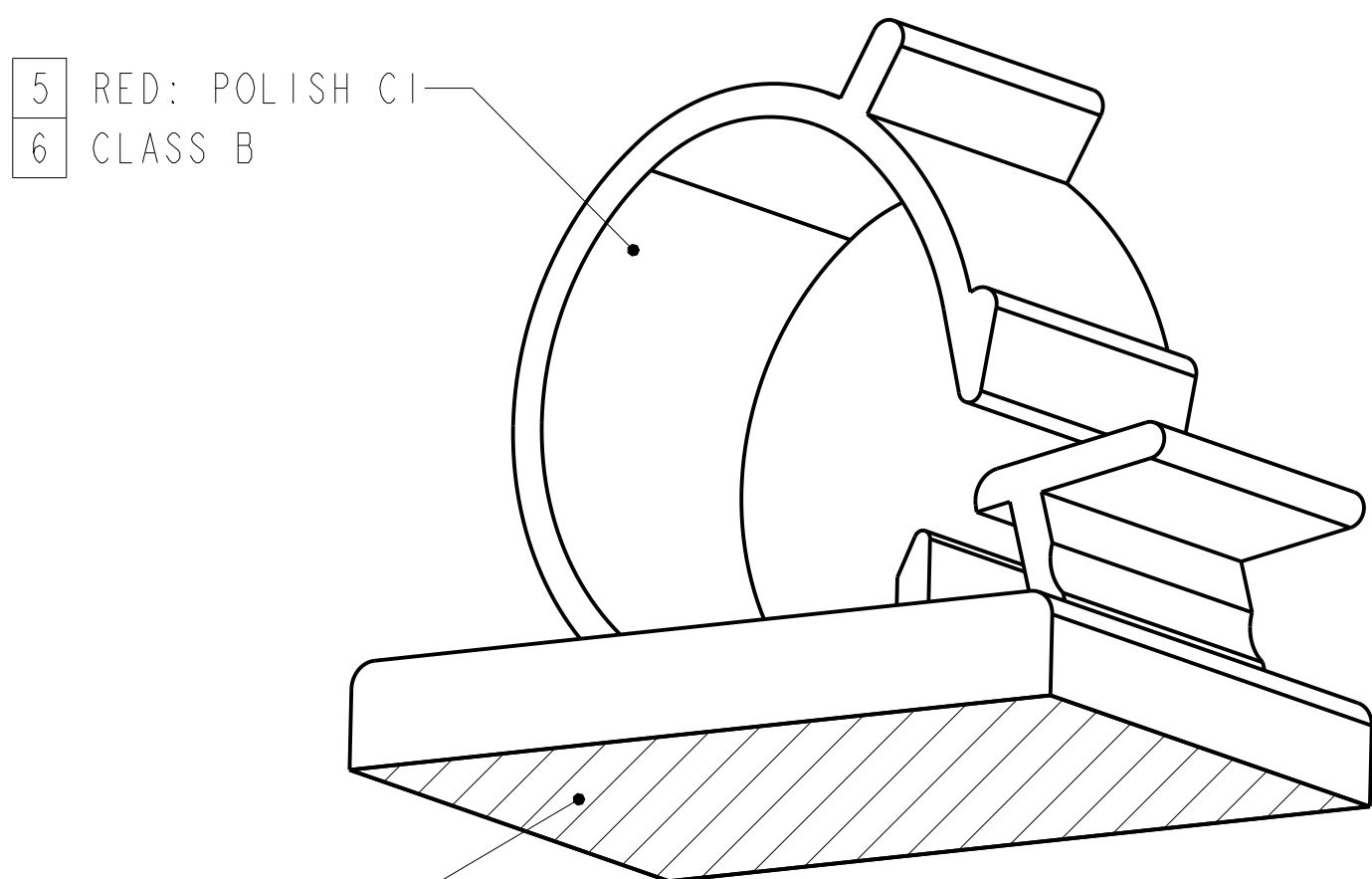
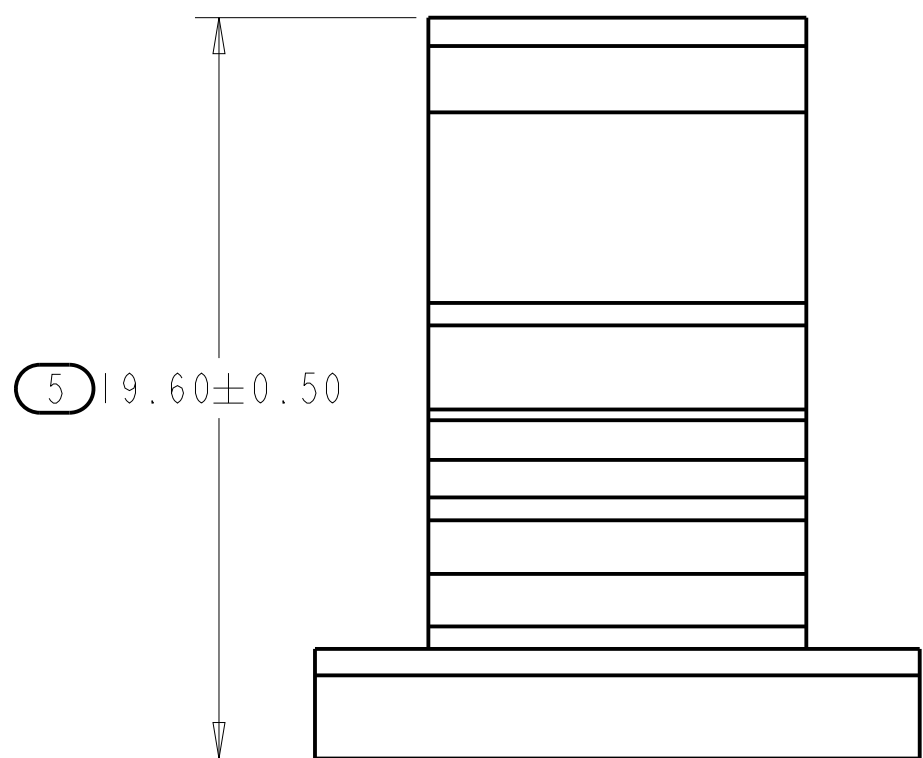
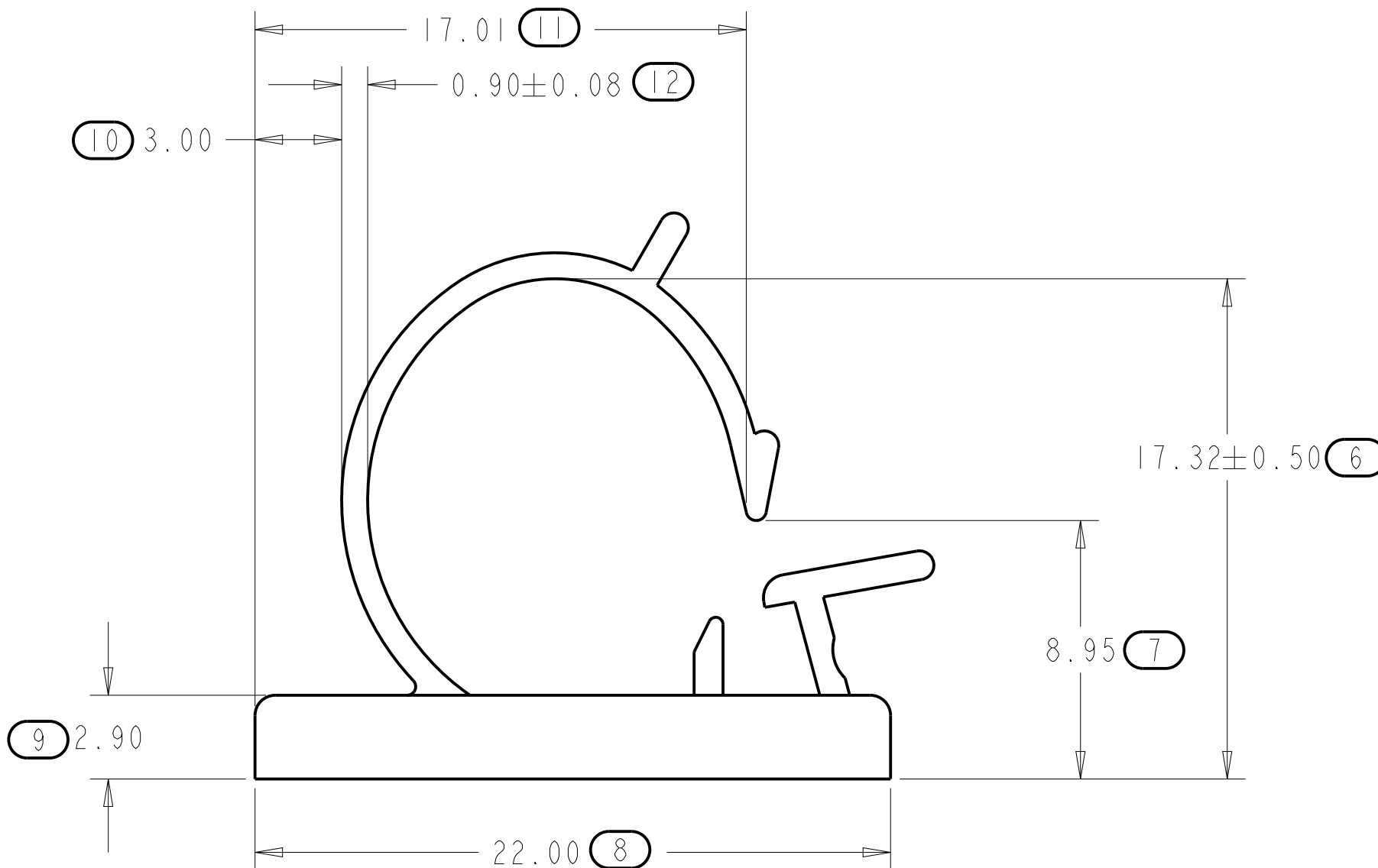
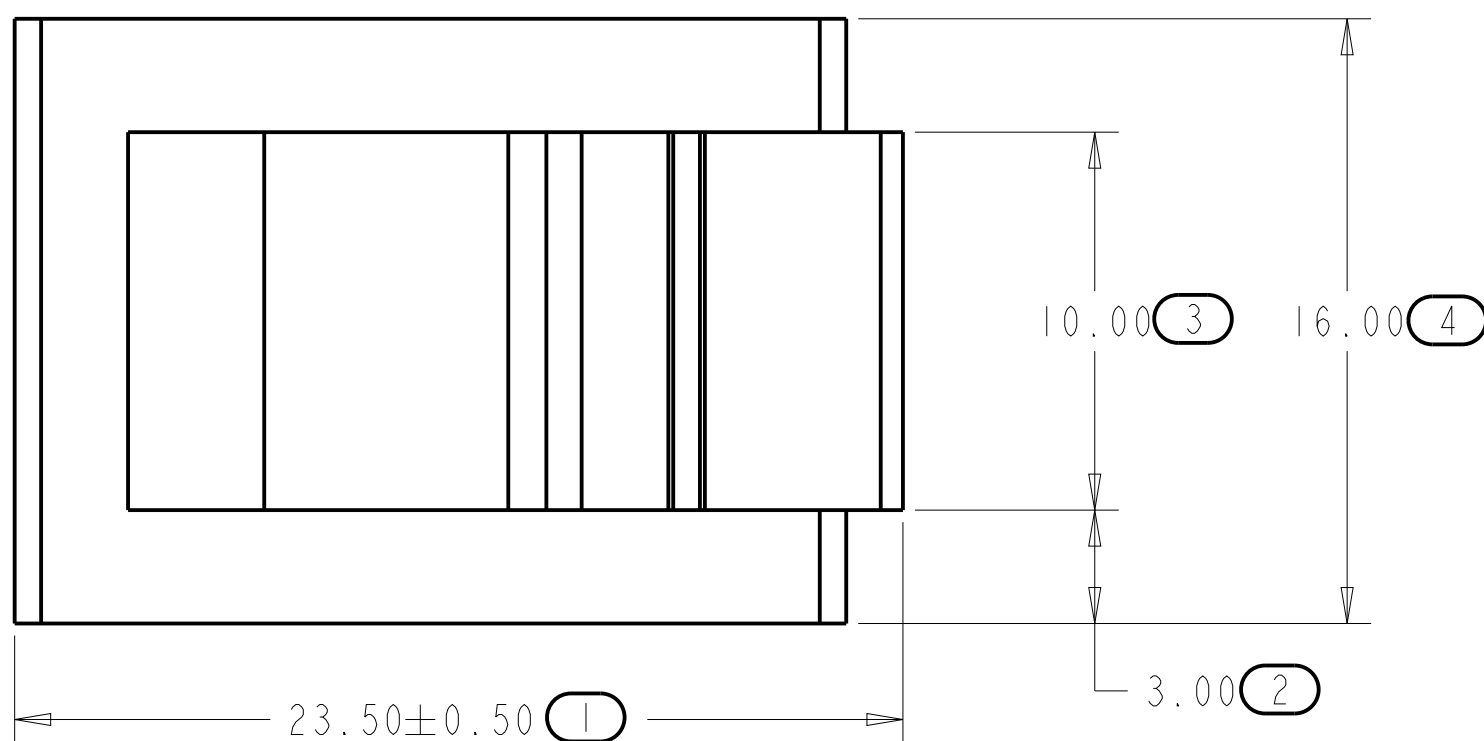


REV	ECO NO	DESCRIPTION	DRAWN	APVD DATE
A	-	INITIAL RELEASE	PENSAR	1/3/13
B	-	UPDATED NOTE 1, ADDED NOTE 16	N. TOLCHIN	5/16/14

NOTES UNLESS OTHERWISE SPECIFIED:

1. INTERPRET DRAWING PER STAPLE Y14.100. DRAWING IS FOR INSPECTION PURPOSES ONLY. ACTUAL PART GEOMETRY IS CONTROLLED BY 3D CAD DATABASE.
2. MATERIAL: NYLON 6/12  
ADHESIVE: 3M PART # 9784 OR MICROSOFT APPROVED EQUIVALENT.
3. NOMINAL WALL THICKNESS: VARIABLE
4. PART WEIGHT: (1.742 GRAMS), (0.061 OZ)
5. FINISH: REFER TO SURFACE COLOR IN 3D ELECTRONIC DATABASE  
FOR COMPLETE INSTRUCTIONS. COLOR KEY IS AS FOLLOWS:  
-GREEN: POLISH CI
6. REFERENCE THE LATEST REVISION OF THE FOLLOWING DOCUMENTS FOR INSPECTION AND ACCEPTANCE CRITERIA:
  - A. MICROSOFT XBOX PLASTICS QUALIFICATION PROCESS (D00434)
  - B. MICROSOFT XBOX PLASTIC PART WORKMANSHIP (D00015)
  - C. MICROSOFT RESTRICTED SUBSTANCES FOR HARDWARE PRODUCTS (H00594)
  - D. MICROSOFT RESTRICTED SUBSTANCES CONTROL SYSTEM (H00642)
  - E. MICROSOFT ADHESIVE SPECIFICATION (H000777)
7. ALL EDGES AND CORNERS WITHOUT RADIUS IN CAD MODEL SHALL BE 0.1mm MAX.  
DEVIATIONS FROM THIS REQUIREMENT MUST BE APPROVED BY MICROSOFT ENGINEERING.
8. MOLD PARTING LINE MISMATCH AND/OR FLASH NOT TO EXCEED 0.05mm.  
MOLD DESIGN TO MINIMIZE EJECTION PIN MARKS, WELD LINES, AND GATE BLUSH.  
MOLD DESIGN TO BE APPROVED BY MICROSOFT ENGINEERING PRIOR TO CONSTRUCTION.
9. TOOL IS TO BE PROPERTY OF MICROSOFT AND IS TO BE PERMANENTLY MARKED WITH "PROPERTY OF MICROSOFT", THE PART NUMBER AND THE TOOL ASSET NUMBER.
10. BAG AND TAG WITH THE FOLLOWING INFORMATION:
  - A. MICROSOFT PART NUMBER
  - B. CURRENT REVISION
  - C. MATERIAL
  - D. DATE OF MANUFACTURE
  - E. SUPPLIER ID (SUPPLIER ID LOCATION)
11. VENDOR SHALL SUPPLY A CERTIFICATE OF REGULATORY COMPLIANCE WITH EACH SHIPMENT THAT INCLUDES THE FOLLOWING INFORMATION:
  - A. NAME OF THE MOLDER
  - B. MOLDING DATE
  - C. UL MOLDER'S FILE NUMBER
  - D. MATERIAL MANUFACTURER'S NAME OR TRADE NAME AND MATERIAL / RESIN DESIGNATION
  - E. FLAMMABILITY RATING
  - F. NAME OF THE COMPANY BUYING THE PRODUCT
  - G. PART NUMBER AND REVISION
  - H. PURCHASE ORDER NUMBER
  - I. SHIPMENT DATE
  - J. QUANTITY OF PARTS SHIPPED
  - K. MANUFACTURER REPRESENTATIVE'S NAME, SIGNATURE OR FUNCTION TO ATTEST TO THE ACCURACY OF THE INFORMATION.
  - L. UL TRACEABILITY FOR RESIN
12. GATE VESTIGE SHALL BE FLUSH WITH OR MAX 0.2mm PROUD OF THE SURFACE.
13. FAI IQC/OQC FIXTURES REQUIRED AND MUST BE APPROVED BY MICROSOFT ENGINEERING. ALL DIMENSIONS ON PRINT SHALL BE INCLUDED IN FAI REPORTS.  
[Measurement Type: FREE or CONSTRAINED] STATE INSPECTION CONDITIONS REQUIRED FOR FAI. ONLY PROCESS DIMENSIONS ARE TO BE USED FOR ON-GOING PROCESS CONTROL PER MICROSOFT XBOX PLASTICS QUALIFICATION PROCESS (D00434).  
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.
14. PARTS SHALL BE PACKAGED FOR SUPPLIER INTERNAL DISTRIBUTION.
15. ALL FEATURES PER DATASET OF NOTE 1 ARE BASED ON SOCIETY OF PLASTICS INDUSTRY (SPI) TOLERANCES AND CALCULATED BY MATERIAL PER H106385.  
ANY TOLERANCE THAT DEVIATES FROM THE STANDARD TOLERANCE BLOCK IS SHOWN ON THE DRAWING.
16. DIMENSIONS AND TOLERANCES NOT MARKED CRITICAL, TOOLING OR PROCESS SHALL BE CONSIDERED REFERENCE DIMENSIONS. ONLY CRITICAL, TOOLING AND PROCESS DIMENSIONS ARE REQUIRED TO BE COMPLIANT FOR FAI. ADDITIONAL MEASUREMENTS REQUIRED AT ENGINEERING REQUEST.

[illegible]

8				7				6				5				4				3				2				1			