	3	X882382
8	PIN, GUIDE, TAPERED NOSE, 7.0 DIA x 16.8 L, STEEL, FLUSH MOUNT	2	X882381
7	PIN, GUIDE, TAPERED NOSE, 4.0 DIA x 10.4 L, STEEL, FLUSH MOUNT	12	X882379
6	M3 SECURITY SCREW	2	X881061
5	HANDLE, FAN TRAY	1	X882378
4	HINGE, FEMALE, FAN TRAY	2	X882377
3	GUARD, FINGER	6	X882390
2	BEAM, RIB, FAN TRAY	2	X882376
1	BASE, TRAY, FAN	1	X882375
ITEM	DESCRIPTION	QTY	DRAWING NUMBER

	DRAWN PENSAR	DATE 7/18/13			MS PART NO: X873083-001 MS PDM VER: D.I				
	CHECKED -	DATE -							
	ENGINEER BRUBEN	DATE 7/18/13	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE: MILLIMETERS TOLERANCES ARE: SEE TOLERANCE BLOCK		TITLE:  FAN TRAY ASSY				
	ENGINEER -	DATE -							
S	COG ENGR -	DATE -	DO NOT SCALE DRAWING						
	MFG ENGR -	DATE -							
DESCRIPTION TABLE	TOOLING -	DATE -	LEGEND:  ★ = TOLERANCE CHAIN DIM ● = CRITICAL DIM ▲ = TOOLING DIM ◆ = PROCESS DIM (D) = DIMENSION ID		SIZE:  D	THIRD ANGLE PROJECTION 	DRAWING NO:  X873083	REV:  D	
	QUALITY -	DATE -					SCALE:  0.750	SHEET:  1 OF 2	
DESCRIPTION TABLE	RELEASED -	DATE -							

DIMENSIONS ARE IN MILLIMETERS			-	-
GENERAL TOLERANCES			SEE NOTES	SEE NOTES
	X	X, X	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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REVISIONS

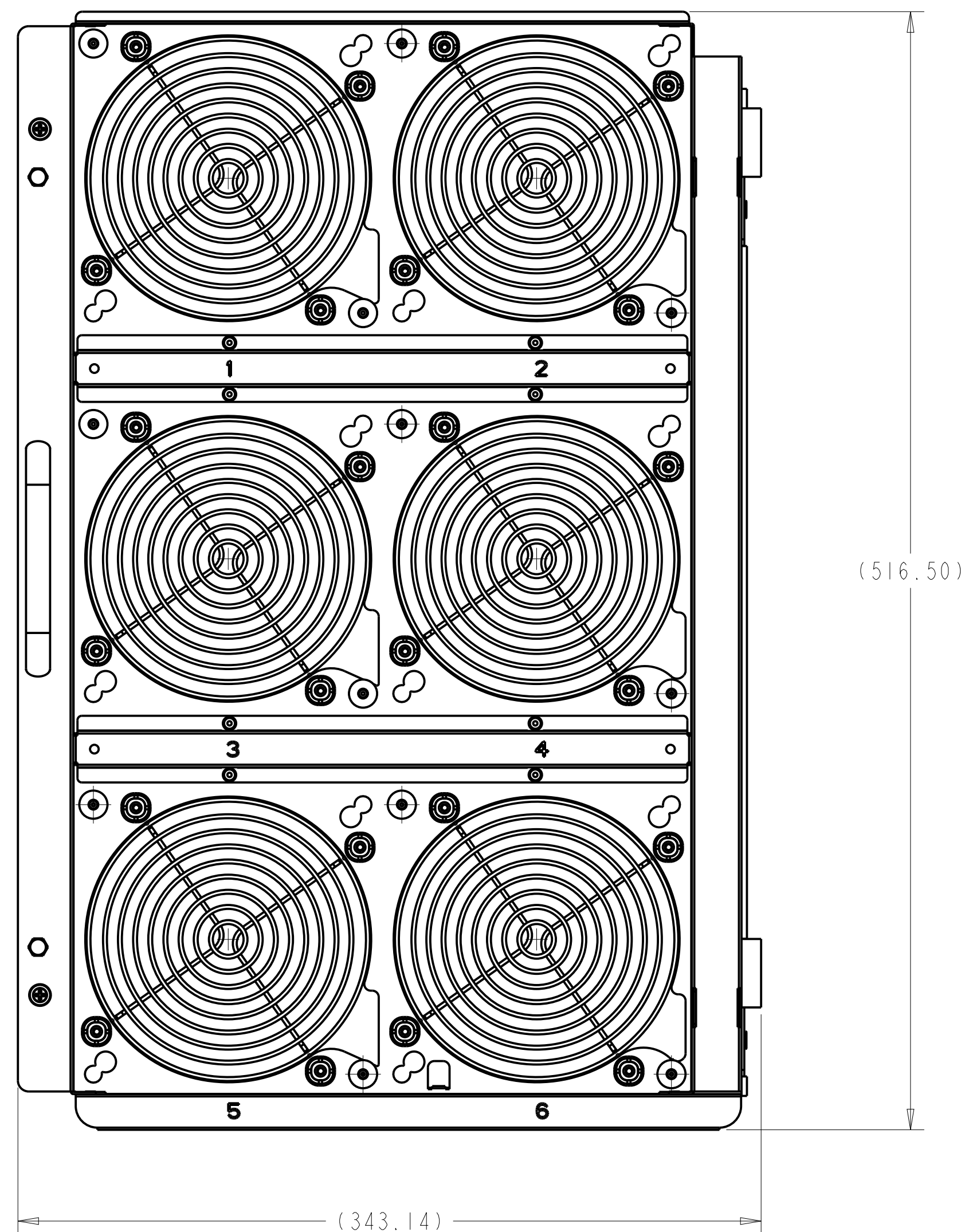
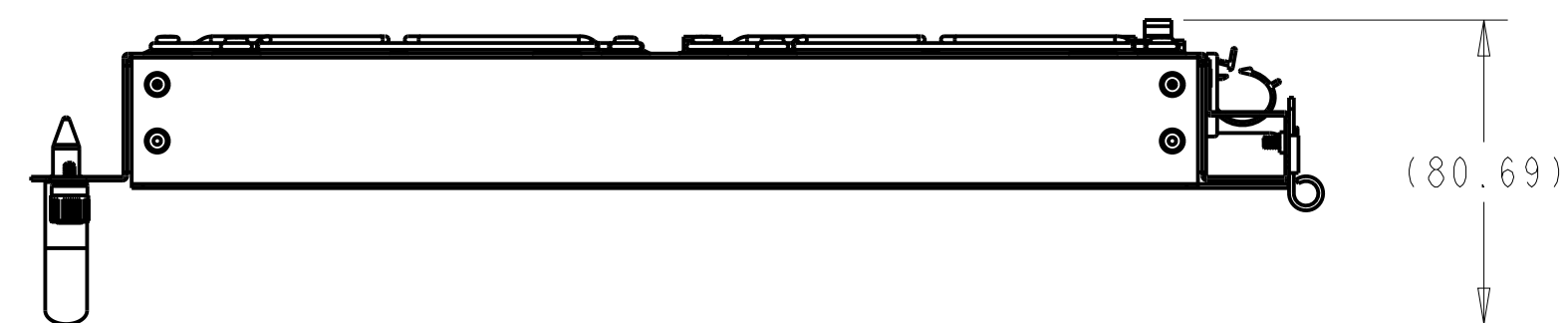
ECO NO.

DESCRIPTION

DRAWN

APPROVED

SEE SHEET 1 FOR REVISIONS

**Microsoft**MS PART NO: X873083-001  
MS PDM VER: D.1TITLE:  
**FAN TRAY ASSY**

SIZE:

THIRD ANGLE  
PROJECTION

DRAWING NO:

X873083

REV:

D

SCALE:  
0.500SHEET:  
2 OF 2