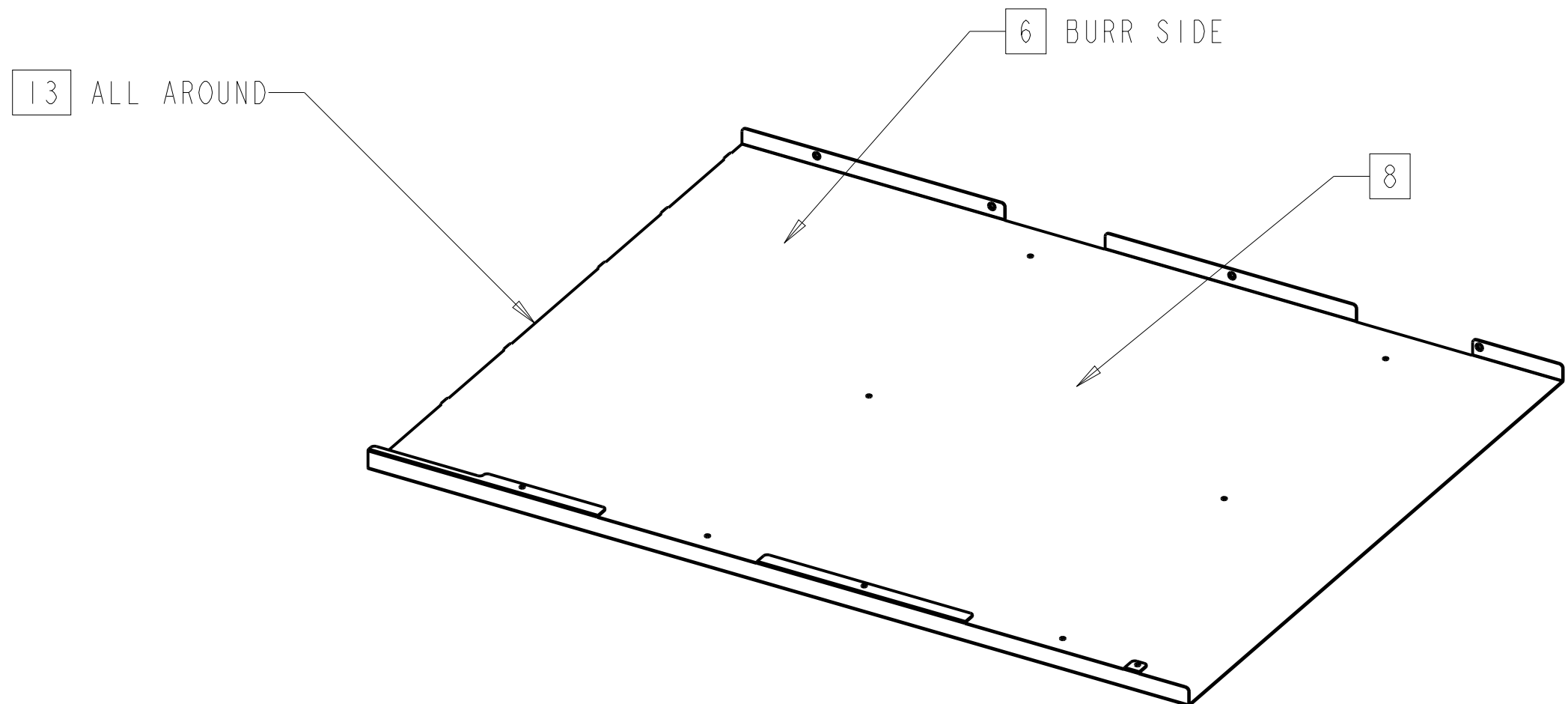
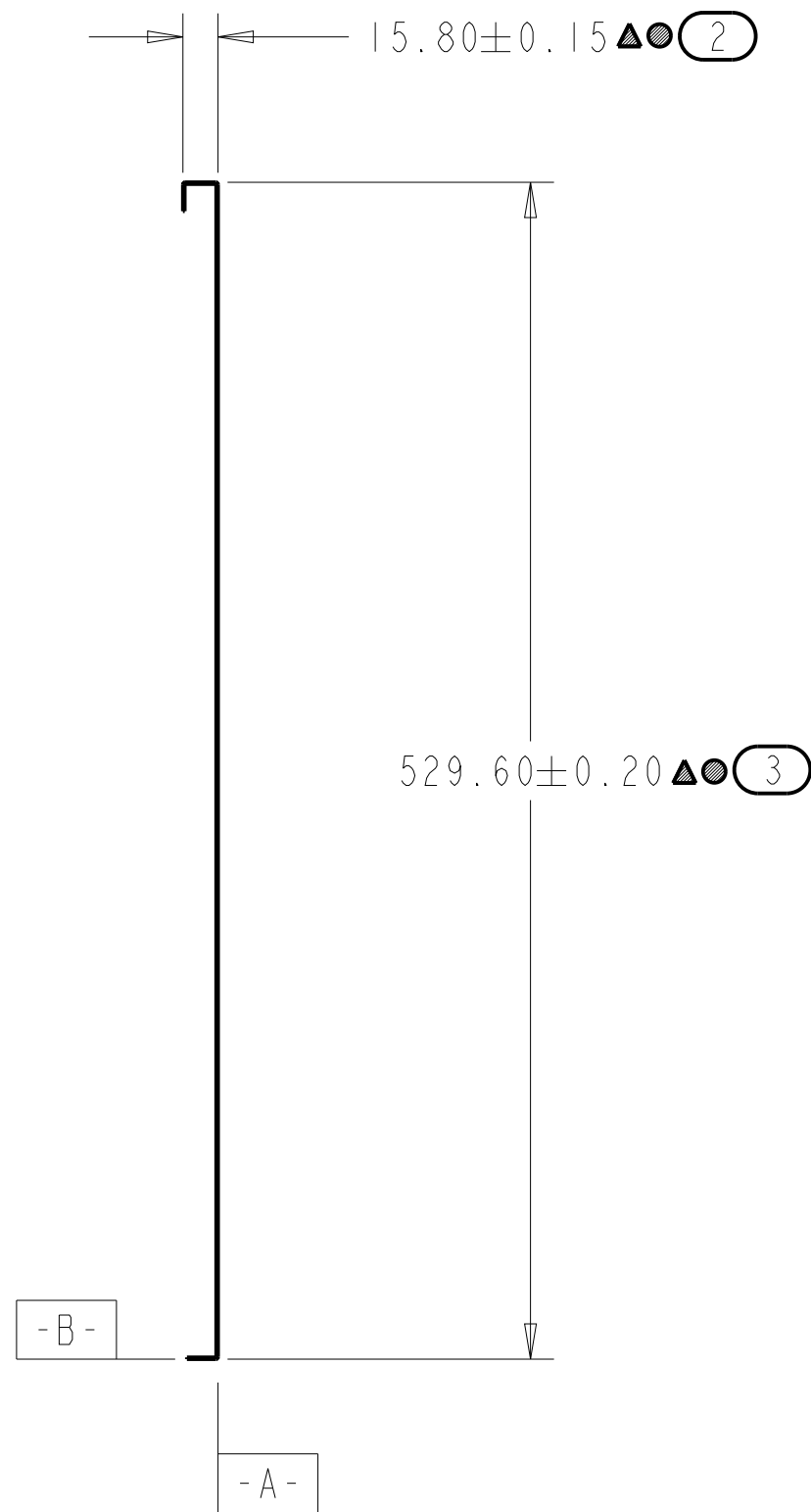
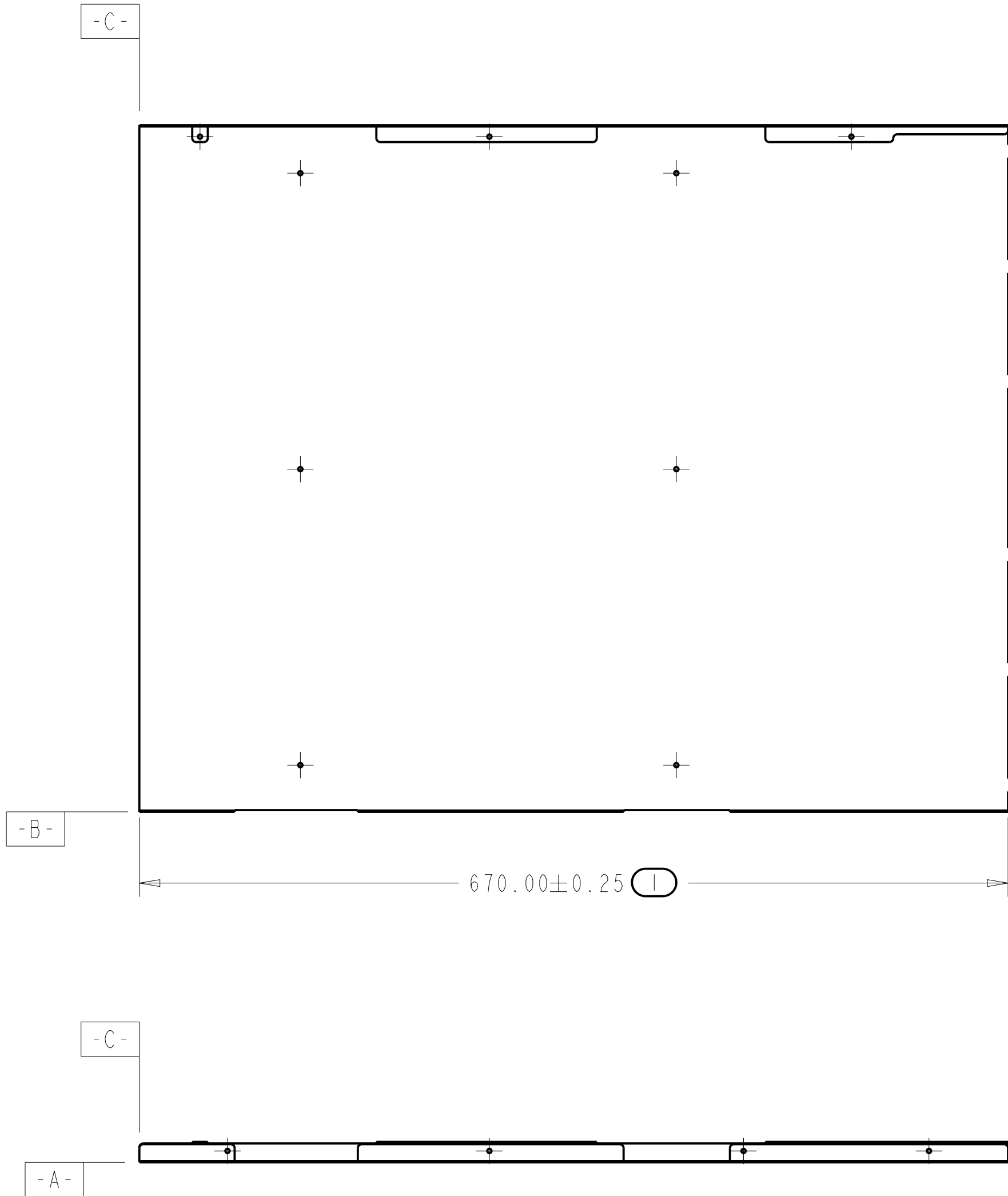


REV	ECO NO	DESCRIPTION	DRAWN	APVD DATE
A	-	INITIAL RELEASE.	PENSAR	7/5/13
B	-	DFM FEEDBACK CHANGES.	MG PETERSON	
C	-	UPDATED NOTE 1, ADDED NOTE 18	N. TOLCHIN	5/15/14

NOTES UNLESS OTHERWISE SPECIFIED:

1. INTERPRET DRAWING PER ASME Y14.100. DRAWING IS FOR INSPECTION PURPOSES ONLY. ACTUAL PART GEOMETRY IS CONTROLLED BY 3D CAD DATABASE.
2. MATERIAL: HOT-DIPPED-GALV-STEEL-SGCC  
THICKNESS: 0.80±0.1mm  
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: (2350.194 GRAMS), (82.915 OZ)
4. PART SHALL BE CLEAN AND FREE OF CONTAMINANTS, METAL FLAKES, AND OIL.
- 5 AS DIMENSIONED OR Ø3.60. STANDARD TOLERANCE APPLIES.
- 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 ULI439 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  
C. MANUFACTURING DATE CODE (DD MMM YYYY)  
D. SUPPLIER ID (SUPPLIER ID LOCATION)
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 RADII AND RELIEFS SHALL COMPLY TO ELECTRONIC DATABASE.
15. CARRY POINTS SHALL BE RECESSED BY 0.25mm MAX. TOOLING HOLES OR OTHER DEVIATION REQUIRE APPROVAL BY MICROSOFT ENGINEERING.
16. TOLERANCE KEY FOR NON-DIMENSIONED ITEMS:  
HOLE DIAMETER: PUNCH DIRECTION ±0.08  
CHAMFERED HOLE DIAMETER: BURR SIDE ±0.15  
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°
17. VENDOR MODIFICATION OF HOLE FEATURE SIZING AND TOLERANCES FOR PRESS-IN HARDWARE IS ALLOWED FOR VENDOR SPECIFIC HARDWARE PER MICROSOFT APPROVAL.

18. 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 FAIL. ADDITIONAL MEASUREMENTS REQUIRED AT ENGINEERING REQUEST.



DIMENSIONS ARE IN MILLIMETERS		-	-
GENERAL TOLERANCES		SEE NOTES	SEE NOTES
	X X.X X.XX	DOCUMENT NO	GENERAL DESCRIPTION
STD. DIM	±0.5 ±0.25 ±0.15	APPLICABLE SPECIFICATION TABLE	
ANGLE	±3° ±1° ±0.5°	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	±25% ±10% ±5%		

DRAWN	DATE
PENSAR	7/5/13
CHECKED	DATE
-	-
ENGINEER	DATE
BRUBEN	7/5/13
ENGINEER	DATE
-	-
COG ENGR	DATE
-	-
MFG ENGR	DATE
-	-
TOOLING	DATE
-	-
QUALITY	DATE
-	-
RELEASED	DATE
-	-

**Microsoft®**

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE: MILLIMETERS  
TOLERANCES ARE:  
SEE TOLERANCE BLOCK

DO NOT SCALE DRAWING


LEGEND:

- ★ = TOLERANCE CHAIN DIM
- = CRITICAL DIM
- = TOOLING DIM
- ▲ = PROCESS DIM
- Ⓢ = DIMENSION ID

TITLE: **SIDE WALL COVER FRONT**

SIZE:  
D

**THIRD ANGLE PROJECTION**

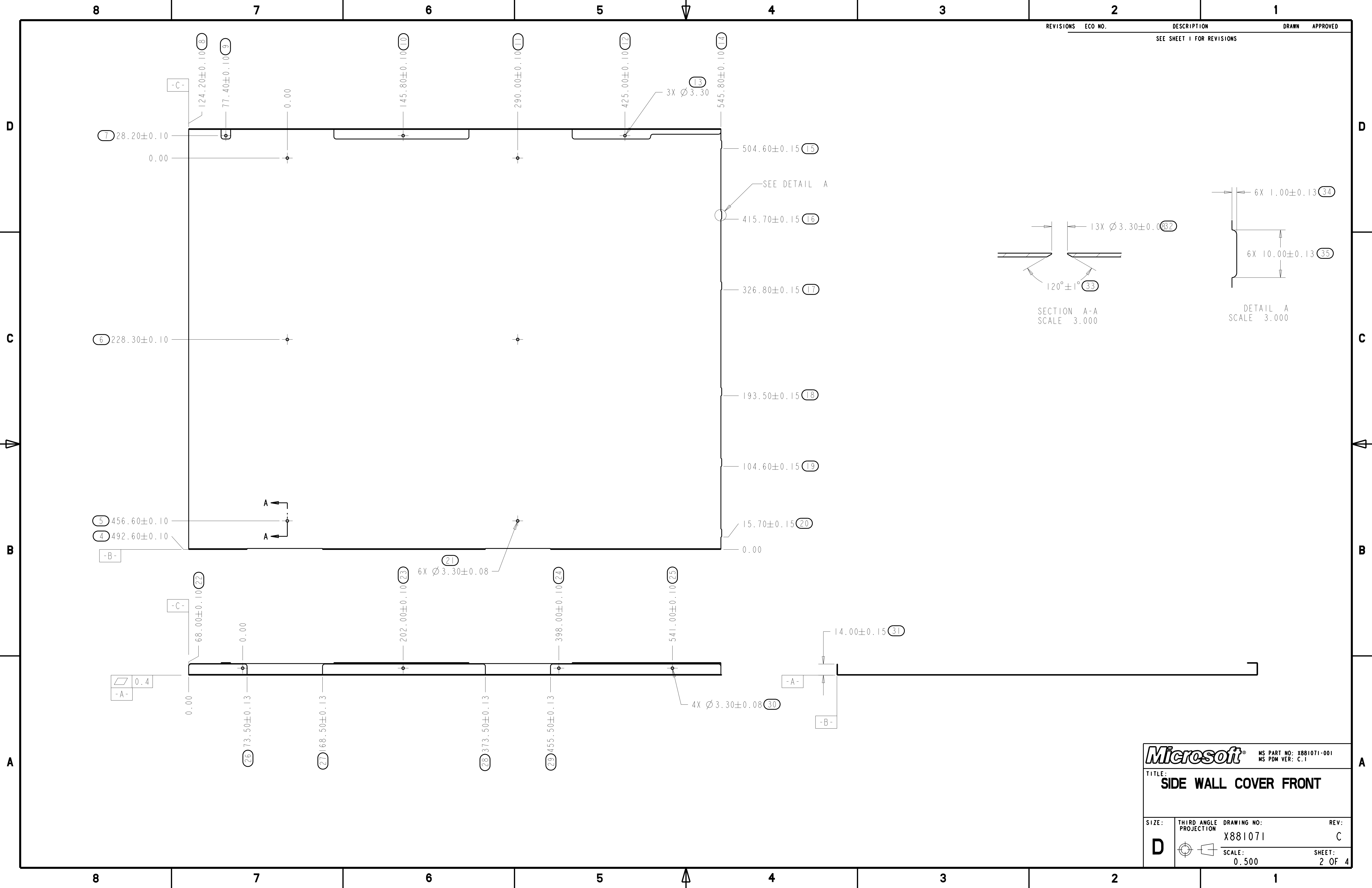
The symbol for third angle projection consists of a circle on the left and a truncated cone on the right. The circle has a horizontal center line and a vertical center line. The truncated cone is shown in profile, with its circular end face on the left and its tapered body extending to the right. A horizontal center line passes through the center of the cone.

DRAWING NO:  
X88107

SCALE:  
0.300

REV:  
C

SHEET:  
1 OF 4



8

7

6

5

4

3

2

1

REVISIONS

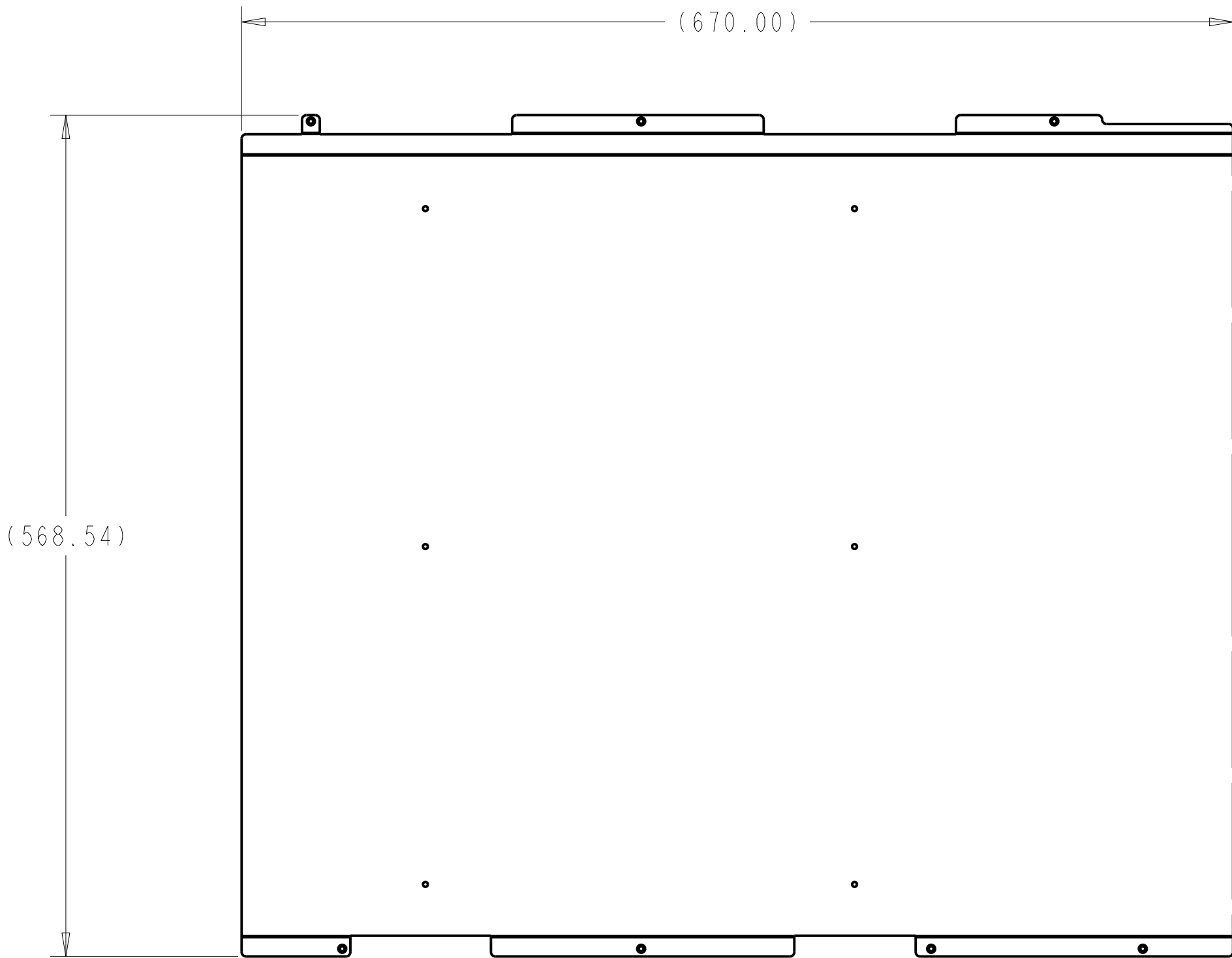
ECO NO.

DESCRIPTION

DRAWN

APPROVED

SEE SHEET 1 FOR REVISIONS



FLAT PATTERN

Microsoft®

MS PART NO: X881071-001  
MS PDM VER: C.1

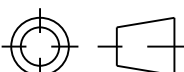
TITLE:

SIDE WALL COVER FNT

SIZE:

D

THIRD ANGLE  
PROJECTION



DRAWING NO:

X881071

REV:

C

SCALE:  
0.300

SHEET:

3 OF 4

D

C

B

A

D

C

B

A

8

7

6

5

4

3

2

1

Microsoft®

MS PART NO: X881071-001  
MS PDM VER: C.1

TITLE:

SIDE WALL COVER FNT

SIZE:

THIRD ANGLE PROJECTION

DRAWING NO:

REV:

D



X881071

C

SCALE:

SHEET:

0.300

4 OF 4