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DESCRIPTION

DRAWN

APVD DATE

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INITIAL RELEASE

PENSAR

12/26/13

B

CS3863

DFM FEEDBACK CHANGES

L CANNON

3/17/14

NOTES (UNLESS OTHERWISE SPECIFIED):

1.

DRAWINGS ARE FOR INSPECTION PURPOSES ONLY. ACTUAL PART SHALL CONFORM TO THE FOLLOWING 3D ELECTRONIC FILE: X882377-FAN-TRAY-THUMB-PIVOT-REVB.PRT

2.

MATERIAL: HOT-DIPPED-GALV-STEEL-SGCC  
THICKNESS: 1.27+0.1/-0.07mm  
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: (20.824 GRAMS), (0.735 OZ)

4.

PART SHALL BE CLEAN AND FREE OF CONTAMINANTS, METAL FLAKES, AND OIL.

5.

UNDIMENSIONED 90° BENDS SHALL BE HELD AT A TOLERANCE OF ±1°.

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)

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

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 RADIUS AND RELIEFS SHALL COMPLY TO ELECTRONIC DATABASE.

15.

CARRY POINTS SHALL BE RECESSED BY 0.25mm MAX. ANY DEVIATION REQUIRES APPROVAL BY MICROSOFT ENGINEERING.

16.

TOLERANCE KEY FOR NON-DIMENSIONED ITEMS:  
HOLE DIAMETER: ±0.08  
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°

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