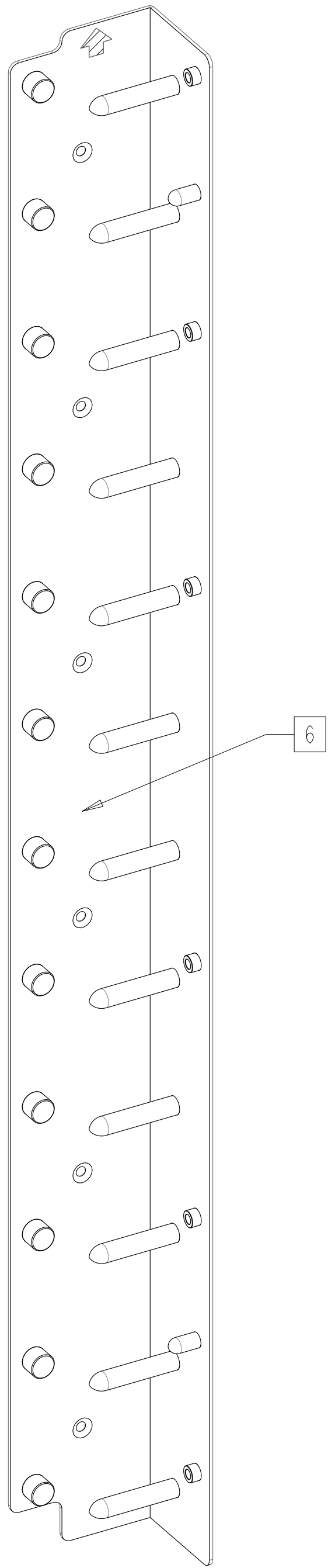
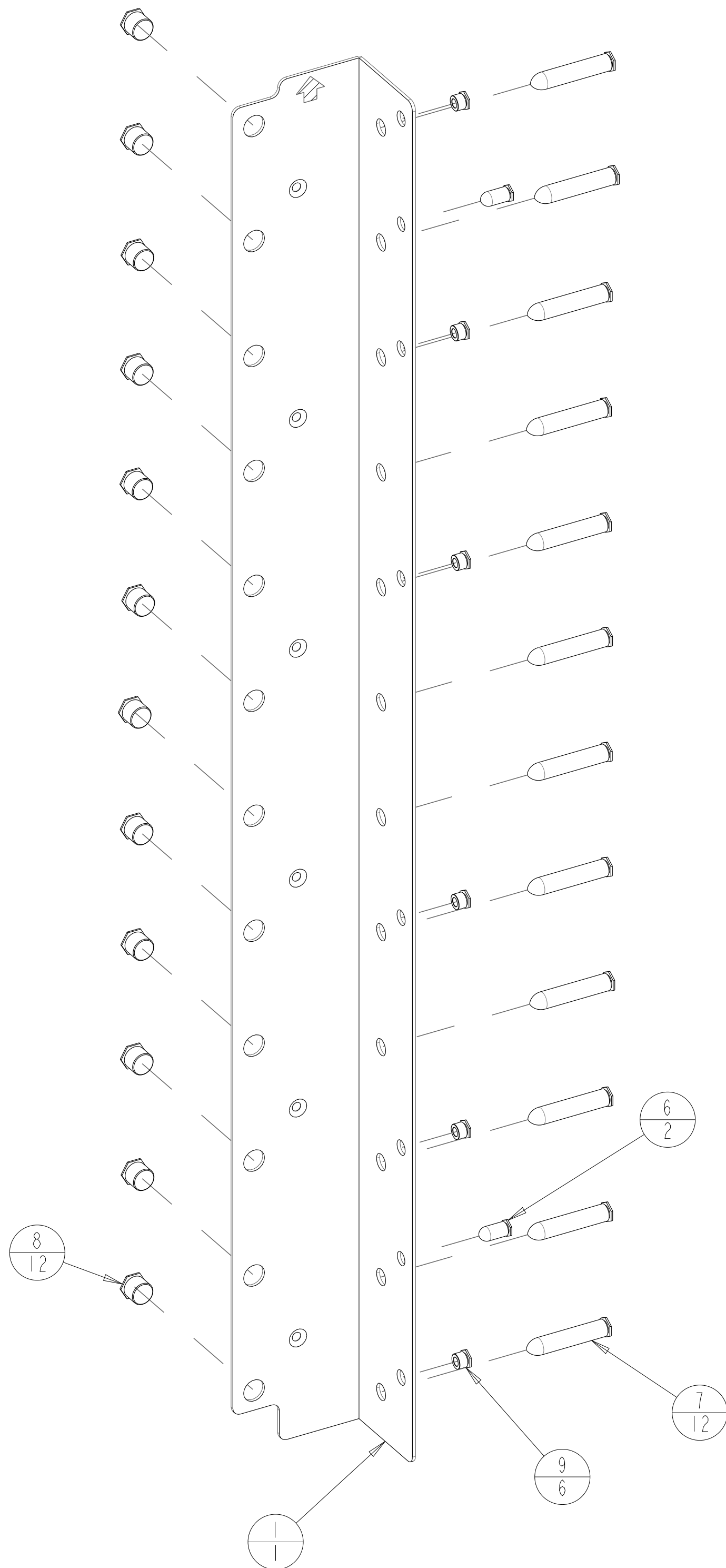


NOTES (UNLESS OTHERWISE SPECIFIED):

1. DRAWINGS ARE FOR INSPECTION PURPOSES ONLY. ACTUAL PART SHALL CONFORM TO THE FOLLOWING 3D ELECTRONIC FILE: X881079-PDB-BRKT-ASSY-REVA.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 IOC/OQC FIXTURES REQUIRED AND MUST BE APPROVED BY MICROSOFT ENGINEERING. ALL DIMENSIONS ON PRINT SHALL BE INCLUDED IN FAI REPORTS. FREE STATE INSPECTION CONDITIONS REQUIRED FOR FAI. ONLY PROCESS DIMENSIONS ARE TO BE USED FOR ON-GOING PROCESS CONTROL PER MICROSOFT METAL QUALIFICATION PROCESS (D00435). ON-GOING PROCESS CONTROL INSPECTIONS SHALL BE DONE IN FREE STATE. DIMENSIONS THAT ARE DRIVEN BY ASSEMBLY LEVEL TOLERANCE CHAIN STUDIES ARE INDICATED WITH A (★) SYMBOL.
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. ASSEMBLY:
  - A. TRAY GUIDE PIN (12X ITEM 2) SHALL BE PRESSED INTO PBD BRKT (ITEM 1).
  - B. TRAY STOP PIN (12X ITEM 3) SHALL BE PRESSED INTO PBD BRKT (ITEM 1).
  - C. PBD GUIDE PIN (2X ITEM 4) SHALL BE PRESSED INTO PBD BRKT (ITEM 1).
  - D. PBD STANDOFF (6X ITEM 5) SHALL BE PRESSED INTO PBD BRKT (ITEM 1).ALL ASSEMBLY MUST MEET THE REQUIREMENTS IN NOTE 8 BELOW.
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 91 KG (200 LBS) (FORCE EXERTED ON TOP EDGE)
10. TOLERANCE KEY FOR NON-DIMENSIONED ITEMS:

HOLE DIAMETER:  $\pm 0.08$   
HOLE TO HOLE:  $\pm 0.13$   
HOLE TO EDGE:  $\pm 0.13$   
EDGE TO EDGE:  $\pm 0.13$   
HOLE TO BEND:  $\pm 0.13$   
EDGE TO BEND:  $\pm 0.21$   
BEND TO BEND:  $\pm 0.26$   
EMBOSS DEPTH:  $\pm 0.26$   
ANGLE:  $\pm 1.0^\circ$



REV	ECO NO	DESCRIPTION	DRAWN	APVD DATE
A	C50993	INITIAL RELEASE.	PENSAR	7/12/13

BOM SHOWN IS FOR REFERENCE ONLY.

9	STANDOFF, 5.4 DIA x 4.3 L, STEEL, FLUSH MOUNT, 6/32 THREAD	6	X885949
8	PIN, STOP, 8.0 DIA x 7.0 L, STEEL, FLUSH MOUNT	12	X881040
7	PIN, GUIDE, BULLET NOSE, 6.0 DIA x 31.0 L, STEEL, FLUSH MOUNT	12	X885948
6	PIN, GUIDE, BULLET NOSE, 5.0 DIA x 11.0 L, STEEL, FLUSH MOUNT	2	X885950
1	BRKT, PDB	1	X885947
ITEM	DESCRIPTION	QTY	DRAWING NUMBER

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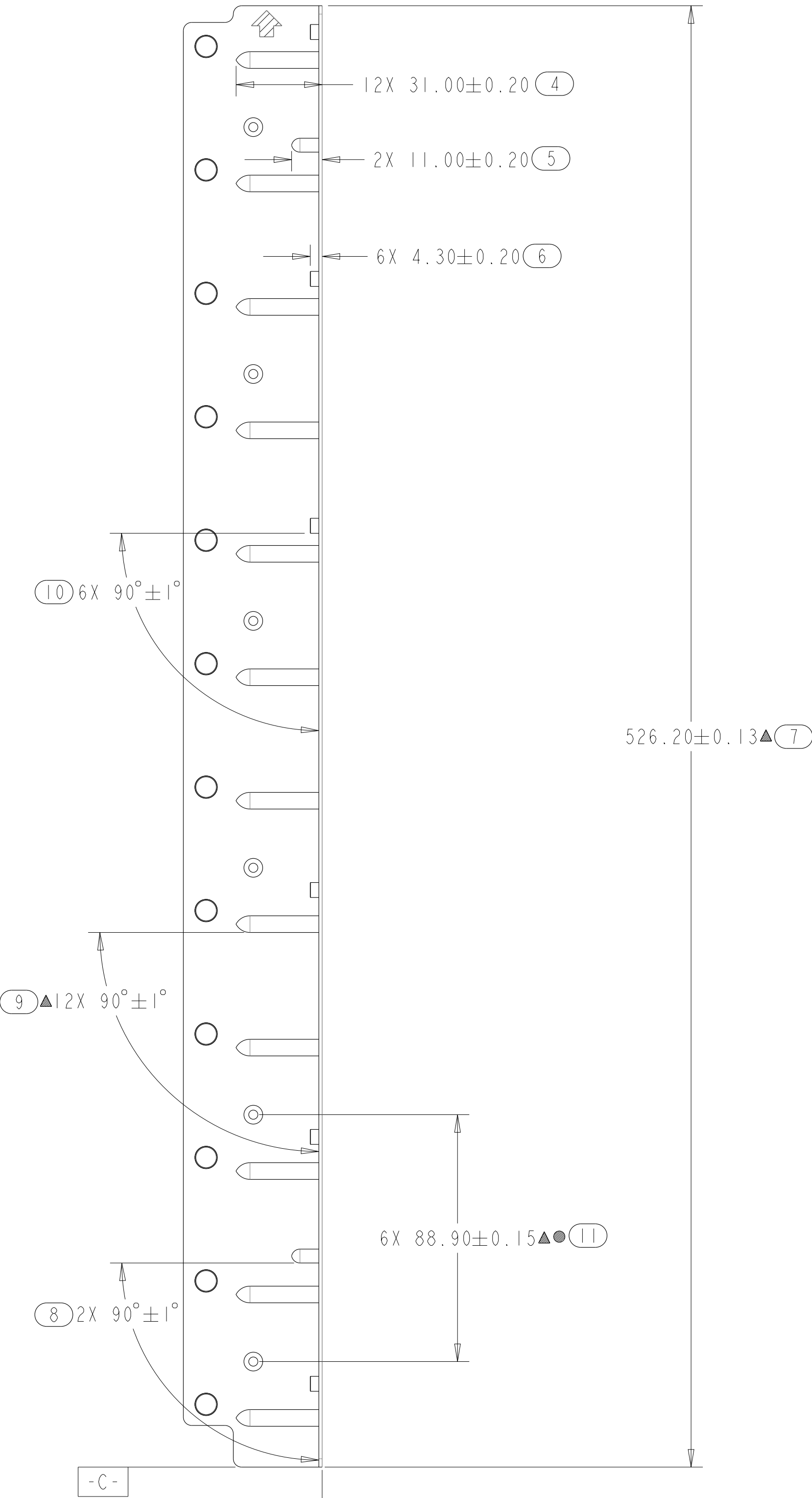
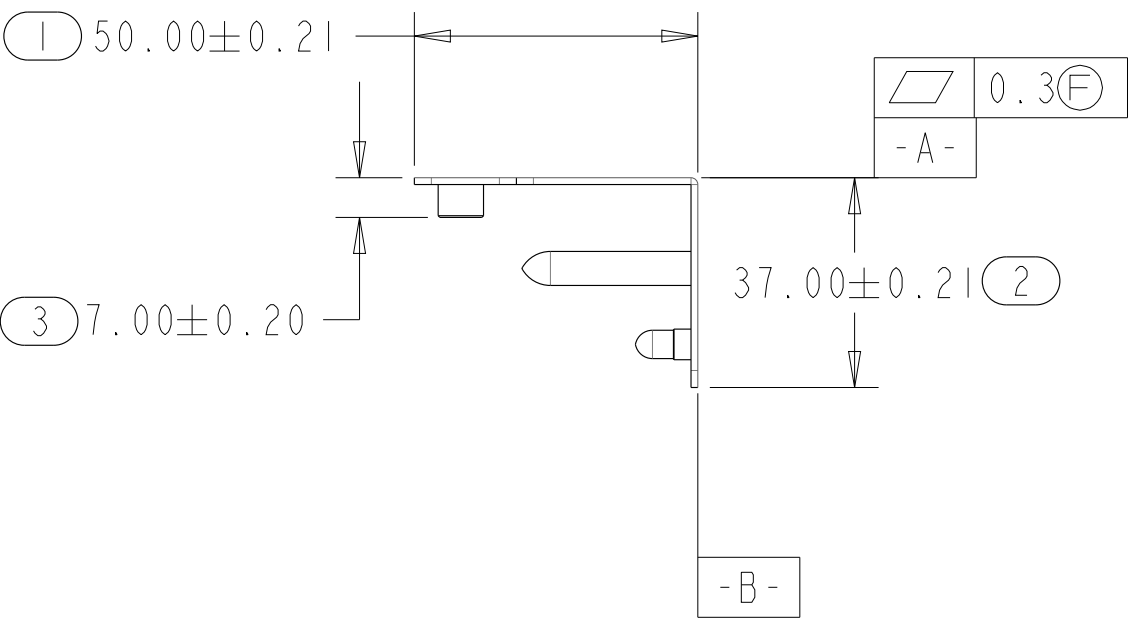
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REVISIONS    ECO NO.    DESCRIPTION    DRAWN    APPROVED

SEE SHEET 1 FOR REVISIONS



Microsoft®

MS PART NO: X881079-001  
MS PDM VER: A.15

TITLE:  
**BRKT, PDB, ASSY**

SIZE: <b>D</b>	THIRD ANGLE PROJECTION	DRAWING NO: X881079	REV: A
SCALE: 0.750		SHEET: 2 OF 3	

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REVISIONS

ECO NO.

DESCRIPTION

DRAWN

APPROVED

SEE SHEET 1 FOR REVISIONS

DIM ID	SHEET	ZONE	DIM TYPE
1	2	D6	
2	2	D5	
3	2	D6	
4	2	D4	
5	2	C4	
6	2	C4	
7	2	B4	▲
8	2	A5	
9	2	B6	▲
10	2	C5	
11	2	A4	▲ ●
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Microsoft®

MS PART NO: X881079-001  
MS PDM VER: A.15

TITLE:  
BRKT, PDB, ASSY

SIZE:  
D

THIRD ANGLE  
PROJECTION

DRAWING NO:  
X881079

REV:  
A

SCALE:  
0.750

SHEET:  
3 OF 3

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