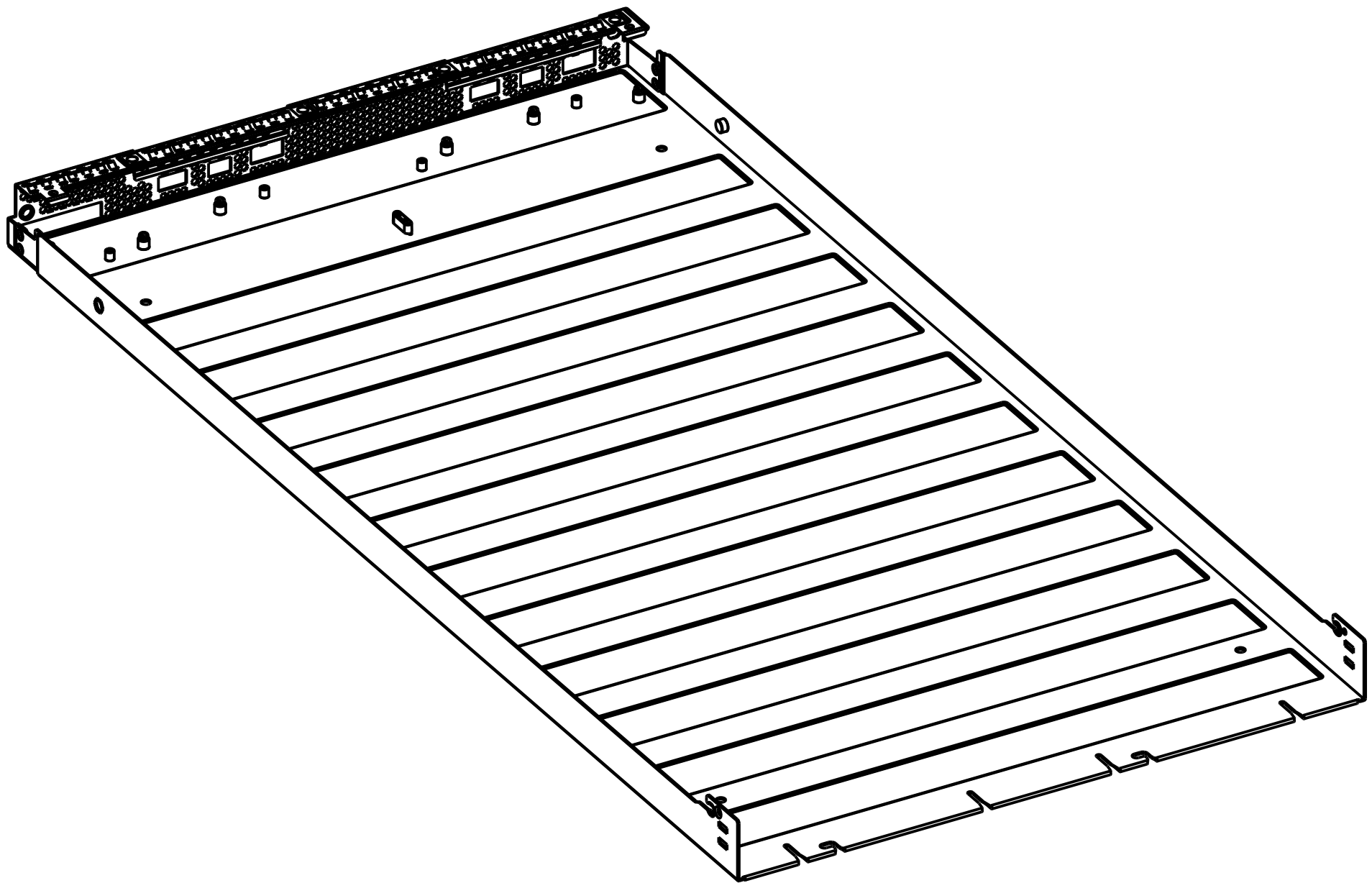
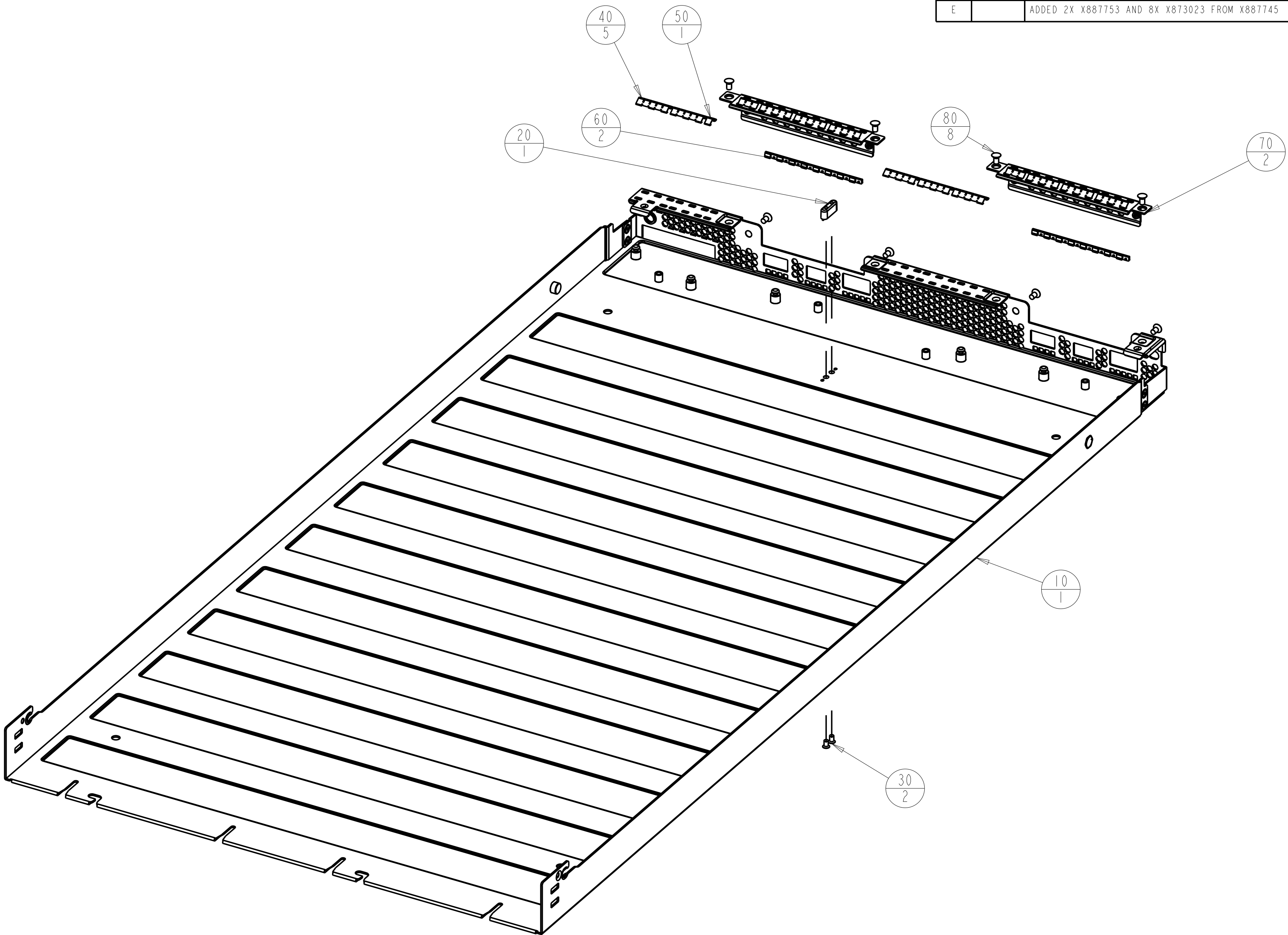



1. DRAWINGS ARE FOR INSPECTION PURPOSES ONLY. ACTUAL PART SHALL CONFORM TO THE FOLLOWING 3D ELECTRONIC FILE: X887747-ASSY-TRAY-PAN-REVE.ASM
2. PART SHALL BE CLEAN AND FREE OF CONTAMINANTS, METAL FLAKES, AND OIL.
3. ACCESSIBLE SHARP EDGES NOT PERMITTED. BURR SHALL BE TOWARDS SURFACE INDICATED. MAX BURR 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.
6. PARTS SHALL BE PACKAGED FOR SUPPLIER INTERNAL DISTRIBUTION.
7. ASSEMBLY:
 - A. TRAY GUIDE (ITEM 20) SHALL BE FIXED TO PAN SUB-ASSEMBLY (ITEM 10) USING M3 X 5.0 SCREW (ITEM 30) (X2).
 - B. EMI GASKET (ITEM 40) (X5) AND EMI GASKET (ITEM 50) SHALL BE CLIPPED INTO PAN SUB-ASSEMBLY (ITEM 10).
 - C. EMI GASKET (ITEM 60) (X2) SHALL BE ASSEMBLED ONTO PAN SUB-ASSEMBLY (ITEM 10).
8. SCREW TORQUE SPECIFICATION 5 KGF-CM. SCREW MUST BE FLUSH OR BELOW OUTER SURFACE.
9. 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: $\pm 1.0^\circ$

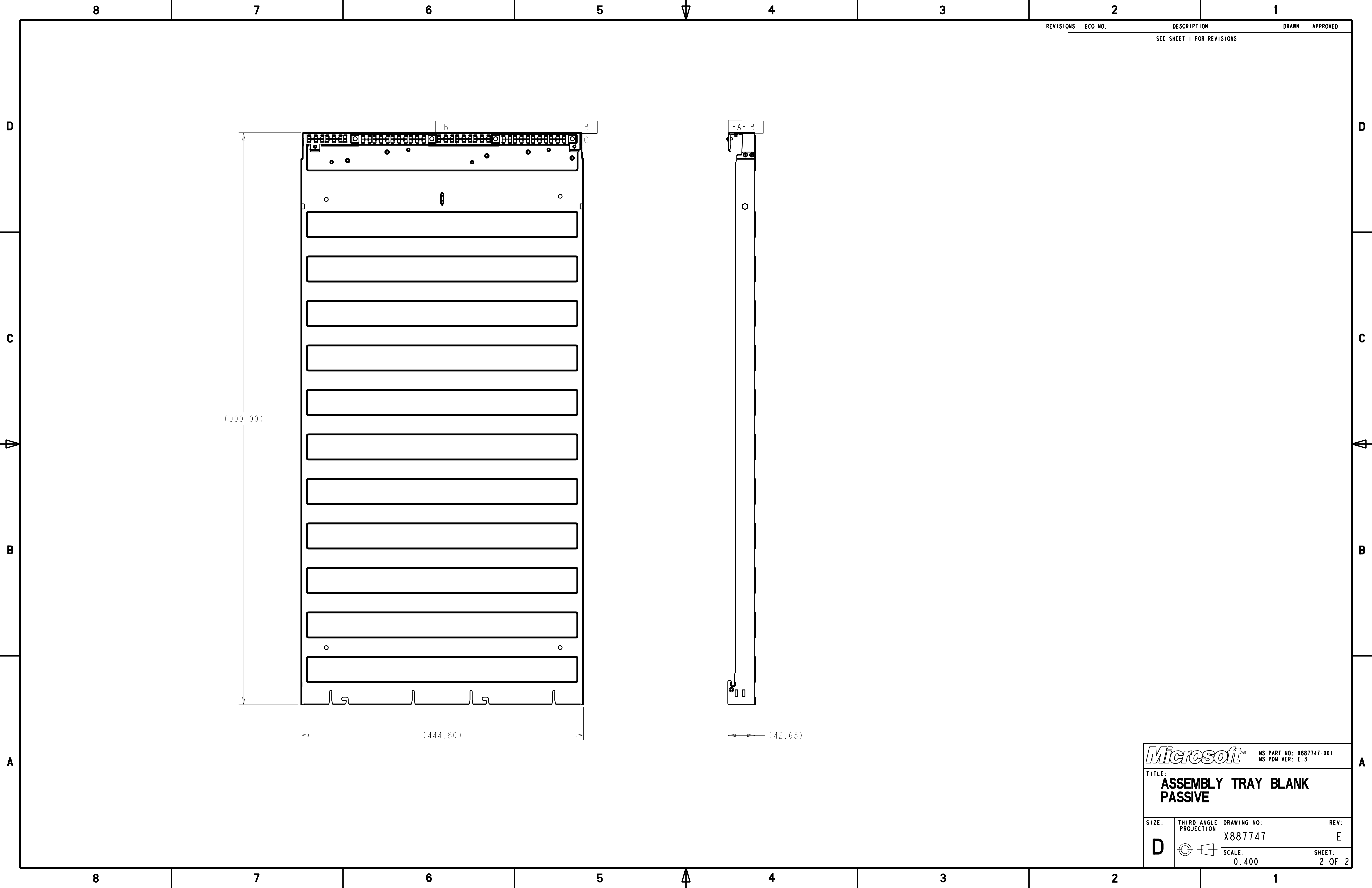
REV	ECO NO	DESCRIPTION	DRAWN	APVD DATE
A		INITIAL RELEASE, BOM ONLY.	BRUBEN	10/8/13
B		DRAWING RELEASE W/ 3D DATA.	PENSAR	11/18/13
C		DFM FEEDBACK CHANGES	L CANNON	3/14/14
D		MOD PART X887749	BROILI	5/30/14
E		ADDED 2X X887753 AND 8X X873023 FROM X887745	BROILI	7/22/14



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

80	SCREW, #6 X 1/4 , 32 TPI (UNC), F-HEAD, NYLOK, STEEL	8	X873023
70	ASSY, BULKHEAD BLANK	2	X887753
60	GASKET, EMI, SLIDE ON STRIP	2	X887751
50	GASKET, EMI, SNAP IN STRIP, 2-FINGER	1	X887755
40	GASKET, EMI, 6-FINGER SNAP-IN STRIP	5	X882357
30	SCREW M3*5-F(ZN)(NYLOK)STEEL	2	X887828
20	GUIDE, TRAY, MB	1	X882329
10	PAN SUB-ASSEMBLY	1	X887748
ITEM	DESCRIPTION	QTY	DRAWING NUMBER

DRAWN	DATE	<i>Microsoft®</i>		MS PART NO: X887747-001 MS PDM VER: E.3		
PENSR	11/8/13					
CHECKED	DATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE: MILLIMETERS TOLERANCES ARE: SEE TOLERANCE BLOCK DO NOT SCALE DRAWING	TITLE: ASSEMBLY TRAY BLANK PASSIVE	DRAWING NO: X887747 SCALE: 0.500 REV: E SHEET: 1 OF 2		
ENGINEER	DATE					
BRUBEN	11/8/13					
ENGINEER	DATE					
COG ENGR	DATE					
MFG ENGR	DATE					
		LEGEND: ★ = TOLERANCE CHAIN DIM □ = CRITICAL DIM ○ = TOOLING DIM ▲ = PROCESS DIM ③ = DIMENSION ID	SIZE: D	THIRD ANGLE PROJECTION 		
TOOLING	DATE					
QUALITY	DATE					
RELEASED	DATE					



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



MS PART NO: X887747-001
MS PDM VER: E.3

TITLE:
**ASSEMBLY TRAY BLANK
PASSIVE**

SIZE: D	THIRD ANGLE PROJECTION 	DRAWING NO: X887747	REV: E
SCALE: 0.400			SHEET: 2 OF 2